

SODASEAL 650 HT

Revision: 1/04/2024

Page 1 of 2

Technical Data

Basis	Hybrid Polymer
Consistency	Stable paste
Curing System	Moisture curing
Specific Gravity	1.48
Skin formation time (23°C/50% R.H) (min)*	Ca. 5
Curing speed* (23°C/50% R.H) (mm/24h)	3
Hardness** Shore A, Points (ISO 868)	50 ± 5
Tensile strength (N/mm ²) (ISO 37)**	3.5
Elongation at Break (ISO 37)** (%)	400
Elasticity Modulus 100% (ISO 37)** (N/mm ²)	2.0
Elastic Recovery (ISO 7389)** (%)	>75
Maximum Allowed Distortion (%)	±20
Temperature Resistance** (°C)	-20 to +80
Application Temperature (°C)	5 to 30

*These values may vary depending on environmental factors such as temperature, moisture and the type of substrate.

**This information relates to fully cured products.

Description:

Soudaseal 650 HT is a high quality, neutral, elastic, 1-component adhesive sealant based on MS-Polymer with a very high initial tack.

Properties:

- High initial tack reducing the need for initial support
- Fast curing
- Good extrudability
- High shear strength after full cure (no primer)
- Stays elastic after curing and very sustainable
- No odour
- Can be painted with water based systems
- Good weather and UV resistance
- Does not contain isocyanates and no silicones
- Good adhesion on slightly moist substrates

Packaging:

Colour: Black, White,

Packaging: 600ml sausage, 20L Drum

Applications:

- Sealing and bonding in the Automotive, Transportation

and construction industry

- Elastic bonding of panels, profiles and other pieces on the most common substrates (Metal, wood, MDF, chipboard etc)
- Elastic structural bonding in car and container industry

Shelf Life and Storage:

12 months in unopened packaging in a cool and dry storage place at temperatures between +5°C and +25°C.

Health and Safety Recommendations:

Take the usual labour hygiene into account. Consult label and material safety data sheet for more information

Substrates:

Substrates: all usual engineering substrates, treated Metals, wood, PVC, plastics,

Nature: rigid, clean, dry, free of dust and grease.

Surface preparation: Porous surfaces in water loaded applications should be primed with Primer 150. Prepare non-porous surfaces with Soudal primer or cleaner (see Technical Data Sheet).

Soudaseal 650 HT has been tested on following metal

Remark: The directives contained in this documentation are the result of our experiments and of our experience and have been submitted in good faith. Because of the diversity of the materials and substrates and the great number of possible applications which are out of our control, we cannot accept any responsibility for the results obtained. In every case it is recommended to carry out preliminary experiments.

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SOUDASEAL 650 HT

Revision: 1/04/2024

Page 2 of 2

surfaces: AlCuMg1, AlMg3, AlMgSi1, stainless steel, electro-galvanized steel, steel ST1403, hot dip galvanized steel.

Soudaseal 650 HT also has a good adhesion on plastics: polystyrene, polycarbonate (Makrolon®), PVC, polyamide, fiberglass reinforced epoxy, polyester. While producing plastics very often releasing agents, processing aids, and other protective agents (like protection foil) are used. These should be removed prior to bonding or sealing. For optimum adhesion the use of Surface Activator is recommended. We recommend a preliminary adhesion test on every surface.

NOTICE: bonding plastics like PMMA (e.g. Plexiglass), polycarbonate (e.g. Makrolon® or Lexan®) in stress loaded applications can give rise to stress cracking and crazing in these substrates. The use of Soudaseal 650 HT is not recommended in these applications. Not suitable for PE, PP, PTFE (e.g. Teflon®), bituminous substrates, copper or copper-containing materials such as bronze and brass. We recommend a preliminary adhesion and compatibility test on every surface.

Joint Size:

The optimal bond thickness for this product is at least 2mm for the elastic properties to come to full justice.

Applying Method:

Application method: With manual or pneumatic caulking gun.

Cleaning: Clean with White Spirit or Soudal Surface Cleaner immediately after use (before curing).

Finishing: With a soapy solution or Soudal Finishing Solution before skinning.

Repair: With the same material.

Remarks:

- Soudaseal 650 HT may be overpainted with water-based paints, however due to the large number of paints and varnishes available we strongly suggest a compatibility test before application. The drying time of alkyd resin based paints may increase
- Soudaseal 650 HT can be applied to a wide variety of substrates. Due to the fact that specific substrates such as plastics, like polycarbonate, etc, may differ from manufacturer to manufacturer, we recommend preliminary compatibility test
- While producing plastics very often releasing agents, processing aids and other protective agents (like

protection foil) are used. These should be removed prior to bonding. For optimum adhesion the use of Surface Activator is recommended

- Soudaseal 650 HT can not be used as a glazing sealant
- Soudaseal 650 HT can be used for bonding of natural stone, but it cannot be used as a joint sealant on this type of surface. Soudaseal 650 HT can therefore only be used on the bottom of natural stone tiles
- When applying, make sure that the surface of the materials is not smudged with sealant
- A total absence of UV can cause a color change of the sealant
- When using different reactive joint sealants, the first joint sealant must be completely hardened before the next one is applied
- Not suitable for bonding aquariums
- Do not use in applications where continuous water immersion is possible
- Discoloration due to chemicals, high temperatures, UV-radiation may occur. A change in color does not affect the technical properties of the product
- Contact with bitumen, tar or other plasticizer releasing materials such as EPDM, neoprene, butyl, etc. is to be avoided since it can give rise to discoloration and loss of adhesion

Chemical Resistance:

Good resistance to (salt) water, aliphatic solvents, hydrocarbons, ketones, esters, alcohols, diluted mineral acids and alkalis. Poor resistance to aromatic solvents, concentrated acids and chlorinated hydrocarbons.

Environmental Clauses:

Leed regulation:

Soudaseal 650 HT conforms to the requirements of LEED.

Low-Emitting

Materials: Adhesives and Sealants. SCAQMD rule1168. Complies with USGBC LEED 2009 Credit 4.1: Low-Emitting Materials – Adhesives & Seal-ants concerning the VOC-content.

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