

SOUDABOND 690 DG

Revision: 24/12/2024

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Technical Data

Basis	Hybrid Polymer
Consistency	Stable paste
Curing System	Polymerization through moisture
Specific Gravity (g/ml)	1.47
Skin formation time (23°C/50% R.H) (min)*	Ca. 15
Curing rate (23°C/50% R.H) (mm/24h)	>3
Hardness, Shore A, Points**	62±5
Tensile strength (N/mm ²)**	ISO 37 Ca. 3.50
Elongation at Break (%)**	ISO 37 >250
Elasticity Modulus 100% (N/mm ²)**	ISO 37 2.30
Shear strength** (N/mm ²) (ss/ss)	Ca. 2.1
Temperature Resistance (°C)**	-30 to +90
Application Temperature (°C)	+5 to +40

*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:

Soudabond 690 DG is a high-quality, one-component, solvent-free hybrid adhesive for the installation of windows on all types of vehicles.

Properties:

- Flexible
- High end strength
- No primer needed
- Good sag resistance
- High initial tack
- Good weather and UV resistance
- Does not shrink

Packaging:

Colour: black

Packaging: 600ml foil bag, 300ml cartridge

Applications:

- Installation of windscreens in vehicles.

Shelf Life and Storage:

At least 12 months in original, unopened packaging at a cool and dry storage place, 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: glass, metals, paintwork

Nature: The surfaces must be clean, free of dust, grease, oil and rust.

Surface preparation: The surfaces should be degreased before bonding them together. A preliminary adhesion test on every surface is recommended.

Joint Size:

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

Applying Method:

Installing a new window: Degrease the surface and window. Apply Soudabond 690 DG in a triangular bead on the window or on the vehicle. Carefully put the window in place, press lightly and attach any decorative strips. Replacing an old window: Remove any trim and cut out the old window up to 1 to 2 mm from the frame. Take care not to damage the paint and treat the rust present. Repair damaged lacquer with primer DG or equivalent.

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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Degrease the window and surface well. Apply Soudabond 690 DG in a triangular bead on the window or on the vehicle. Carefully put the window in place, press lightly and reassemble the trims.

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.

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.

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Soudal India Pvt. Ltd.

Plot No. 200, Sec. 4, Phase - II, Growth Centre, Bawal, Dist. Rewari, Haryana - 123501 (India)
info@soudal.in | www.soudal.in | +91 8010-114-114