

Soudaseal 235SF

Revision: 31/03/2014

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Technical data

Basis	MS Polymer
Consistency	Stable paste
Curing system	Moisture curing
Skin formation* (20°C / 65% R.H.)	Ca. 12 min
Curing speed * (20°C / 65% R.H.)	2 mm/24h → 3 mm/24h
Hardness	38 ± 5 Shore A
Density	1,40 g/ml
Elastic recovery (ISO 7389)	> 75 %
Maximum allowed distortion	± 20 %
Temperature resistance	-40 °C → 90 °C
Max. tension (DIN 53504)	2,20 N/mm ²
Elasticity modulus 100% (DIN 53504)	0,75 N/mm ²
Elongation at break (DIN 53504)	800 %
Application temperature	5 °C → 35 °C

(*) these values may vary depending on environmental factors such as temperature, moisture, and type of substrates.

Product description

Soudaseal 235SF is a high quality, neutral, elastic, 1-component construction joint and adhesive sealant based on MS-Polymer.

Properties

- Excellent adhesion on nearly all surfaces, even if slightly moist.
- Very good mechanical characteristics
- High elasticity – movement accomodation up to ±20%
- Good extrudability even at low temperatures
- No bubble formation within sealant in high temperature and humidity applications.
- Good colour stability, weather and UV resistance
- Ecological advantages – free of isocyanates, solvents, halogens and acids
- Can be painted with water based systems

Applications

- Joints and flexible bonds between metals.
- Structural bonding that require high end-strength and flexibility.
- Structural bonding in vibrating constructions.

- Elastic structural bonding in automotive applications: buses, trains, trucks, caravans, ship-building, ...

Packaging

Colour: white, black

Packaging: 290 ml cartridge, 600 ml sausage

Shelf life

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

Chemical resistance

Good resistance to water, aliphatic solvents, mineral oils, grease, diluted inorganic acids and alkalis. Poor resistance to aromatic solvents, concentrated acids and chlorinated hydrocarbons.

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 beyond our control, no liability under this publication are 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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Substrates

Substrates: all usual building substrates, treated wood, PVC, plastics, ...

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

Surface preparation: Porous surfaces in water loaded applications should be primed with Primer 150. All smooth surfaces can be treated with Surface Activator. The surfaces should be degreased before bonding them together.

We recommend a preliminary adhesion test on every surface. Soudaseal 235SF has excellent adhesion on most substrates. Soudaseal 235SF has been tested on the following metal surfaces: steel, AlMgSi1, brass, electrolytic galvanised steel, AlCuMg1, flame galvanised steel, AlMg3 and steel ST1403. Soudaseal 235SF also has a good adhesion on plastics: polystyrene, polycarbonate (Makrolon®), PVC, ABS, polyamide, PMMA, fiberglass reinforced epoxy, polyester. While producing plastics very often releasing agents, processing aids and other protective agents (like protection foil) are used. These should be removed prior to bonding. For optimum adhesion the use of Surface Activator is recommended. NOTICE: bonding plastics like PMMA (e.g. Plexi® glass), polycarbonate (e.g. Makrolon® or Lexan®) in stress loaded applications can give rise to stress cracking and crazing in these substrates. The use of Soudaseal 235SF is not recommended in these applications. There is no adhesion on PE, PP, PTFE (Teflon®), silicones and bituminous substrates.

Joint dimensions

Min. width for bonding: 2 mm

Min. width for joints: 5 mm

Max. width for bonding: 10 mm

Max. width for joints: 30 mm

Min. depth for joints: 5 mm

Recommendation sealing jobs: joint width = 2 x joint depth.

Application method

Application method: With manual- or pneumatic caulking gun.

Cleaning: Clean with white spirit or Surface Cleaner 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. Consult label for more information.

Remarks

- Soudaseal 235SF may be overpainted with water based paints, however due to the large number of paints and varnishes available we strongly suggest a compatibility test before application.
- The drying time of alkyd resin based paints may increase.
- Soudaseal 235SF can be applied to a wide variety of substrates. Due to the fact that specific substrates such as plastics, like polycarbonate, etc, may differ from manufacturer to manufacturer, we recommend preliminary compatibility test.
- Soudaseal 235SF can not be used as a glazing sealant.
- Soudaseal 235SF is not suitable for ship deck caulking.

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