



Soudabond 370 Fine Spray

Revision: 29/07/2019

Page 1 from 2

Technical data

Basis	Synthetic rubber
Curing system	Physical drying and crystallisation
Density	Ca. 0,86 g/ml
Viscosity (Brookfield)	Ca. 350 mPa.s
Total solid content	Ca. 27 %
Open time	Minimum 1-2 min Maximum up to 30 min
Drying time (23°C and 50% R.H.)	Ca. 48 h
Consumption (*)	Ca. 165 m ² adhesive surface
Short term temperature resistance after complete curing	-20°C --> 70°C (10 min)
Application temperature	10 °C → 28 °C
Spray pattern	drips

* 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

Soudabond 370 Fine Spray is a ready-to-use, universal contact adhesive based on synthetic rubbers. It is applied two-sided and carried in a canister for immediate spraying without extra spray installation.

Properties

- Very low adhesive consumption
- Overlapping isn't necessary
- Fast drying process.
- Fast strength build-up.
- Immediately fixed
- Moisture resistant.
- Chemical resistant against light acids and bases
- Doesn't contain toluene- and methylene chloride
- Wide application area
- Good adhesion to many materials
- Ready to use and very user friendly
- Efficient spraying - no loss of product
- Portable, no electricity or compressed air needed
- maintenance-free

Applications

- For adhesion and laminate of wood and stratified decorative covering panels (HPL: Formica®, Resopal®, Duropal®, ...), high

gloss panels, laminate, veneer and lacedwood veneer, stairsteps and nosings, PVC-plinths, leather, cork, textile, with each other for wood, multiplex, MDF panels, particle board, lightweight panels, stone, concrete, plaster, metal and other smooth, non-porous surfaces.

- Specifically for adhesions on higher temperatures (+115°C). Can withstand short temperature spikes up to +130°C. Used for postforming up to +180°C.
- Not suitable for polyethylene (PE), polypropylene (PP) and Teflon® (PTFE/PFA/FEP), nor for applications whose surfaces only touch by a few points.

Packaging

Colour: pink or transparent

Packaging: Canister under pressure, 22,1L

Shelf life

18 months in unopened packaging in a dry storage place at temperatures between +10°C and +25 °C. The product should be stored in accordance to the rules of storage of inflammable substances. Consult material safety data sheet for more information. Never place canister on a concrete or tiled floor. Changing canisters: Close the valve of the canister and empty the residue in the hose. Mount the hose and pistol on a new canister

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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Revision: 29/07/2019

Page 2 from 2

immediately and open the valve of the new canister. Open the valve of the old canister slowly, to release the pressure, in a well ventilated space. Make sure all the pressure is released. Perforate the empty canister and discharge as scrap metal.

Substrates

Nature: Clean, dry, free of dust, grease, oil, moist and well fitting

Surface preparation: If necessary, degrease the surface with Soudal Surface Cleaner. Before using, shake or roll canister, at least 20 times. Ideal to apply in a room with a temperature of minimum +18°C. Make sure both the adhesive and the surfaces are acclimatised. For a better adhesion, it's recommended to roughen the surface with sanding paper P80, metal has to be free of rust and roughened at a St 3 level (according to ISO 8501-1). A preliminary adhesion test on every surface is recommended.

Application method

Application method: Adjust the desirable spray pattern by choosing the correct nozzle and adjusting the ErgoGrip gun. Apply the adhesive two-sided with the ErgoGrip gun. Make sure the adhesive is nebulized equally. At least 80% should be covered. For strong porous materials (plaster, concrete, ...) a second layer can be applied after the first layer (wait for +/- 15 to 20 min). About 1-2 min, depending on the circumstances, let it dry and close maximum 30 min after applying. Immediate adhesion. Then, press well with a pressure roller, in a press during 15s or bat down with a rubber hammer. After usage, immediately close the ErgoGrip gun.

Health- and Safety Recommendations

canister under pressure, do not store at temperatures higher as +50°C or in direct sunlight. Use only in well-ventilated areas. Do not smoke. In case of insufficient ventilation it is appropriate to wear respiratory protection. Consult label and material safety data sheet for more information. These guidelines are meant as a recommendation. The user has to check if the product is suitable for the specific application.

Remarks

- When the metal is free of rust and roughened, it's important to ground the element. A discharge of static electricity can ignite the solvents if the adhesive is applied on the surface.
- Once the maximum open time is exceeded and the adhesive is too dry to bond, the surface can be reactivated with an extra thin layer of Soudabond 370 Fine Spray.
- Pressing the materials, during curing, is not necessary to reach the highest end strength. The initial strength and not the duration of the compression will determine the ultimate strength.
- Soudabond 370 Fine Spray has to be stored at +10°C to +25°C. This way it can be used immediately.
- At aftertreatment of veneer, make sure to avoid at all costs that the varnish reaches the adhesive through the veneer. Respect the curing time of the adhesive before applying varnish. Preferred to apply the finishing products in multiple thin layers as in one abundant layer.

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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