



# Soudaseal 250XF

## Product description

Soudaseal 250XF is a high quality, neutral, elastic one-component adhesive sealant based on SMX-polymer. Soudaseal 250XF has a very high initial tack.

## Properties

- High initial tack
- Reduced need for support.
- Fast curing
- Good extrudability
- High shear strength after full cure (no primer).
- Low odour
- Stays elastic after curing
- Very durable
- Can be painted with water based systems
- Good weather resistance
- Good UV resistance
- Good adhesion on slightly moist substrates



## Applications

- Sealing and bonding applications in the building industry.
- Elastic bonding of objects, panels, profiles and other pieces on the most common substrates.
- Elastic structural bonding in car and container industry.

## Technical data

|                                |                    |                            |
|--------------------------------|--------------------|----------------------------|
| Base                           | SMX Hybrid Polymer |                            |
| Consistency                    | Stable paste       |                            |
| Curing system                  | Moisture curing    |                            |
| Skin formation                 | ca. 5 minutes      |                            |
| Curing speed                   | ca. 3 mm/24h       |                            |
| Density                        | ca. 1.47 g/ml      |                            |
| Maximum allowed joint movement | ± 20 %             |                            |
| Elasticity modulus             | ISO 37             | ca. 1.60 N/mm <sup>2</sup> |
| Elastic recovery               | ISO 7389           | > 75 %                     |
| Elongation at break            | ISO 37             | ca. 500 %                  |
| Maximum tension                | ISO 37             | ca. 3.00 N/mm <sup>2</sup> |
| Hardness                       | 50 ± 5 Shore A     |                            |
| Application temperature        | +5°C → +35°C       |                            |
| Temperature resistance         | -40°C → +90°C      |                            |

*Footnote: Skinning time and curing speed may vary depending on environmental factors such as temperature, moisture, and type of substrates.*



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## Substrates

- **Substrate condition**  
The surface must be rigid, clean, dry or slightly moist, free of dust and grease.
- **Substrate preparation**  
Porous surfaces in water loaded applications should be primed with Primer 150. Prepare non-porous surfaces with a soudal activator or cleaner (see technical data sheet). 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.
- **Substrate types**  
Soudaseal 250XF has a good adhesion to following substrates: all usual building substrates, lacquered wood, AlCuMg1, AlMg3, AlMgSi1, stainless steel, electrolytic galvanized steel, steel ST1403, hot dip galvanized steel, polystyrene, polycarbonate, PVC, polyamide, fiberglass reinforced epoxy, polyester, etc.. Soudaseal 250XF has no good adhesion or is not suitable for PE, PP, PTFE (Teflon®), bituminous substrates, copper or copper containing materials such as bronze and brass. 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. We recommend a preliminary adhesion and compatibility test on every surface.

## Application method

- **Application method**  
Apply the product with a manual, pneumatic or accu caulking gun.
- **Cleaning method**  
Clean with White Spirit or Soudal Surface Cleaner immediately after use (before curing).
- **Finishing method**  
With Finishing Solution before skinning.
- **Repair method**  
Repair with the same material.

## Health- and Safety Recommendations

Take the usual labour hygiene into account. Consult the packaging label and safety data sheet for more information.  
Keep the area well ventilated during use and curing of the product.  
Dangerous. Respect the precautions for use.

## Packaging/Logistics

Colour: Please consult the product catalogue, the Soudal website or a Soudal representative.  
Packaging: Please consult the product catalogue, the Soudal website or a Soudal representative.  
Shelf life: 12 months in unopened packaging in a cool and dry storage place at temperatures between +5°C and +25°C, Once opened the product has only a limited shelf life.

## Standards and certificates

- EC1 Plus label: very low emission

## Joint dimensions

- The optimal bond thickness for this product is at least 2 mm for the elastic properties to come to full justice.

## Environmental clauses

- **Leed regulation:** Soudaseal 250XF conforms to the requirements of LEED. Low –Emitting Materials: Adhesives and Sealants. SCAQMD rule 1168. Complies with USGBC LEED 2009 Credit 4.1: Low-Emitting Materials – Adhesives & Sealants concerning the VOC-content.



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## 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 a preliminary compatibility test.
- Soudaseal 250XF can not be used as a glazing sealant.
- Soudaseal 250XF can be used for bonding natural stone, but it cannot be used as a joint sealant on this type of surface.
- When applying, make sure that the surface of the materials is not smudged with sealant.
- A total absence of UV can cause a color change of the sealant.
- When using different reactive joint sealants, the first joint sealant must be completely hardened before the next one is applied.
- Not suitable for bonding aquariums.
- Do not use in applications where continuous water immersion is possible.
- Discoloration of the product due to chemicals, high temperatures, UV-radiation may occur.
- Contact with bitumen, tar or other plasticizer releasing materials such as EPDM, neoprene, butyl, etc. is to be avoided since it can give rise to discoloration and loss of adhesion.

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. It is general in nature and does not constitute any liability. 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. It is the responsibility of the user to determine by his own tests whether the product is suitable for the application. In every case it is recommended to carry out preliminary experiments. The manufacturer reserves the right to modify products without prior notice.