



## Soudabond 365 Classic Spray

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### Technical data

Basis	Synthetic rubber
Curing system	Physical drying and crystallisation
Density**	Ca. 0,86 g/ml
Viscosity (Brookfield)	Ca. 500 mPa.s
Total solid content	Ca. 28 %
Evaporation time (=minimum time before bonding)	Ca. 5 min
Open time (23°C, 55% RV)*	≤ 45 min.
Pressing times	15-30s, press, roll or tap well
Short term temperature resistance after complete curing	-20°C - 90°C
Application temperature	10 °C → 25 °C
Drying time (23°C and 50% R.H.)	Ca. 72h
Spray pattern	Web
Tools	Ergogrip gun
Consumption*	Ca. 125 ml/m <sup>2</sup> each side Ca. 145 m <sup>2</sup> adhesive surface

\* 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 365 Classic Spray is a ready to use, universal, methylene chloride free contact adhesive based on synthetic rubbers. Packed in a portable canister for an immediate use without a spray installation.

### Properties

- Very low adhesive consumption
- Fast drying process.
- Fast strength build-up.
- Long open time
- Immediately fixed
- Moisture resistant.
- High heat resistance
- maintenance-free
- Chemical resistant against light 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

### Applications

- Used in two-sided adhesions on plasticizer resistant, soft materials like carpet, leather, cork, felt, textile and others.
- Suitable for two-sided bondings of different materials which are flat and well-fitting.
- 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: 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

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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 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. Keep the gun perpendicular to the surface to spray the adhesive equally. There should be an overlap of 50% to 75% between the different adhesive strips. Be extra careful with sides and corners, we advise to start by applying a frame of adhesive around the sides. For strong porous materials (plaster, concrete, ...) a second layer can be applied after the first layer (wait for +/- 15 to 20 min). Respect the evaporation time and close down the bond before the open time expires. 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.

Cleaning: After spraying, clean the spray tip with Soudal Dissolver SP.

Finishing: Wait the full drying time before applying a lacquer or bite. Apply those in multiple thin layers. After pressing, the bonded parts can be finished.

Repair: With the same material.

### 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.

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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 365 Classic 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 365 Classic Spray has to be stored at +10°C to +25°C. This way it can be used immediately.
- For bonding high gloss laminate or super matte laminate, use Soudal 370SP.
- Not suitable for synthetic materials with a high percentage of plasticizer.
- Too much adhesive will result in a longer evaporation time and might give a worse result.

### 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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