



Soudabond 675 HR

Revision: 30/06/2021

Page 1 from 2

Technical data

Basis	SMX Hybrid Polymer
Consistency	Stable paste
Curing system	Moisture curing
Skin formation* (23°C/50% R.H.)	Ca. 5 min
Curing speed * (23°C/50% R.H.)	3 mm/24h → 4 mm/24h
Hardness**	68 ± 5 Shore A
Density	1,52 g/ml
Maximum allowed distortion (ISO 11600)	± 20 %
Max. tension (ISO 37)**	2,80 N/mm ²
Elasticity modulus 100% (ISO 37)**	2,00 N/mm ²
Elongation at break (ISO 37)**	> 250 %
Temperature resistance**	-40 °C → 90 °C
Short term temperature resistance after complete curing	Max. 30 min in drying oven at 200°C
Application temperature	5 °C → 35 °C

* These values may vary depending on environmental factors such as temperature, moisture, and type of substrates. ** This information relates to fully cured product.

Product description

Soudabond 675 HR is a high quality, neutral, elastic, one component adhesive sealant based on SMX Polymer.

Properties

- High temperature resistance
- High end strength
- Fast skinning time
- High initial tack and fast build-up of end strength.
- Excellent adhesion on nearly all surfaces, even if slightly moist.
- Very good mechanical characteristics.
- Combines high end strength with certain rigidity.
- Easy to use and apply, also under difficult circumstances.
- No bubble formation within sealant in high temperature and humidity applications.
- Good weather and UV resistance
- Free of isocyanates, solvents, halogens and acids
- Can be painted with water based systems and industrial varnishes and coatings.

Applications

- For use in elastic structural bonding applications where a tough and rigid bond is required.
- Structural bonding in vibrating constructions.
- Elastic structural bonding in automotive applications: buses, trains, trucks, caravans or trailers ...
- Joints between metal plates.

Packaging

Colour: white

Packaging: 600 ml foil bag

Shelf life

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

Chemical resistance

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

Remark: This technical data sheet replaces all 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. 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. In every case it is recommended to carry out preliminary experiments. Soudal reserves the right to modify products without prior notice.

Soudabond 675 HR

Revision: 30/06/2021

Page 2 from 2

Substrates

Substrates: all usual substrates for bonding, treated wood, PVC, ...

Nature: rigid, 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 Soudal Surface Activator.

Soudabond 675 HR has excellent adhesion on most substrates. Soudabond 675 HR is has been tested on following metal surfaces: stainless steel, AlMgSi1, electro-galvanized steel, hot dip galvanized steel, AlMg3, steel ST1403. Soudabond 675 HR also has a good adhesion on plastics: polystyrene, polycarbonate (Makrolon®), PVC, ABS, polyamide, PMMA, 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 or sealing. For optimum adhesion the use of Surface Activator is recommended. 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 Soudabond 675 HR is not recommended in these applications. Not suitable for PE, PP, PTFE (eg Teflon®), bituminous substrates, copper or copper-containing materials such as bronze and brass. We recommend a preliminary adhesion test on any substrate.

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 Soudal Surface Cleaner or with Soudal Swipex, 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

- Soudabond 675 HR is paintable with most waterbased 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.
- Once fully cured Soudabond 675 HR can be coated with water-based industrial paints or powder coating and then dried for a maximum of 30 minutes in a drying oven at temperatures up to 200°C.
- Soudabond 675 HR 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.
- Soudabond 675 HR can not be used as a glazing sealant.
- Soudabond 675 HR can be used for bonding of natural stone, but it cannot be used as a joint sealant on this type of surface. Soudabond 675 HR can therefore only be used on the bottom of natural stone tiles.
- When applying, make sure that the surface of the materials is not smudged with sealant.

Remark: This technical data sheet replaces all 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. 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. In every case it is recommended to carry out preliminary experiments. Soudal reserves the right to modify products without prior notice.