

SOUDAL

Soudal Installation Reference Compact Core Panel Bonding Guide

Products Referenced

- Soudaseal 250XF - Hybrid Polymer Fast-Grab Adhesive/Sealant
- Soudacryl Flex - Paintable Siliconized Acrylic Latex Sealant

1. General Notes

- This guideline assists installers in correct use of Soudal products.
- Soudaseal 250XF is a hybrid polymer adhesive/sealant designed for bead application.
- Not a laminating adhesive; do not full-spread with a trowel.
- Recommended bond line thickness: 2-3 mm.
- On-site adhesion testing required before full installation.
- Follow panel manufacturer recommendations for compatibility and prep.

2. Surface Preparation

- Remove protective film from panel surface before bonding.
- Clean substrates to remove dust, grease, residue.
- If residue suspected, wipe with IPA and allow to dry.
- Surface activator may be required for optimal bonding.
- Ensure surfaces are dry, clean, and sound.
- Avoid oily cleaners like WD-40.

3. Application of Soudaseal 250XF

- Cut nozzle to 1/4" - 3/8" (6-10 mm).
- Apply continuous beads spaced 10-15 cm.
- Do not smear or use a notched trowel.
- Press panel firmly into place immediately after application.
- Aim for uniform 2-3 mm bond thickness.
- Support with bracing or tape until cured.
- Avoid disturbance for 24 hours; full cure 24-48 hours at 23C, 50% RH.

4. Finishing and Sealing

- Use Soudacryl Flex for finishing joints or edge sealing.
- Verify adhesion to substrate.
- Tool joints within 10 minutes.

5. Important Notes & Disclaimer

- Conditions like temperature and humidity affect cure.
- Installer must verify adhesion performance.
- Guide does not replace engineering specifications.
- Use Soudal products within intended parameters.