SOUDAL

Technical datasheet

Carbond 940FC

Product description

Carbond 940FC is an elastic polyurethane adhesive for structural bonding of body elements.

Properties

- Easy to apply
- Permanently elastic after curing
- Good UV resistance
- Fast curing
- Very good adhesion on many materials
- Can be painted over after curing
- High chemical resistance

Applications

- Supple bonding and sealing in vibrating constructions in carbodies, caravans and containers.
- Strong elastic bonding in vibrating constructions.
- Flexible connections in automotive applications.

Technical data

Base		Polyurethane
Consistency		Stable paste
Curing system		Moisture curing
Skin formation		ca. 15 minutes
Curing speed		3 mm/24h
Density		1,30 g/ml
Maximum allowed joint movement	ISO 11600	± 20 %
Elasticity modulus	ISO 37	0,80 N/mm²
Elastic recovery	ISO 7389	> 80 %
Elongation at break	ISO 37	700 %
Maximum tension	ISO 37	1,70 N/mm²
Hardness		40 ± 5 Shore A
Application temperature		+5°C → +35°C
Temperature resistance		-30°C → +90°C

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

Substrates

- Substrate condition
  The surface must be rigid, clean, dry, free of dust and grease.
- Substrate preparation
  Porous surfaces should be primed with Primer 100. If needed non porous surfaces can be prepared with Soudal Surface Cleaner (see Technical Data Sheet). All substrates should be tested for suitability with regard to adhesion and compatibility.

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- Substrate types
  Carbond 940FC has a good adhesion to following substrates: all metals, epoxy coatings, polyester. Carbond 940FC has no good adhesion or is not suitable for PVC, glass, PE, PP, PTFE (Teflon®), bituminous substrates. We recommend a preliminary adhesion and compatibility test on every surface.

Application method

- Application method
  Apply Carbond 940FC with a manual- or pneumatic caulking gun.
- Cleaning method
  Clean with White Spirit or Soudal Surface Cleaner immediately after use (before curing).
- Finishing method
  Finish with a soapy solution or Finishing Solution before skinning.
- Repair method
  Repair with the same material.

Health- and Safety Recommendations

Take the usual labour hygiene into account. Consult the packaging label and safety data sheet for more information.
Use only in well-ventilated areas.

Packaging/Logistics

Colour: Please consult the product catalogue, the Soudal website or a Soudal representative.
Packaging: Please consult the product catalogue, the Soudal website or a Soudal representative.
Shelf life: 12 months in unopened packaging in a cool and dry storage place at temperatures between +5°C and +25°C

Joint dimensions

- Min. width for bonding: 2 mm
  Min. width for joints: 5 mm
  Max. width for bonding: 10 mm
  Max. width for joints: 30 mm
  Min. depth for joints: 5 mm
  Recommendation sealing jobs: joint width = 2 x joint depth.

Remarks

- Carbond 940FC is paintable with most waterbased paints, however due to the large number of paints and varnishes available we strongly suggest a compatibility test before application.
- When painted with oxidative drying paints disturbances in the drying of the paint may occur (we recommend to do a compatibility test before application).
- Remove all traces of soap (tooling) because it will harm the adhesion of the paint onto the sealant.
- When using different reactive joint sealants, the first joint sealant must be completely hardened before the next one is applied.

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