

Soudaflex 621

Description

Soudaflex 621 is a strong and permanently elastic polyurethane adhesive for bonding and sealing in the automotive and transport industry.

Properties

- Medium open time and high viscosity
- Applicable in warm and humid climate
- Permanently elastic after curing
- Water-tight
- Excellent resistance weather, UV and many chemicals
- Can be painted with all water-based paints and many other systems (to be tested)
- Very good primer less adhesion on many materials such as aluminum, steel, GRP and epoxy coatings.

Application

- Supply bonding and sealing in vibrating constructions in carbodies, caravans and containers.
- Replaces the traditional weld or spot weld.
- Also bonding of upright parts.
- Bonding of container elements, car body parts, windscreens, wheel arch extensions, etc.



Technical data

Base	Polyurethane	
Consistency	Stable paste	
Curing system	Moisture curing	
Specific Gravity (g/ml)	1.24	
Skin formation (minutes)	ca. 50	
Curing speed (mm/24h)	ca. 3	
Hardness (Shore A, Points)	40 ± 5	
Movement Accommodation	ISO 11600	± 20
Modulus at 100% Elongation (N/mm ²)	ISO 37	ca. 1.34
Elongation at Break (%)	ISO 37 / ASTM D412	600
Elastic recovery	ISO 7389	> 80
Tensile Strength (N/mm ²)	ISO 37	ca. 1.52
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 clean, dry, free of dust, rust and grease.

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■ 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.

■ Substrate types

Soudaflex 621 has a good adhesion to all types of metals.

Soudaflex 621 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

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.

Remarks

- Soudaflex 621 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.
- When painted with oxidative drying paints disturbances in the drying of the paint may occur (we recommend doing a compatibility test before application.)
- Remove all traces of soap (tooling) because it will harm the adhesion of the paint onto the sealant.
- Do not use in applications where continuous water immersion is possible.
- Soudaflex 621 can discolour under extreme conditions or after very long UV exposure.
- Do not apply or allow to cure in the presence of uncured silicone sealants, alcohol - or 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.