

SOUDAFLEX 621

Revision: 20/03/2023

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Technical Data

Basis	Polyurethane
Consistency	Stable paste
Curing System	Moisture curing
Specific Gravity	Ca. 1.28
Skin formation time (23°C/50% R.H) (min)*	Ca. 50
Curing Speed (23°C/50% R.H) (min)*	3
Hardness, Shore A, points**	Ca. 40±5
Max. tension (N/mm ²) (ISO 37)**	1.52
Elongation at Break (ISO 37)** (%)	600
Elasticity Moduls 100% (N/mm ²) (ISO 37)**	1.34
Maximum allowed distortion (%)	±20
Elastic Recovery (ISO 7389)** (%)	>80
Temperature Resistance (°C)	-30 →90
Application Temperature (°C)	-5 → 35

* 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

Soudaflex 621 is a strong and permanently elastic polyurethane adhesive for bonding and sealing in the automotive and transport industry.

- For bonding container elements, car body parts, windscreens, wheel arch extensions, etc...
- Replaces the traditional weld or spot weld.

Properties

- Medium open time
- High viscosity
- Applicable in warm and humid climate.
- Permanently elastic after curing
- Good weather and UV resistance
- Watertight
- Excellent resistance to many chemicals
- Can be painted with all water based paints and many other systems (to be tested)
- Very good primerless adhesion on many materials such as aluminium, steel, GRP, epoxy coatings etc

Packaging

Colour: white, black
Packaging: 600 ml foil bag, other packaging on request

Shelf life

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

Health- and Safety Recommendations

Take the usual labour hygiene into account. Use only in well-ventilated areas. Consult the packaging label for more information.

Applications

- Supple bonding and sealing in vibrating constructions in car bodies, caravans and containers.
- Also bonding of upright parts.

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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Substrates: all metals, epoxy coatings, polyesters, ...

There is no adhesion on PE, PP, PTFE (Teflon®) and bituminous substrates. No adhesion on glass and PVC. We recommend a preliminary adhesion test on any substrate.

Nature: rigid, clean, dry, free of dust and grease.

Surface preparation: All smooth surfaces can be treated with Soudal Surface Activator.

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.

Remarks

- Soudaflex 621 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.
- When painted with oxidative drying paints disturbances in the drying of the paint may occur (we recommend to do a compatibility test before application).
- Remove all traces of soap (tooling) because it will harm the adhesion of the

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