

## Metal Fix

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### Technical data

Basis	SMX Hybrid Polymer
Consistency	Stable paste
Curing system	Moisture curing
Skin formation* (20°C / 65% R.H.)	Ca. 5 min
Curing speed * (20°C / 65% R.H.)	3 mm/24h
Hardness	65 ± 5 Shore A
Density	1,47 g/ml
Elastic recovery (ISO 7389)	> 75 %
Maximum allowed distortion	± 20 %
Max. tension (DIN 53504)	3,20 N/mm <sup>2</sup>
Elasticity modulus 100% (DIN 53504)	2,30 N/mm <sup>2</sup>
Elongation at break (DIN 53504)	400 %
Temperature resistance	-40 °C → 90 °C
Application temperature	5 °C → 35 °C

(\*) these values may vary depending on environmental factors such as temperature, moisture, and type of substrates.

### Product description

SOUDAL METAL FIX is an extremely strong construction adhesive with high initial tack

(> 150kg/m<sup>2</sup>). Suitable for bonding heavy materials without any mechanical fastening.

### Properties

- High initial tack reducing the need for initial support.
- Fast curing
- Good extrudability
- high shear strength after full cure (no primer)
- Stays elastic after curing and very sustainable
- Impervious to mould, contains ZnP (biocide with fungicidal action)
- No odour.
- Can be painted with water based systems
- Good weather and UV resistance
- Does not contain isocyanates and no silicones
- Good adhesion on slightly moist substrates

### Applications

- Sealing and bonding in the building and construction industry.

- Elastic bonding of panels, profiles and other pieces on the most common substrates (wood, MDF, chipboard, etc).

### Packaging

*Colour:* grey

*Packaging:* 290 ml cartridge

### Shelf life

12 months in unopened packaging in a cool and dry storage place at temperatures between +5°C and +25°C.

### Chemical resistance

Good resistance to (salt)water, aliphatic solvents, hydrocarbons, ketones, esters, alcohols, diluted mineral acids and alkalis. Poor resistance to aromatic solvents, concentrated acids and chlorinated hydrocarbons.

Remark: This technical data sheet replaces all previous versions. The directives contained in this documentation are the result of our experiments and of our experience and have been submitted in good faith. Because of the diversity of the materials and substrates and the great number of possible applications which are out of our control, we cannot accept any responsibility for the results obtained. Since the design, the quality of the substrate and processing conditions are beyond our control, no liability under this publication is accepted. In every case it is recommended to carry out preliminary experiments. Soudal reserves the right to modify products without prior notice.

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**Substrates**

*Substrates:* metals, treated wood, PVC, plastics, all usual building substrates

*Nature:* clean, dry, free of dust and grease.

*Surface preparation:* Porous surfaces in water loaded applications should be primed with Primer 150. All smooth surfaces can be treated with Soudal Surface Activator.

We recommend a preliminary adhesion test on every surface. Not suitable for PE, PP, PTFE (eg. Teflon®) and bituminous substrates.

**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.

**Application method**

*Application method:* With manual- or pneumatic caulking gun.

*Cleaning:* With Fix ALL Cleaner immediately after use.

*Finishing:* With a soapy solution or Soudal Finishing Solution before skinning.

*Repair:* With the same material

**Health- and Safety Recommendations**

Take the usual labour hygiene into account. Consult label for more information.

**Remarks**

- Metal Fix may be overpainted with water based paints, 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.
- Metal Fix can be applied to a wide variety of substrates. Due to the fact that specific substrates such as plastics, like polycarbonate, etc, may differ from manufacturer to manufacturer, we recommend preliminary compatibility test.
- While producing plastics very often releasing agents, processing aids and other protective agents (like protection foil) are used. These should be removed prior to bonding. For optimum adhesion the use of Surface Activator is recommended.
- Metal Fix can not be used as a glazing sealant.
- Not suitable for bonding aquariums.
- Metal Fix can be used for bonding of natural stone, but it cannot be used as a joint sealant on this type of surface. Metal Fix can therefore only be used on the bottom of natural stone tiles.
- When applying, make sure not to spill any sealant on the surface of materials.
- The sanitary formula should not replace regular cleaning of the joint. Excessive contamination, deposits or soap remainings will stimulate the development of fungi.

**Environmental clauses***Leed regulation:*

Metal Fix conforms to the requirements of LEED. Low –Emitting Materials: Adhesives and Sealants. SCAQMD rule 1168. Complies with USGBC LEED® 2009 Credit 4.1: Low-Emitting Materials – Adhesives & Sealants concerning the VOC-content.

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### 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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