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### SoudaSeal FC

Base	Silyl-terminated polymer	
Sag	No sag in vertical displ. @120°F	ASTM C 639
Curing system	Moisture Cure	
Tack-free time	20 minutes	ASTM C 679 (maximum 72 hours)
Cure time	24-72 hrs, ¼" diameter bead	@ 75°F & 50% relative humidity
Hardness – Shore A	50 +/- 5	ASTM C 661
Skin Formation (*) (75°F/50% RH)	5 minutes	
Service temperature range	-40°F to +194°F	
Tensile Yield	435 psi	ASTM D 412
Elongation	500%	ASTM D 412
Total joint movement	+/- 25 %	ASTM C 719
Stain and color change	Passes	ASTM C 510 (no visible stain)
Artificial weathering	No Cracking	ASTM C 793 (2,000 hrs Xenonarc)
Shelf life	18 months	Stored between 33°F & 80°F

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

#### Product:

SoudaSeal Fast Cure is an SMX® adhesive/sealant with high initial tack

#### Characteristics:

- excellent adhesion on porous and non porous substrates
- immediate high grab strength on nearly all surfaces
- high performance mechanical properties
- flexible elastic rubber - movement accommodation up to +/- 25%
- high green strength, quick build-up of end strength, high shear strength after full cure
- no bubble formation within sealant even in high temperature and humidity applications
- very easy to tool and finish
- color stable and UV resistant
- ecological advantages - free of isocyanates, solvents, halogens and acids
- minimal health and safety considerations
- can be painted with all water based paints and many other systems (to be tested)
- good extrudability even at low temperatures
- excellent weather resistance in all climates
- primerless adhesion on many different substrates (except where water pressure may occur)
- almost odorless

#### Applications:

- can be used for mirror installations as a 1 step product
- sealing and bonding in building and construction industry and metal working industry
- sanitary and kitchen areas - resists mould growth
- structural elastic bonding
- structural bonding applications in the automotive industry (cars, coaches, caravans, marine, trains)
- elastic bonding of panels, profiles and other pieces on the most common substrates

#### Colors:

white, gray, black, limestone, tan

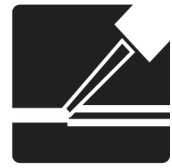
#### Packaging:

10.1 fl. oz. cartridge

#### Shelf life:

18 months in unopened packaging in a cool and dry storage place at temperatures between 41°F and 77°F

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### Adhesion:

SoudaSeal FC has an excellent adhesion on almost all substrates. SoudaSeal FC has been tested on the following metal surfaces: steel, AlMgSi1, brass, electrolytic galvanized steel, AlCuMg1, flame galvanized steel, AlMg3 and steel ST1403. Plastics that were tested include: polystyrene, polycarbonate (Makrolon®), PVC, polyamide, glasfiber reinforced epoxy and polyester (GRP). 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 polycarbonate (ie Makrolon® or Lexan®) in stress loaded applications can give rise to stress cracking and crazing in these substrates. The use of SoudaSeal FC is not recommended in these applications. There is no adhesion on PE, PP, PTFE (Teflon®) and PMMA (ie Plexi® glass).

### Substrates:

*Type:* all usual building surfaces, most metals, polyesters and many plastics. Not suitable for PE, PP, PTFE (Teflon®), ABS or PMMA (ie Plexi® glass).

*Surface Preparation:* clean, dry, free of dust and grease

- it is expected that the product will adhere and perform in uncontaminated joints with most common construction substrates, without the use of a primer
- porous surfaces in water loaded applications should be primed with Primer 150  
surface activator may be used to pretreat non-porous surfaces
- we always recommend preliminary compatibility tests pervious to application

### Resistance to chemical agents:

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

### Remarks:

- Pre-testing for adhesion is intended to eliminate potential filed problems. This testing will aid in determining the proper surface preparation method.
- May be painted, 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.
- 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 tests.
- Porous surfaces in water loaded applications should be primed with Primer 150.
- Lower temperatures and humidity will extend curing time.

### Bonding Layer:

We recommend a bonding layer of at least 3/4" to achieve a bond with maximum elastic properties.

### Application:

*Method:* Manual- or pneumatic caulking gun *Application temperature:* 34°F to +90°F *Cleaning:* with IPA immediately after use and before curing *Repair with:* SoudaSeal FC

### Meets:

ASTM C 920, Type S, Grade NS, Class 25, Use T, NT, M, A, G and O, Federal Specification TT-S-00230C, Type II, Class A

### Health- and Safety Recommendation:

KEEP OUT OF REACH OF CHILDREN. Avoid skin and eye contact. On Contact, uncured sealant could cause irritation to skin and eyes. In case of eye contact, flush eyes with warm water for 15 minutes, call a physician. For skin contact, remove sealant with a paper towel. If swallowed, do not induce vomiting, call a physician. SoudaSeal FC is manufactured for professional use only. Refer to Material Safety Data Sheet (MSDS) for further information.

### Limited Warranty:

Soudal warrants product to be of good quality and will replace or, at our election, refund the purchase price of any products proved to be defective. Satisfactory results depend not only upon quality products, but also upon many factors beyond our control. Therefore, except for such replacement or refund, Soudal makes no warranty or guarantee, express or implied, including warranties of fitness for a particular purpose or merchantability, respecting its products, and Soudal shall have no other liability with respect thereto. Any claim regarding product defect must be received in writing one (1) year from the date of shipment. No claim will be considered without such written notice or after the specified time interval. User shall determine the suitability of the products for the intended use and assume all risks and liability in connection therewith.