

# SODASEAL METALBOND

Revision: 10/15/20

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**Technical Data:**

Base	Silyl-terminated polymer	
Sag	No sag in vertical displ. @120°F	ASTM C 639
Curing system	Moisture Cure	
Skin Formation (*)	8 minutes	@ 75°F & 50% relative humidity
Tack-free time (*)	60 minutes	ASTM C 679
Curing time (*)	24-48 hrs, 1/4" diameter bead	@ 75°F & 50% relative humidity
Hardness – Shore A	40 +/- 5	ASTM C 661
Tensile Yield	145 psi	ASTM D 412
Elongation	170%	ASTM D 412
Movement capability	+/- 20%	ASTM C 719
Stain and color change	Passes	ASTM C 510 (mortar)
Artificial weathering	No Cracking	ASTM C 793
Service temperature range	-40°F to +200°F	
Application temperature range	-35°F to +140°F	
Shelf life	12 months	Stored between 41°F & 77°F
VOC	2% - 35 g/L	EPA method 24

(\*) these values may vary depending on environmental factors such as temperature, moisture, and type of substrates. Test results are averages obtained under laboratory conditions. Reasonable variations can be expected.

**Product:**

Soudaseal Metalbond is a solvent free, high quality single component HVAC ducting sealant for all types of metal ducts. This high performance product is engineered for a wide range of sealing and bonding applications. It is based on SMX®. Polymer.

**Characteristics:**

- Very easy to apply
- Low odor and solvent free
- Color fast and waterproof after curing
- Very good adhesion on galvanized and stainless steel
- Remains permanently flexible

**Applications:**

- All types of HVAC duct systems including sheet metal, duct board and flexible ducts
- Sealing of seems, spigot & flange joints, and metal fabrications
- Bonding in the building and construction industry
- Indoor and outdoor use
- Good UV resistance

**Packaging:**

*Color:* gray  
*Packaging:* One gallon in PE bucket, other sizes by special order

**Shelf life:**

12 months in unopened packaging in a cool and dry storage place at temperatures between 41°F and 77°F.

**Resistance to chemical agents:**

Good resistance to water, aliphatic solvents, mineral oils, grease, diluted inorganic acids and alkalis.

Poor resistance to aromatic solvents, concentrated acids and chlorinated hydrocarbons.

**Substrates:**

*Nature:* Clean, free of dust and grease, no adhesion on PE, PP, PTFE and bituminous substrates.  
*Priming:* Porous surfaces should be primed with Primer 150, surface activator may be used on non-porous surfaces.

**We recommend preliminary compatibility test previous to application.**

Remark: This information and all further technical advice are based on Soudal present knowledge and experience. However, Soudal assumes no liability for providing such information and advice including the extent to which such information and advice may relate to existing third party intellectual property rights, especially patent rights. In particular, Soudal disclaims all WARRANTIES EXPRESS OR IMPLIED, INCLUDING THE IMPLIED WARRANTIES OF FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY. Soudal SHALL NOT BE RESPONSIBLE FOR CONSEQUENTIAL, INDIRECT OR INCIDENTAL DAMAGES (INCLUDING LOSS OF PROFITS) OF ANY KIND. Soudal reserves the right to make any changes according to technological progress or further developments.

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**Application:**

*Method:* spatula or notched trowel

*Cleaning:* IPA immediately after use and before curing

*Tooling:* with soapy solution before skin formation

*Repair with:* Soudaseal Metalbond

**Health- and Safety Recommendation:**

KEEP OUT OF REACH OF CHILDREN. Avoid skin and eye contact. On Contact, uncured sealant could cause irritation to skin and eyes. In case of eye contact, flush eyes with warm water for 15 minutes, call a physician. For skin contact, remove sealant with a paper towel. If swallowed, do not induce vomiting, call a physician. Soudaseal Metalbond is manufactured for professional use only. Refer to Safety Data Sheet (SDS) for further information.

**Remarks:**

- 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.
- Can be applied to a wide variety of substrates. Due to the fact that specific substrates, like polycarbonate, etc. may differ from manufacturer to manufacturer, we recommend preliminary compatibility tests.
- Bonding plastics like PMMA (ie Plexi® glass) and polycarbonate (ie Makrolon® or Lexan®) in stress loaded applications can give rise to stress cracking and crazing in these substrates. The use of Soudaseal Metalbond is not recommended in these applications.
- There is no adhesion on PE, PP, PTFE (Teflon®), silicones and bituminous substrates.
- Should not be used as a glazing sealant.
- Should not be used for continuous immersion in water.
- Do not apply to freshly treated wood; treated wood must have been weathered for at least 6 months.
- Lower temperatures and humidity will extend curing time.
- Contact with plasticizer containing plastics (e.g. flexible PVC, butyl rubber, EPDM,...) can lead to incompatibilities, such as discoloration or loss of adhesion. We recommend a preliminary compatibility test.

**Limited Warranty:**

SODAL warrants product to be of good quality and will replace or, at our election, refund the purchase price of any products proved to be defective. Satisfactory results depend not only upon quality products, but also upon many factors beyond our control. Therefore, except for such replacement or refund, SODAL MAKES NO WARRANTY OR GUARANTEE, EXPRESSED OR IMPLIED, INCLUDING WARRANTIES OF FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY, RESPECTING ITS PRODUCTS, and SODAL shall have no other liability with respect thereto. Any claim regarding product defect must be received in writing one (1) year from the date of shipment. No claim will be considered without such written notice or after the specified time interval. User shall determine the suitability of the products for the intended use and assume all risks and liability in connection therewith.