



# Soudaseal 605

## Description

Soudaseal 605 is a high-quality, neutral, elastic, one-component adhesive – sealant with very fast strength build-up on SMX – polymer.

## Properties

- Fast curing
- High initial tack
- Very good adhesion on many materials
- Stays elastic after curing
- No bubble formation within sealant in high temperature and humidity applications
- No odour
- Does not shrink
- Free of isocyanates, solvents, halogens and acids
- Phthalate- and Tin-free

## Application

- Supple bonding and sealing in vibrating construction in carbodies, caravans and containers.
- Strong elastic bonding in vibrating constructions.
- Flexible connections in automotive applications.



## Technical data

Base	SMX Hybrid Polymer	
Consistency	Stable paste	
Curing system	Moisture curing	
Specific Gravity (g/ml)	1.69	
Skin formation (minutes)	ca. 25	
Curing speed (mm/24h)	ca. 3	
Hardness (Shore A, Points)	50 ± 5	
Maximum allowed joint movement (%)	ISO 11600	± 20
Elasticity Modulus (N/mm <sup>2</sup> )	ISO 37	ca. 1.30
Elongation at Break (%)	ISO 37 / ASTM D412	> 200
Maximum tension (N/mm <sup>2</sup> )	ISO 37	ca. 1.70
Temperature Resistance (°C)	-40 to +90	
Application Temperature (°C)	+5 to +35	

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.



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## ■ Substrate preparation

Prepare non-porous surfaces with a Soudal Activator or cleaner. Porous surfaces should be primed with Soudal Primer 150.

## ■ Substrate types

Soudaseal 605 has a good adhesion to many porous and non-porous substrates, metals, aluminum, wood, PVC.

Soudaseal 605 is not suitable for PE, PP, PTFE (Teflon®), bituminous substrates, copper or copper containing materials such as bronze and brass.

We recommend a preliminary adhesion and compatibility test on every surface.

## Application method

### ■ Application method

Apply the product with a manual, pneumatic or a battery-operated caulking gun.

### ■ Cleaning method

Swiftly clean with Soudal Surface Cleaner or with White Spirit, immediately after use (before curing). Cured product can only be removed mechanically.

### ■ Finishing method

Finish with a soapy solution or Soudal 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.

## Packaging/Logistics

Colour: White, Black, Alu Grey

Packaging: 600g Sausage

Shelf life: 12 months from the date of production. The product must be stored in its original, undamaged, and sealed packaging under dry conditions, protected from direct sunlight, and at temperatures between +5°C and +25°C.

## Remarks

- When applying, make sure not to spill any sealant on the surface of materials next to the joint. Using tape on the surface next to the joint can prevent this.
- A total absence of UV can cause a color change of the sealant.
- Soudaseal 605 can discolour under the influence of high UV stress and in dark spaces.
- Discoloration of the product due to chemicals, high temperatures, UV-radiation may occur.
- A change in color does not affect the technical properties of the product.
- When using different reactive joint sealants, the first joint sealant must be completely hardened before the next one is applied.
- Do not use in applications where continuous water immersion is possible.
- 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 supersedes all earlier versions. The information provided is based on our tests and practical experience and is supplied in good faith as general guidance only, without creating any liability. Since materials, substrates, application design, and processing conditions vary widely and are outside our control, we cannot accept responsibility for the results obtained from use of this information. The user must verify suitability for the intended application through their own testing, and preliminary trials are recommended in all cases. The manufacturer reserves the right to change product specifications without prior notice.