

**SOUDABOND 642 DUO**

Revision: 08/07/2015

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Technical data:

Base	2-component polyurethane
Curing system	Chemical curing
A-component Consistency Colour Specific gravity Brookfield viscosity (RVT 6/5)	Paste White Approx. 1,32 g/cm ³ Approx. 48.000 mPa.s
B-component Consistency Colour Specific gravity Brookfield viscosity (RVT 6/5)	Paste Brown Ca. 1,32 g/cm ³ Ca. 48.000 mPa.s
Mixture Mixing ratio Consistency Colour Specific gravity (g/cm ³) Brookfield viscosity (HBT A/20)	A:B = 1:1 Paste Beige Ca. 1,32 Ca. 48.000 mPa.s
Processing time (after mixing) at 21°C and 50% rh	Ca. 45 minutes
Load bearing	Approx. 24 hours
Shore D (A+B)	Approx. 65
Shear strength (DIN EN 1465)	>16 N/mm ²
Temperature resistance	-40°C to +100°C (once fully cured)
Durability against ageing	Excellent
Total solids content	100% (solvent free)
Application rate	15- 20 grams per window corner

Product:

Soudabond 642 DUO is a solvent- and water-free 2-component polyurethane adhesive for bonding of aluminium corner angles in extruded window profiles.

Properties:

- Moisture independent curing
- Solvent free
- Water free
- Rapid buildup of bond strength
- Very high final bond strength
- Good filling capacity
- Does not shrink
- Wide application spectrum

Applications:

Soudabond 642 DUO is extremely suitable for bonding of aluminium corner angles into extruded window profiles by means of post injection. Also suitable for bonding of metal in other applications.

Description:

Soudabond 642 DUO cures by means of a chemical reaction. Fully cured (approx. 24 h at 21°C and 50% RH) a hard-elastic and non-shrinkable adhesive layer with excellent resistance to moisture, heat and all weather conditions is formed.

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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The adhesive has excellent adhesion to practically all common substrates used in the construction industry.

Packaging:

2-component cartridge 310+310 mL with static mixing nozzle
Mixing ratio: 1:1 (can be used as a one-component product by means of the static mixer)

Shelf life:

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

Substrates:

Type: most common metal bonds. Not suitable for glass, PE, PP, PA, EPDM and PTFE (Teflon).
Conditions: clean, dry, free of dust and grease.
Preparation: none

We recommend a preliminary compatibility test.

Applying the adhesive:

Application method: With manual- or pneumatic caulking gun. When using a pneumatic gun **do not exceed 4.5 bar**.

Remove green cap from the cartridge and assemble static mixer. Extrude the first 10 cm of the product onto a piece of cardboard until a homogeneous mixture of the product is achieved. Apply Soudabond 642 Duo, after assembly of the aluminium window frame, by means of post-injection in the respective openings. Do not cut off the static mixer. In case post-injection is not possible, the mixed adhesive can also be applied in the extruded profile before assembling and pressing the window frame.

For other metal bonding applications, apply the mixed product onto one of the substrates to be bonded. Join the parts together within 60 minutes and clamp for at least 4 hours. Pressing the materials, during curing, is necessary to reach the highest possible end strength.

Because of curing of the mixed components the mixed adhesive can not be applied after 45 min. If necessary replace the static mixer.

Non mixed components can be re-used within several months after the cartridge is resealed with the green seal.

Application temperature: +5°C to +35°C

Cleaning: Soudabond 642 Duo can, before the adhesive is cured, be removed from tools and materials with Soudal Gun and Foam Cleaner. Cured adhesive has to be removed mechanically.

Health and safety recommendations:

Apply the usual industrial hygiene precautions. Wear gloves.

Consult the label for more information.

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