**Technical Data Sheet**

**Soudaseal 250XF**

**Revision: 8/09/2015**

**Technical data**

<table>
<thead>
<tr>
<th>Property</th>
<th>Specification</th>
</tr>
</thead>
<tbody>
<tr>
<td>Basis</td>
<td>MS Polymer</td>
</tr>
<tr>
<td>Consistency</td>
<td>Stable paste</td>
</tr>
<tr>
<td>Curing system</td>
<td>Moisture curing</td>
</tr>
<tr>
<td>Skin formation* (20°C / 65% R.H.)</td>
<td>Ca. 5 min</td>
</tr>
<tr>
<td>Curing speed * (20°C / 65% R.H.)</td>
<td>3 mm/24h</td>
</tr>
<tr>
<td>Hardness</td>
<td>50 ± 5 Shore A</td>
</tr>
<tr>
<td>Density</td>
<td>1.47 g/ml</td>
</tr>
<tr>
<td>Elastic recovery (ISO 7389)</td>
<td>&gt; 75 %</td>
</tr>
<tr>
<td>Maximum allowed distortion</td>
<td>± 20 %</td>
</tr>
<tr>
<td>Temperature resistance</td>
<td>-40 °C → 90 °C</td>
</tr>
<tr>
<td>Max. tension (DIN 53504)</td>
<td>3.00 N/mm²</td>
</tr>
<tr>
<td>Elasticity modulus 100% (DIN 53504)</td>
<td>1.60 N/mm²</td>
</tr>
<tr>
<td>Elongation at break (DIN 53504)</td>
<td>500 %</td>
</tr>
<tr>
<td>Application temperature</td>
<td>5 °C → 35 °C</td>
</tr>
</tbody>
</table>

(*) 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 moist substrates
- Elastic structural bonding in car and container industry.

**Packaging**

- Colour: white, black, grey
- Packaging: 290 ml cartridge, 600 ml sausage

**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.
- Elastic bonding of panels, profiles and other pieces on the most common substrates (wood, MDF, chipboard, etc).

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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. All smooth surfaces can be treated with Surface Activator. Soudaseal 250XF is has 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, 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®) 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.
- A total absence of UV can cause a color change of the sealant.

Environmental clauses

Leed regulation:

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