Technical datasheet

Soudabond SP 370 FS

Product description

Soudabond SP 370 FS is a ready-to-use, universal contact adhesive based on synthetic rubbers. It is applied two-sided. Soudabond SP 370 FS is carried in canister for immediate spraying without extra sprayinstallation.

Properties

- Very low adhesive consumption
- Overlapping isn't necessary
- Fast drying
- Fast build-up of end strength
- Immediatly fixed
- Resistant to high temperatures
- Moisture resistant
- Maintenance-free
- Chemical resistant against weak acids and bases
- Doesn't contain toluene and methylene chloride
- Ready to use and very user-friendly
- Efficient spraying - no loss of product
- Portable, no electricity or compressed air needed
- Wide application area

Applications

- For adhesion and laminate of wood and stratified decorative coveringpanels (HPL: Formica®, Resopal®, Duropal®, ...), high gloss panels, laminate, veneer and lacewood 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 temperture spikes up to +130°C. Used for postforming up to +180°C.

Technical data

Base	Synthetic rubber
Curing system	Physical drying
Drying time	ca. 48 hours
Density	ca. 0,86 g/ml
Open time	ca. 30 minutes
Spray pattern	Mist
Consumption	ca. 125 ml/m², each side
Application temperature	10°C - 25°C
Temperature resistance	-20°C → +70°C
Pressing time	15-30 sec
Solid content	ca. 27%

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Evaporation time	ca. 2 minutes

Footnote: evaporation time, open time and curing speed may vary depending on environmental factors such as temperature, moisture, and type of substrates.

Substrates

- Substrate condition
  The materials should be flat and well fitting as well as clean, dry and free of dust and grease.
- Substrate preparation
  Both substrates have to be even and/or well matched. Make sure both the adhesive as the substrates are acclimatized. For a better adhesion, it is 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). All substrates should be tested for suitability with regard to adhesion and compatibility.
- Substrate types
  Soudabond SP 370 FS has a good adhesion to following substrates: all common materials. Beware of migration of the plasticizer form soft plastics, this might negatively influence the bond. Soudabond SP 370 FS has no good adhesion or is not suitable for PE, PP, PTFE (Teflon®). We recommend a preliminary adhesion and compatibility test on every surface.

Application method

- Application method
  Before using, shake or roll canister, at least 20 times. 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. Make sure that the adhesive is sprayed equally, the coverage has to be min. 80%. For strong porous materials (plaster, concrete, ...) a second adhesive layer has to be applied, ± 20 mins after the first layer. Wait for ca. 2 minutes and join both parts together. Then press hard with a roller or tap strongly with a rubber hammer. The bonding happens immediately. After usage, immediately close the ErgoGrip gun. Changing canisters: Close the valve of the canister and empty the residue in the hose. Mount the hose and pistol on a new cannister 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. The emptied, non-cleaned canister with opened valve can be disposed and processed according to the local and/or national regulations.
- Application tools
  Ergogrip gun
- Cleaning method
  Apply solvent cleaner to a cloth to wipe off uncured product. After spraying, clean the spray tip with Soudal Dissolver SP.
- Repair method
  Repair with Soudabond SP 370 FS.

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

Packaging/Logistics

Packaging: Various sizes available. Please consult the product catalogue, the Soudal website or a Soudal representative.
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.

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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 SP 370 FS
- 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 SP 370 FS has to be stored at +10°C to +25°C. This way it can be used immediately.
- Too much adhesive will result in a longer evaporation time and might give a worse result.
- 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.

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