

Soudabond 690 DG

Description

Soudabond 690 DG is a high quality, one-component, solvent-free adhesive based on Hybrid Polymer.

Soudabond 690 DG can be used for the installation of windows on all types of vehicles.

Properties

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

Application

- Soudabond 690 DG is suitable for the installation of windscreens in vehicles.



Technical data

Base	Hybrid Polymer	
Consistency	Stable paste	
Curing system	Moisture curing	
Specific Gravity (g/ml)	1.47	
Skin formation (minutes)	ca. 15	
Curing speed (mm/24h)	ca. 3	
Hardness (Shore A, Points)	62 ± 5	
Elasticity Modulus (N/mm ²)	ISO 37	ca. 2.30
Elongation at Break (%)	ISO 37 / ASTM D412	> 250
Maximum Tension (N/mm ²)	ISO 37	ca. 3.50
Shear Strength (N/mm ²)	ca. 2.1	
Temperature Resistance (°C)	-20 to +90	
Application Temperature (°C)	+5 to +40	

Footnote: Skinning time and curing speed may vary depending on environmental factors such as temperature, moisture, and type of substrates.

Substrates

- Substrate condition
The surface must be clean, dry, free of dust, rust and grease.
- Substrate preparation
The surfaces should be degreased before bonding them together.

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■ Substrate types

Soudabond 690 DG has a good adhesion to glass, metals, and paintwork. We recommend a preliminary adhesion and compatibility test on every surface.

Application method

■ Application method

For the installation of 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 slightly and attach any decorative strips. For the replacement of an old window: Remove any trim and cut out the old window up to 1 or 2 mm from the frame. Take care not to damage the paint and treat the rust present. Repair damaged lacquer with primer DG or an equivalent. 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 slightly and reassemble the trims.

■ Application tools

Apply the sealant with a caulking gun or putty knife into the crack, joint or screw hole.

■ Cleaning method

Swiftly clean with Soudal Surface Cleaner or with White Spirit, immediately after use (before curing). Cured product can only be removed mechanically.

■ Finishing method

Finish with a soapy solution or Soudal Finishing Solution before skinning.

■ Repair method

Repair with the same material.

Health and Safety Recommendations

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

Packaging/Logistics

Colour: Black

Packaging: 600ml Sausage

Shelf life: 12 months from the date of production. The product must be stored in its original, undamaged, and sealed packaging under dry conditions, protected from direct sunlight, and at temperatures between +5°C and +25°C.

This technical data sheet supersedes all earlier versions. The information provided is based on our tests and practical experience and is supplied in good faith as general guidance only, without creating any liability. Since materials, substrates, application design, and processing conditions vary widely and are outside our control, we cannot accept responsibility for the results obtained from use of this information. The user must verify suitability for the intended application through their own testing, and preliminary trials are recommended in all cases. The manufacturer reserves the right to change product specifications without prior notice.