

# Soudaflex 611

Revision: 18/08/2021

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## Technical data

Basis	Polyurethane
Consistency	Stable paste
Curing system	Moisture curing
Skin formation* (23°C/50% R.H.)	Ca. 45 min
Curing speed * (23°C/50% R.H.)	Ca. 4 mm/24h
Hardness**	35 ± 5 Shore A
Density	Ca. 1,41 g/ml
Maximum allowed distortion (ISO 11600)	± 20 %
Elasticity modulus 100% (ISO 37)**	Ca. 1,30 N/mm <sup>2</sup>
Elongation at break (ISO 37)**	850 %
Max. tension (ISO 37)**	Ca. 2,30 N/mm <sup>2</sup>
Temperature resistance**	-30 °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. \*\* This information relates to fully cured product.

## Product description

Soudaflex 611 is a high quality, neutral, elastic, 1-component construction joint and adhesive sealant based on polyurethane.

## Properties

- Very easy to apply
- Permanently elastic after curing
- Excellent resistance to UV radiation
- Very good adhesion on many materials
- Excellent resistance to many chemicals

## Applications

- Soudaflex 611 is suitable for several industrial and building applications like elastic bonding in car body work, caravan, bus and container industry.
- Supple bonding and sealing in vibrating constructions in car bodies, caravans and containers.
- Replaces the traditional weld or spot weld.
- Also bonding of upright parts.

## Packaging

Colour: white, black, grey  
Packaging: 600 ml foil bag

## Shelf life

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

## Substrates

All types of metals. There is no adhesion on PE, PP, PTFE (Teflon®) and bituminous substrates. We recommend a preliminary adhesion and compatibility test on every surface.

*Nature:* rigid, clean, dry, free of dust and grease.

*Surface preparation:* Soudaflex 611 has a good adhesion to most substrates. All smooth surfaces can be treated with Soudal Surface Activator.

## Application method

*Application method:* With a manual, pneumatic or accu caulking gun.

*Cleaning:* Clean with Soudal Surface Cleaner or with Soudal Swipex, immediately after use Cured Soudaflex 611 can only be removed mechanically.

*Finishing:* With a soapy solution or Soudal Finishing Solution before skinning.

*Repair:* With the same material.

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.

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Take the usual labour hygiene into account.  
Consult label and material safety data sheet for more information.

**Remarks**

- Soudaflex 611 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.
- Soudaflex 611 can not be used as a glazing sealant.
- Do not use in applications where continuous water immersion is possible.
- It is recommended to do a compatibility test prior to application.
- Soudaflex 611 has a good UV resistance but can discolour under extreme conditions or after very long UV exposure.
- Do not apply or allow to cure in the presence of uncured silicone sealants, alcohol - or other solvent cleaners.
- When using different reactive joint sealants, the first joint sealant must be completely hardened before the next one is applied.

**Environmental clauses***Lead regulation:*

Soudaflex 611 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.

**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.

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