

Soudaseal 250XF

Revision: 13/03/2014

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Technical data

Basis	MS Polymer
Consistency	Stable paste
Curing system	Moisture curing
Skin formation* (20°C / 65% R.H.)	Ca. 5 min
Curing speed * (20°C / 65% R.H.)	3 mm/24h
Hardness	50 ± 5 Shore A
Density	1,47 g/ml
Elastic recovery (ISO 7389)	> 75 %
Maximum allowed distortion	± 20 %
Temperature resistance	-40 °C → 90 °C
Max. tension (DIN 53504)	3,00 N/mm ²
Elasticity modulus 100% (DIN 53504)	1,60 N/mm ²
Elongation at break (DIN 53504)	500 %
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 250XF is a high quality, neutral, elastic, 1-component adhesive sealant based on MS-Polymer with a very high initial tack.

Properties

- High initial tack reducing the need for initial support. Fast curing Good
- extrudability
- high shear strength after full cure (no primer)
- □ Stays elastic after curing and very sustainable
- No odour.
- Can be painted with water based systems
- □ Good colour stability, weather and UV resistance
- Does not contain isocyanates and no silicones
- Good adhesion on wet substrates

- Elastic bonding of panels, profiles and other pieces on the most common substrates (wood, MDF, chipboard, etc).
- Elastic structural bonding in car and container industry.

Packaging

Colour: white, black, grey

Packaging: 290 ml cartridge

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, hydrocarbons, ketones, esters, alcohols, diluted mineral acids and alkalis and (salt) water. Poor resistance to aromatic solvents, concentrated acids and chlorinated hydrocarbons.

Applications

- Sealing and bonding in the building and construction industry.

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.

been tested on following metal surfaces: AlCuMg1, AlMg3, AlMgSi1, stainless steel, electro-galvanized steel, brass, steel ST1403, hot dip galvanized steel. Soudaseal 250XF also has a good adhesion on plastics: polystyrene, polycarbonate (Makrolon®), PVC, polyamide,

All smooth surfaces can be treated with Surface Activator. Soudaseal 250XF is has

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. We recommend a preliminary adhesion test on every surface. **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 250XF is not recommended in these applications. There is no adhesion on PE, PP, PTFE (Teflon®), silicones and bituminous substrates.

Joint dimensions

The optimal bond thickness for this product is at least 2 mm for the elastic properties to come to full justice.

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 250XF 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 250XF 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.
- 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.
- Soudaseal 250XF can not be used as a glazing sealant.
- Soudaseal 250XF can be used for bonding of natural stone, but it cannot be used as a joint sealant on this type of surface. Soudaseal 250XF can therefore only be used on the bottom of natural stone tiles.
- When applying, make sure not to spill any sealant on the surface of materials.

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