Technical datasheet

Soudaseal 255 Supertack

Product description



Soudaseal 255 Supertack is a high quality, neutral, elastic, 1-component adhesive based on SMX-polymer. Soudaseal 255 Supertack has a very high initial tack.

Properties

- Extreme high initial tack of min. 200 kg/m²
- Very good adhesion on many materials, even if slightly moist
- Fast curing
- Good workability
- High shear strength after full cure (no primer).
- Low odour
- Permanently elastic after curing
- Very durable
- Good weather resistance
- Good UV resistance
- Non staining on natural stone
- Soudaseal 255 Supertack achieves a hand tight bond in 30 minutes

Applications

- Bonding in building and metal industry.
- Elastic bonding of objects, panels, profiles and other pieces on the most common substrates.

Technical data

Base		SMX Hybrid Polymer
Consistency		Stable paste
Curing system		Moisture curing
Skin formation		ca. 5 minutes
Curing speed		ca. 3 mm/24h
Density		ca. 1.48 g/ml
Maximum allowed distortion		± 20 %
Elasticity modulus	ISO 37	ca. 2.80 N/mm²
Maximum tension	ISO 37	ca. 3.60 N/mm²
Hardness		70 ± 5 Shore A
Initial tack		> 200 kg/m²
Application temperature		+5°C → +35°C
Temperature resistance		-40°C → +90°C

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.

Soudal NV
Everdongenlaan 18 - 20, B-2300 Turnhout
+32 (0)14.42.42.31
www.soudal.com info@soudal.com

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- Substrate preparation
  Porous surfaces in water loaded applications should be primed with Primer 150. Prepare non-porous surfaces with a soudal activator or cleaner (see technical data sheet). 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 or sealing. For optimum adhesion the use of Surface Activator is recommended.
- Substrate types
  Soudaseal 255 Supertack has a good adhesion to following substrates: all usual building substrates, lacquered wood, stainless steel, AlMgSi1, electrolytic galvanized steel, AlCuMg1, hot dip galvanized steel, AlMg3, steel ST1403, polystyrene, polycarbonate, PVC, ABS, polyamide, PMMA, fiberglass reinforced epoxy, polyester. Soudaseal 255 Supertack has no good adhesion or is not suitable for PE, PP, PTFE (Teflon®), bituminous substrates, copper or copper containing materials such as bronze and brass. 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 255 Supertack is not recommended in these applications. We recommend a preliminary adhesion and compatibility test on every surface.

Application method

- Application method
  Apply the adhesive by means of a caulking gun in beads or dabs (every 15 cm) on one of the substrates. Always apply adhesive to the edges and corners of the panels. Do not apply the glue in a closed circumference, but interrupted. Bond the substrate and tamp with a rubber hammer. If necessary, support the bonded materials. For bonding on absorbent and porous substrates with thin adhesive layer, the adhesive is already hand tight after ca. 30 minutes and can be loaded after ca. 3 hours. Thicker adhesive layers or non-absorbent substrates extend the curing time. The bond can be fully loaded after 24-48 hours.
- Cleaning method
  Clean with White Spirit or Soudal Surface Cleaner immediately after use (before curing).
- Finishing method
  With 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: Please consult the product catalogue, the Soudal website or a Soudal representative.
Packaging: Please consult the product catalogue, the Soudal website or a Soudal representative.
Shelf life: 12 months in unopened packaging in a cool and dry storage place at temperatures between +5°C and +25°C, Once opened the product has only a limited shelf life.

Joint dimensions

- The optimal bond thickness for this product is at least 1 mm for the elastic properties to come to full justice.

Environmental clausules

- Leed regulation: Soudaseal 255 Supertack 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

- Soudaseal 255 Supertack may be overpainted, however due to the large number of paints and varnishes available we strongly suggest a compatibility test before application.

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- The drying time of alkyd resin based paints may increase.
- Soudaseal 255 Supertack 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 a preliminary compatibility test.
- Soudaseal 255 Supertack can not be used as a glazing sealant.
- Soudaseal 255 Supertack can be used for bonding natural stone, but it cannot be used as a joint sealant on this type of surface.
- When applying, make sure that the surface of the materials is not smudged with sealant.
- A total absence of UV can cause a color change of the sealant.
- When using different reactive joint sealants, the first joint sealant must be completely hardened before the next one is applied.
- Not suitable for bonding aquariums.
- Do not use in applications where continuous water immersion is possible.
- Discoloration of the product due to chemicals, high temperatures, UV-radiation may occur.
- Contact with bitumen, tar or other plasticizer releasing materials such as EPDM, neoprene, butyl, etc. is to be avoided since it can give rise to discoloration and loss of adhesion.

This technical data sheet replaces al 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. It is general in nature and does not constitute any liability. 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. It is the responsibility of the user to determine by his own tests whether the product is suitable for the application. In every case it is recommended to carry out preliminary experiments. The manufacturer reserves the right to modify products without prior notice.

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