



SODASEAL METALBOND

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Technical Data:

Base	Silyl-terminated polymer	
Sag	No sag in vertical displ. @ 120°F	ASTM C 639
Curing system	Moisture Cure	
Skin Formation (*)	11 minutes	@ 75°F & 50% relative humidity
Tack-free time (*)	60 minutes	ASTM C 679
Curing time (*)	24-48 hrs, 1/4" diameter bead	@ 75°F & 50% relative humidity
Hardness – Shore A	40 +/- 5	ASTM C 661
Tensile Yield	145 psi	ASTM D 412
Elongation	170%	ASTM D 412
Movement capability	+/- 20%	ASTM C 719
Stain and color change	Passes	ASTM C 510 (mortar)
Artificial weathering	No Cracking	ASTM C 793
Service temperature range	-40°F to +200°F	
Application temperature range	-35°F to +140°F	
Shelf life	12 months	Stored between 41°F & 77°F
VOC	2% - 35 g/L	Directive 2004/42/EG

(*) these values may vary depending on environmental factors such as temperature, moisture, and type of substrates. Test results are averages obtained under laboratory conditions. Reasonable variations can be expected.

Product:

Soudaseal Metalbond is a solvent free, high quality single component HVAC ducting sealant for all types of metal ducts. This high performance product is engineered for a wide range of sealing and bonding applications. It is based on MS-Polymer®.

Characteristics:

- Very easy to apply
- Low odor and solvent free
- Color fast and waterproof after curing
- Very good adhesion on galvanized and stainless steel
- Remains permanently flexible

Applications:

- All types of HVAC duct systems including sheet metal, duct board and flexible ducts
- Sealing of seems, spigot and flange joints, and metal fabrications
- Bonding in the building and construction industry
- Indoor and outdoor use
- Good UV resistance

Packaging:

Color: gray

Packaging: 1 gallon in PE bucket, other sizes by special order

Shelf life:

12 months in unopened packaging in a cool and dry storage place at temperatures between 41°F and 77°F.

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 and chlorinated hydrocarbons.

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Substrates:

Nature: clean, free of dust and grease, no adhesion on PE, PP, PTFE and bituminous substrates.

Priming: porous surfaces should be primed with Primer 150, surface activator may be used on non-porous surfaces.

We recommend preliminary compatibility test previous to application.

Application:

Method: spatula or notched trowel

Application temperature: 40°F to +95°F

Cleaning: IPA immediately after use and before curing

Tooling: with soapy solution before skin formation

Repair with: Soudaseal Metalbond

Health- and Safety Recommendation:

KEEP OUT OF REACH OF CHILDREN. Avoid skin and eye contact. On Contact, uncured sealant could cause irritation to skin and eyes. In case of eye contact, flush eyes with warm water for 15 minutes, call a physician. For skin contact, remove sealant with a paper towel. If swallowed, do not induce vomiting, call a physician. Soudaseal Metalbond is manufactured for professional use only. Refer to Material Safety Data Sheet (MSDS) for further information.

Remarks:

- May be painted, 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.
- 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 tests.
- Bonding plastics like PMMA (ie Plexi® glass) and polycarbonate (ie Makrolon® or Lexan®) in stress loaded applications can give rise to stress cracking and crazing in these substrates. The use of Soudaseal Metalbond is not recommended in these applications.
- There is no adhesion on PE, PP, PTFE (Teflon®), silicones and bituminous substrates.
- Should not be used as a glazing sealant.
- Should not be used for continuous immersion in water.
- Do not apply to freshly treated wood; treated wood must have been weathered for at least 6 months.
- Lower temperatures and humidity will extend curing time.
- Contact with plasticizer containing plastics (e.g. flexible PVC, butyl rubber, EPDM,...) can lead to incompatibilities, such as discoloration or loss of adhesion. We recommend a preliminary compatibility test.

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