



Soudaflex 620

Revision: 12/10/2020

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Technical data

Basis	Polyurethane
Consistency	Stable paste
Curing system	Moisture curing
Skin formation* (23°C/50% R.H.)	Ca. 20 min
Curing speed * (23°C/50% R.H.)	3 mm/24h
Hardness**	40 ± 5 Shore A
Density**	1,28 g/ml
Elastic recovery (ISO 7389)**	> 80 %
Maximum allowed distortion (ISO 11600)	± 20 %
Elasticity modulus 100% (ISO 37)**	1,00 N/mm ²
Elongation at break (ISO 37)**	800 %
Max. tension (ISO 37)**	2,25 N/mm ²
Temperature resistance**	-30 °C → 90 °C
Application temperature	5 °C → 35 °C

* These values may vary depending on environmental factors such as temperature, moisture, and type of substrates. ** This information relates to fully cured product.

Product description

Soudaflex 620 is an elastic polyurethane adhesive for bonding and sealing of body elements.

Properties

- Short open time
- Highly elastic
- Permanently elastic after curing
- Excellent resistance to UV radiation
- Fast curing
- Can be painted over after curing
- High chemical resistance
- Excellent adhesion to most common materials (except PE, PP, PTFE, PVC, glass and bituminous materials)

Applications

- Supple bonding and sealing in vibrating constructions in car bodies, caravans and containers.
- Strong elastic bonding in vibrating constructions.
- Flexible connections in automotive applications.

Packaging

Colour: white, black

Packaging: 600 ml foil bag, other packaging on request

Shelf life

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

Substrates

Substrates: all metals, epoxy coatings, polyesters, ...

There is no adhesion on PE, PP, PTFE (Teflon®) and bituminous substrates. No adhesion on glass and PVC. We recommend a preliminary adhesion test on any substrate.

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

Surface preparation: All smooth surfaces can be treated with Soudal Surface Activator.

Remark: This technical data sheet replaces all previous versions. 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. Since the design, the quality of the substrate and processing conditions are beyond our control, no liability under this publication is accepted. In every case it is recommended to carry out preliminary experiments. Soudal reserves the right to modify products without prior notice.



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Application method

Application method: With manual- or pneumatic caulking gun.

Cleaning: Clean with Soudal Surface Cleaner or with Soudal Swipex, immediately after use

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

Repair: With the same material.

Health- and Safety Recommendations

Take the usual labour hygiene into account. Use only in well-ventilated areas. Consult the packaging label for more information.

Remarks

- Soudaflex 620 is paintable with most waterbased 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 to do a compatibility test before application).
- Remove all traces of soap (tooling) because it will harm the adhesion of the paint onto the sealant.

Liability

The content of this technical data sheet is the result of tests, monitoring and experience. It is general in nature and does not constitute any liability. It is the responsibility of the user to determine by his own tests whether the product is suitable for the application.

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