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**Soudaseal 270 HS**

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**Technical Characteristics:**

Base	MS Polymer®
Consistency	Paste
Curing System	Moisture Cure
Skin Formation (*) (20°C/65% R.V.)	Ca. 5 min.
Curing Rate (*) (20°C/65% R.V.)	3 - 4 mm/24h
Hardness (DIN 53505)	68 ± 5 Shore A
Specific Gravity (DIN 53479)	1,52 g/ml
Maximum Deformation	± 20 %
Temperature Resistance (fully cured)	-40°C to +90°C
Elasticity Modulus 100 % (DIN 53504)	2,00 N/mm <sup>2</sup>
Tear Strength (DIN 53504)	2,80 N/mm <sup>2</sup>
Elongation at break (DIN 53504)	> 250 %
Shear Strength Substrate Thickness Shear velocity	> 2 N/mm <sup>2</sup> AlMgSi1 2 mm 10 mm/min

(\*) these values may vary depending on environmental factors such as temperature, moisture, and type of substrates

**Product:**

Soudaseal 270HS is a high quality single component adhesive-sealant with high stiffness and very high adhesive strength. It is based on MS-Polymer®, chemically neutral and fully elastic.

**Characteristics:**

- High performance mechanical properties
- Combines high stiffness with very high bond strength
- High green strength, quick build-up of end strength, high shear strength after full cure
- Does not contain isocyanates, silicone, solvent
- Can be sanded after full cure
- Flexible elastic rubber – movement accommodation up to 20%
- No bubble formation within sealant (in high temperature and humidity applications)
- Very easy to tool and finish
- Colour stability and UV resistance
- Can be painted wet-on-wet in paint trains with most industrial paints
- Withstands all climatic conditions
- Minimal health and safety considerations

**Applications:**

For use in elastical structural bonding applications in the car-, coach-, caravan-, marine-, train-, aerospace industries where a tough and flexible bond is required.

Structural elastic bonding between metal surfaces, coated surfaces and many plastics (not PE, PP, Teflon)

Bondings which pass through paint tunnels  
Structural bonding in vibrating constructions  
Connection joints in sheet metal fabrication

**Packaging:**

*Colour:* white, black

*Packaging:* cartridge 290 ml, foil bag 600 ml, hobbocks 20 l, drums 200 l on request

**Shelflife:**

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

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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**Resistance to chemical agents:**

Good resistance to water, aliphatic solvents, mineral oils, grease, diluted inorganic acids and alkalis

Poor resistance to aromatic solvents, concentrated acids, chlorinated hydrocarbons.

**Bonding:**

Soudaseal 270 HS has an excellent adhesion on almost all substrates. Soudaseal 270 HS has been tested on the following metal surfaces: steel, AlMgSi1, brass, electrolytic galvanised steel, AlCuMg1, flame galvanised steel, AlMg3 and steel ST1403. Plastics that were tested include: polystyrene, polycarbonate (Makrolon®), PVC, ABS, polyamide, PMMA, glasfiber reinforced epoxy and polyester (GRP).

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. NOTICE: bonding plastics like PMMA (ie Plexi® glass), polycarbonate (ie Makrolon® or Lexan®) in stress loaded applications can give rise to stress cracking and crazing in these substrates. The use of Soudaseal 270 HS is not recommended in these applications.

There is no adhesion on PE, PP and PTFE (Teflon®).

**Substrates:**

*Nature:* clean, dry, free of dust and grease. We recommend the use of Soudal Surface Activator on non porous surfaces to clean and activate them.

*Priming:* Primer 150 may be used on porous substrates in water loaded applications.

We always recommend preliminary compatibility tests previous to application.

**Bonding Layer:**

We recommend a bonding layer of at least 2mm to achieve a bond with maximum elastic properties.

**Application:**

*Method:* Manual or pneumatic caulking gun

*Application temperature:* +1°C until +30°C

*Cleaning:* White Spirit or Surface Cleaner immediately after application and before curing

*Tooling:* soapy solution before skin formation

*Repair with:* Soudaseal 270HS

**Health- and Safety Recommendation:**

Apply the usual industrial hygiene.

**Remarks:**

- Soudaseal 270HS can be coated with many types of paints and varnishes. Due to the large variety of paints and coatings a compatibility test is strongly recommended. The drying times of alkyd resin based paints may increase.
- Soudaseal 270HS can be painted immediately after application "wet on wet" with waterbased industrial paints in paint trains at temperatures of up to 200°C during up to 45 minutes.
- Soudaseal 270HS can be applied to a wide variety of substrates. Due to the fact that specific substrates such as plastics, polycarbonate, etc, may differ from manufacturer to manufacturer, we recommend preliminary compatibility test.
- This product can not be used as a glazing sealant

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