



Soudabond 680

Revision: 24/11/2016

Page 1 from 2

Technical data

Basis	Hybrid Polymer
Consistency	Stable paste
Curing system	Moisture curing
Skin formation	Ca. 20-30 min. (*)
Curing speed *	3 mm/24h (20°C/65% R.H.)
Hardness	60 ± 5 Shore A
Density	1,40 g/ml
Max. tension (DIN 53504)	4,20 N/mm ² ± 0,4 N/mm ²
Elasticity modulus 100% (DIN 53504)	2,30 N/mm ²
Elongation at break (DIN 53504)	> 300 %
Shear strength	> 2 MPa (Measured on Stapron®, 2mm paste thickness and 10mm/min test speed)
Temperature resistance	-40 °C → 90 °C
Application temperature	5 °C → 35 °C

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

Product description

Soudabond 680 is a high quality, neutral, one-component adhesive based on Hybrid Polymer. Soudabond 680 has an excellent primer-less adhesion to ABS.

Properties

- Excellent primerless adhesion on ABS and Stapron® as well as on most other materials
- used in the transport industry
- Very good mechanical characteristics.
- Combines high end strength with certain rigidity.
- High initial tack and fast build-up of end strength.
- 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

- Bonding of ABS parts

- For bonding of for instance (imitation) leather, textile, glass, metal, textile, ABS, Plexiglas and many synthetic materials, both hard and soft.
- For use in elastic structural bonding applications where a tough and rigid bond is required.
- Elastic structural bonding in automotive applications: buses, trains, trucks, caravans or trailers ...

Packaging

Colour: white, black

Packaging: 400 ml sausage, 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.

Chemical resistance

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

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 680

Revision: 24/11/2016

Page 2 from 2

Substrates

Substrates: all usual substrates for bonding, stainless steel, AlCuMg1, AlMgSi1, brass, electrolytic galvanised steel, galvanized steel, AlMg3, staal ST1403

Nature: clean, dry, free of dust and grease. Soudabond 680 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. 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 680 is not recommended in these applications. There is no adhesion on PE, PP, PTFE (Teflon®) and bituminous substrates. 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 680 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.
- Soudabond 680 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 680 has a good UV resistance but can discolour under extreme conditions or after very long UV exposure.
- Soudabond 680 can not be used as a glazing sealant.

Liability

The content of this technical data sheet is the result of tests, monitoring and experience. It is general in nature and does not constitute any liability. It is the responsibility of the user to determine by his own tests whether the product is suitable for the application.

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.