

			<p>SoudaSeal 25 has an excellent adhesion on almost all substrates. SoudaSeal 25 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 25 is not recommended in these applications. There is no adhesion on PE, PP and PTFE (Teflon®).</p>	<p>SoudaSeal FC has an excellent adhesion on almost all substrates. SoudaSeal FC 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, polyamide, 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 polycarbonate (ie Makrolon® or Lexan®) in stress loaded applications can give rise to stress cracking and crazing in these substrates. The use of SoudaSeal FC is not recommended in these applications. There is no adhesion on PE, PP, PTFE (Teflon®) and PMMA (ie Plexi® glass).</p>		
Bonding						
Application	Method: caulking gun	Method: caulking gun	Method: caulking gun	Method: caulking gun	Method: caulking gun	Method: caulking gun
	Application temperature: 41°F (5°C) to 95°F (35°C)	Application temperature: 41°F (5°C) to 95°F (35°C)	Application temperature: 41°F (5°C) to 95°F (35°C)	Application temperature: 41°F (5°C) to 95°F (35°C)	Application temperature: 41°F (5°C) to 95°F (35°C)	Application temperature: 41°F (5°C) to 95°F (35°C)
	Clean: with white spirit or Surface Cleaner immediately after application and before curing	Clean: with white spirit or Surface Cleaner immediately after application and before curing	Clean: with white spirit or Surface Cleaner immediately after application and before curing	Clean: with white spirit or Surface Cleaner immediately after application and before curing	Clean: with white spirit or Surface Cleaner immediately after application and before curing	Clean: with white spirit or Surface Cleaner immediately after application and before curing
	Finish: soapy water before skinning	Finish: soapy water before skinning	Finish: soapy water before skinning	Finish: soapy water before skinning	Finish: soapy water before skinning	Finish: soapy water before skinning
	Repair: with SoudaSeal 150LM	Repair: with SoudaSeal 50LM	Repair: with SoudaSeal 25	Repair: with SoudaSeal FC	Repair: with SoudaSeal CL	Repair: with SoudaSeal SL
Health- and Safety Recommendation	Apply the usual industrial hygiene. Consult the label for more information	Apply the usual industrial hygiene. Consult the label for more information	Apply the usual industrial hygiene. Consult the label for more information	Apply the usual industrial hygiene. Consult the label for more information	Apply the usual industrial hygiene. Consult the label for more information	Apply the usual industrial hygiene. Consult the label for more information
Joint Size	Minimum width: 1/16 inch (5mm)	Minimum width: 1/16 inch (5mm)	Minimum width: 1/16 inch (5mm)	Minimum width: 1/16 inch (5mm)	Minimum width: 1/16 inch (5mm)	Minimum width: 1/16 inch (5mm)
	Maximum width 1 - 1/2 inch (30mm)	Maximum width 1 - 1/2 inch (30mm)	Maximum width 1 - 1/2 inch (30mm)	Maximum width 1 - 1/2 inch (30mm)	Maximum width 1 - 1/2 inch (30mm)	Maximum width 1 - 1/2 inch (30mm)
	Minimum width: 1/16 inch (5mm)	Minimum width: 1/16 inch (5mm)	Minimum width: 1/16 inch (5mm)	Minimum width: 1/16 inch (5mm)	Minimum width: 1/16 inch (5mm)	Minimum width: 1/16 inch (5mm)
	Recommandation: 2 x depth = width	Recommandation: 2 x depth = width	Recommandation: 2 x depth = width	Recommandation: 2 x depth = width	Recommandation: 2 x depth = width	Recommandation: 2 x depth = width
Remarks		SoudaSeal 50Lm 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. SoudaSeal 50LM should not be used as a glazing sealant	SoudaSeal 25 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. SoudaSeal 25 should not be used as a glazing sealant	SoudaSeal FC 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. SoudaSeal FC should not be used as a glazing sealant		
			SoudaSeal 25 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.	SoudaSeal FC 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.		