



# SODASEAL 270HS

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## Technical Characteristics:

Base	MS Polymer®
Consistency	Stable Paste
Curing System	Moisture Cure
Skin Formation (*)	Ca. 5 min. (20°C/65% R.V.)
Curing Rate (*)	3-4mm/24h (20°C/65% R.V.)
Hardness	68±5 Shore A
Change in volume	<2%
Specific Gravity	1,52g/mL
Maximum Deformation	±20%
Temperature Resistance (fully cured)	-40°C until +90°C
Elasticity Modulus 100 %	2N/mm <sup>2</sup> (DIN 53504)
Tear Strength	2,80N/mm <sup>2</sup> (DIN 53504)
Elongation at break	>250% (DIN 53504)
Shear Strength	>2N/mm <sup>2</sup>
Substrate	AlMgSi1
Tickness	2mm
Shear velocity	10mm/min

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

### Product:

Soudaseal 270HS is a high quality single component adhesive sealant with high stiffness and very high adhesive strength. It is based on MS-Polymer®, chemically neutral and fully elastic. For use in elastical structural bonding applications in industrial, automotive, marine and aerospace areas where a tough flexible rubber is required.

### Characteristics:

- High performance mechanical properties
- Combines high stiffness with very high bond strength
- High green strength, quick build-up of end strength, high sheer strength after full cure
- Does not contain isocyanates, silicone, solvent
- Can be sanded after full cure
- Flexible elastic rubber – movement accomodation up to 20%
- No bubble formation within sealant (in high temperature and humidity applications)
- Very easy to tool and finish
- Colour stability and UV resistance

- Can be painted wet-on-wet in paint trains with most industrial paints
- Withstands all climatic conditions
- Minimal health and safety considerations

### Applications:

Structural elastic bonding between metal surfaces, coated surfaces and many plastics (not PE, PP, Teflon)

Structural bonding applications in the car-, coach-, caravan-, marine-, train-, aerospace industries  
 Bondings which pass through paint tunnels  
 Structural bonding in vibrating constructions  
 Connection joints in sheet metal fabrication

### Packaging:

Colour: white, black  
 Packaging: cartridge 290mL; foil bag 600mL, hobbocks 20L, drums 200L on request

### Shelflife:

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

Remark: 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. In every case it is recommended to carry out preliminary experiments.



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**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 hydrogens

**Bonding:**

Soudaseal 270HS has excellent adhesion on many surfaces. The following metal surfaces have been tested: steel, AlMgSi1, brass, electrogalvanized steel, AlCuMg1, firegalvanized steel, steel ST1403. Excellent adhesion as well on many plastics: Polystyrene, Polycarbonate (Macrolon®, Lexan®), PVC, ABS Polyamide, PMMA, GRP, Fibre Reinforced Epoxy, Polyester.

Please remove protective films from plastic surfaces prior to application of Soudaseal HS. Careful: do not use plastic material which is under stress (PMMA, Plexiglass, Polycarbonate, etc.) as stress tearing may occur. No adhesion on PE, PP and PFTE (Teflon)

**Substrates:**

*Nature:* clean, dry, free of dust and grease  
*Priming:* substrates should be primed with Soudal Surface Activator  
We recommend preliminary compatibility tests previous to application.

**Bonding layer:**

We recommend a bonding layer of at least 2mm

**Application:**

*Method:* Manual- or pneumatic caulking gun

*Application temperature:* +1°C until +30°C

*Cleaning:* White Spirit or Surface Cleaner immediately after application and before curing

*Tooling:* soapy solution before skin formation

*Repair with:* Soudaseal 270HS

**Health- and Safety Recommendation:**

Apply the usual industrial hygiene.

**Remarks:**

- Soudaseal 270HS may be painted with most types of lacquer used in industrial applications, however due to the large number of paints and varnishes available we strongly suggest a compability test before application. The drying time of alkyd resin based paints may increase.
- Soudaseal 270HS can be applied to a wide variety of substrates. Due to the fact that specific substrates such as plastics, polycarbonate, etc, may differ from manufacturer to manufacturer, we recommend preliminary compatilby test.

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