

SODATHERM ROOF 250

Revision date: 13/10/2014

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Technical data:

Basis	Polyurethane Adhesive
Consistency	Liquid
Curing system	Moisture curing
Skin formation (20°C and 60% R.H.)*	8 min
Curing time (20°C and 60% R.H.)*	40 min for beads with a diameter of 30mm
Walking on the boards after (20°C and 60% R.H.)*	45 min
Burdening after (20°C and 60% R.V.)*	After 1h
Yield	12 m ² insulation / can
Post expansion	Minimal
Temperature resistance	From -40°C to +90°C (when cured)
Colour	Orange
Fire Rating (DIN 4102 part 1)	B2
Thermal conductivity (EN 12667)	Ca. 0,036 W/m.K

(*)These values may vary depending on ambient factors such as temperature, humidity and type of substrate

Product:

Soudatherm Roof 250 is a polyurethane foam adhesive in aerosol for the efficient, clean, economical and durable bonding of roof insulation panels. The characteristics of this foam adhesive make it also suitable for uneven surfaces. The adhesive can be applied efficiently and quickly with an adjustable gun

- Resistant to wind uplift (Tested by IFI, Aachen)
- Reduces weight and space
- Excellent adhesive properties
- No solvent content so fully compatible with polystyrene (PS).
- Does not age or rot, but should not be exposed to UV

Characteristics:

- Adhesive foam is a perfect insulator: also for filling the joints. Thermal conductivity: 0.036W/m.K
- Ready-to-use
- Economic in use due to precise application
- Saving of up to 30% in working time
- Open time: Max 8 min
- Fast curing; 1 hour after application
- Suitable for uneven surfaces as it fills cavities (up to 1cm under an insulation panel)
- Also suitable for vertical applications

Applications:

Bonding of common insulation materials

- PIR/PUR covered with
 - Mineral-coated glass fibre
 - Bituminous glass fibre (Sand surfaced or chipped, not on burnable PP surfaces)
 - Aluminium
- Expanded polystyrene (EPS)
- Mineral insulation materials (e.g. Perlite, Multipor®, Fermacell®)
- Mineral wool (but on flat surfaces, Soudatherm Roof 170 is a better bonding solution)

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On many types of surfaces:

- Insulation on insulation (multi-layer)
- Even and uneven surfaces
- Masonry surfaces (e.g. concrete, fibre cement, cellular concrete)
- Steel roof decks
- Bituminous roofing felts, sand surfaced or chipped
- Wooden boards, hard PVC, plaster,...
- On vapour barriers:
 - Check the technical data sheet of the vapour barrier to make sure it is suitable for insulation bonding
 - To be tested prior to use or used only with approval of the manufacturer of the barrier
 - Bituminous vapour barriers are possible
 - Aluminium coated vapour barriers: only with the approval of the manufacturer
- Doesn't bond on PP, PE or PTFE (Teflon)
- Always perform a prior adhesion test

Working method adhesives:

- The materials should be clean and free of dust and grease. Loose parts should be removed and the surface should be coated with a primer if necessary.
- For renovation and especially ballasted roofs, make sure the bonding surface is firmly attached to the substructure.
- Adjust extrusion rate to allow for 30mm beads using the setting screw at the end of the applicator gun.
- Apply directly onto the surface, holding the gun at an angle of about 90° to the surface and ensure a distance of about 1 to 2 cm between nozzle and surface. The nozzle should not be in direct contact with the surface.

- Shake at least 30 times with the can upside down to ensure proper mixing of the ingredients and maximum yield.
- Thread the can tightly to the Applicator Gun.
- After extrusion, the panels need to be pressed down in the adhesive beads within the open time of 8 minutes.
- It's recommended to shake the can after each work interruption.
- At least 4 beads / m² (30mm diameter) should be applied (80 to 100 g/m²). On the corners and the edges of the roof, at least 8 beads are recommended. The correct number of beads (and thus the usage of adhesive) can be calculated according to EN 1991-1-4. The region, the roof area, the location and structure height and also the location on the roof (middle, corners or edges) are factors that have to be taken into account.
- On uneven surfaces (for example old bituminous roofing felts), more adhesive (thicker beads up to 50mm) needs to be applied in order to make sure that there is at least 40% adhesive transfer between surface and insulation panel.
- Do not hammer on the boards
- When the boards are pulled back or displaced (and the adhesive layer is broken), it's necessary to apply extra adhesive to get a good bond.
- If not yet cured, use Soudal Gun & Foam Cleaner for cleaning. Cured adhesive should be removed mechanically.
- After 30 minutes, the roofing membrane can be placed on the insulation panels. Limit walking on the panels to a minimum during the first 60 minutes.

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Working method gap filling:

- Shake at least 30 times with the can upside down to ensure proper mixing of the ingredients and maximum yield.
- Thread the can tightly to the Applicator Gun.
- It's recommended to shake the can after each work interruption.
- When the product is applied in multiple layers, moisten the surface between each layer.
- If not yet cured, use Soudal Gun & Foam Cleaner for cleaning. Cured adhesive should be removed mechanically.

Application temperature:

- Surface temperature:
From +0 °C to +35 °C
- Ambient temperature:
From +5 °C to +35 °C
- Aerosol temperature:
From +10 °C to +35 °C

Packaging:

- Aerosol can of 800mL (net content), 12 cans / box

Colour: Orange**Shelf life:**

- 18 months in the unopened packaging in a dry location (with a storage temperature from 5°C to 25°C).

- After application, just lock the gun and it's closed.
- If the product will not be used within the following week, clean can and gun with Soudal Gun & Foam Cleaner.
- After cleaning, remove the Soudal Gun & Foam Cleaner and empty the gun completely.

Safety recommendations:

- Observe the standard industrial hygiene procedures
- Wear protective goggles and gloves
- Remove cured adhesive mechanically, never remove with a flame.
- For further information on product safety and handling, refer to the information on the container.

Test reports:

- IFI (Aachen) PB 22/09: EPS 040
- IFI (Aachen) PB 23/09: Powerdeck F
- Carlisle Europe 08/08/2013: Kingspan TR27 on PDT ALUTRIX 600/FR
- BDA (Gorinchem) 0293-L-13/1: Linitherm PAL (SK)
- BDA (Gorinchem) 0197-L-14/1: Bondrock MV on Hassodritt Vapor

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