

Soudaflex 611

Description

Soudaflex 611 is a high-quality, neutral, elastic, one-component construction joint and adhesive sealant based on polyurethane.

Properties

- Very easy to apply.
- Permanently elastic after curing.
- Very good adhesion on many materials.
- Excellent resistance to UV radiation.
- Excellent resistance to many chemicals.

Application

- Soudaflex 611 is suitable for several industrial and building applications like elastic bonding in car body work, caravan, bus and container industry.
- Supple bonding and sealing in vibrating construction in car bodies, caravans and containers.
- Replaces the traditional weld or spot weld.
- Also bonding of upright parts.



Technical data

Base	Polyurethane	
Consistency	Stable paste	
Curing system	Moisture curing	
Specific Gravity (g/ml)	1.38	
Skin formation (minutes)	ca. 45	
Curing speed (mm/24h)	ca. 4	
Hardness (Shore A, Points)	35 ± 5	
Movement Accommodation	ISO 11600	± 20
Modulus at 100% Elongation (N/mm ²)	ISO 37	ca. 1.30
Elongation at Break (%)	ISO 37 / ASTM D412	850
Tensile Strength (N/mm ²)	ISO 37	ca. 2.30
Temperature Resistance (°C)	-30 to +90	
Application Temperature (°C)	+5 to +35	

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 rigid, clean, dry, free of dust and grease.
- Substrate preparation
Porous surfaces should be primed with Primer 100. If needed non-porous surfaces can be prepared with Soudal Surface Cleaner. All substrates should be tested for suitability regarding adhesion and compatibility.

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■ Substrate types

Soudaflex 611 has a good adhesion to all types of metals.

Soudaflex 611 is not suitable for PE, PP, PTFE (Teflon®), bituminous substrates.

We recommend a preliminary adhesion and compatibility test on every surface.

Application method

■ Application method

Apply the product with a manual, pneumatic or a battery-operated caulking gun.

■ Cleaning method

Swiftly clean with Soudal Surface Cleaner or with Soudal Swipex Wipes, immediately after use. 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.

Keep the area well-ventilated during use and curing of the product. Dangerous. Respect the precautions for use.

Packaging/Logistics

Colour: White, Black, Grey

Packaging: 600g 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.

Environmental Clauses

- Leed regulation: Soudaflex 611 conforms to the requirements of LEED. Low –Emitting Materials: Adhesives and Sealants. SCAQMD rule 1168.
- Complies with USGBC LEED 2009 Credit 4.1: Low-Emitting Materials – Adhesives & Sealants concerning the VOC-content.

Remarks

- Soudaflex 611 is paintable with most water-based paints, however due to the large number of paints and varnishes available we strongly suggest a compatibility test before application.
- Soudaflex 611 cannot be used as a glazing sealant.
- Do not use in application where continuous water immersion is possible.
- It is recommended to do a compatibility test prior to application.
- Soudaflex 611 has a good UV resistance but can discolour under extreme conditions or after long UV exposure.
- Do not apply or allow to cure in the presence of uncured silicone sealants, alcohol – or any other solvent cleaners.
- When using different reactive joint sealants, the first joint sealant must be completely hardened before the next one is applied.

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.