



# Industry

## Bus, Coach, Car, Truck, Train, OEM, OES Solutions Guide

- Soudaflex: PU Sealants
- Soudaseal: Hybrid Sealants
- Soudafoam: PU Foams
- Soudabond: Adhesives
- Silirub: Silicone Sealants

**Now in India**

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R&D Centre, Belgium



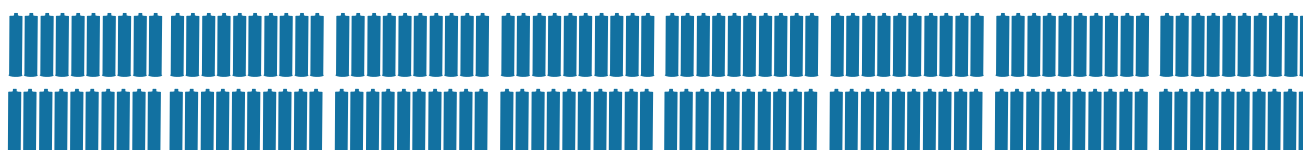
R&D Centre, Bawal (India)

# Key Figures 2014

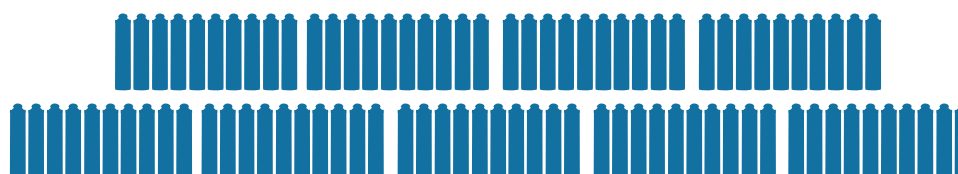
Annual key figure Soudal Group

(In thousand €)	2014	2013	2012
Gross Turnover	564.751	489.395	436.393
Operating Result	33.904	27.518	22.969
Net Result	21.734	16.580	16.948
Cash Flow	40.283	30.701	28.767
Added Value	139.944	114.751	101.632
Balance Sheet Total	300.129	269.119	214.451
Investments	40.800	35.700	22.000
Workforce	2.195	1.843	1.559

**200 MILLION**  
**CARTRIDGES PRODUCED**  
 SEALANTS & ADHESIVES



**100 MILLION**  
**CANS PRODUCED**  
 PU FOAMS



# Production sites all over the world



Soudal PU foam production: Turnhout, Belgium

## Belgium - since 1966

In 1966, Vic Swerts, the owner of Soudal, has been one of the pioneers to start the commercial production of silicone sealants. The first year 3.000 cartridges were produced which grew over the years to more than 500.000 cartridges a day. Production has expanded over the years to other sealants like acrylics, polyurethanes and MS polymers and all kinds of adhesives. From 1982 PU foams were added to the product line.



Soudal PU foam production: Pionki, Poland

## Poland - since 2009

In 2008, the finishing touches to the construction of a brand new 8,000 m<sup>2</sup> production facility inside a 40,000 m<sup>2</sup> plus ground in the Polish town of Pionki. As of February 2009 some 100 new staff started the production of PU foams and sealants in new, high-tech production lines that are entirely geared to the fast-growing Polish & Eastern European markets.



Soudal PU foam production: Shanghai, China

## China - since 2010

In 2010 Soudal signed an agreement to take over Shija, the second largest supplier of PU foams in the Chinese market. Shija was one of the major manufacturers in China with over 10 million cans of PU foam produced annually. With strong growth, China is rapidly developing into one of largest economies worldwide. Through this acquisition Soudal has gained access to this market, with a significant presence in the construction sector.



Soudal sealant production: Istanbul (Turkey)

## Istanbul (Turkey)- since 2011

On 31 October 2011 Soudal NV took over all of İşik Group's production and sales activities for sealants, adhesives and PU foams from the family shareholder. This take-over is a sign of Soudal's ambitions to expand and make its presence felt around the globe.



McCoy Soudal Plant and R&D Centre (Bawal), Haryana

## India (Bawal, Haryana) - since 2012

November 4<sup>th</sup> 2012 was a proud moment for McCoy Soudal, a 50:50 Joint Venture between the McCoy Group (India) and Soudal Group (Belgium) to have inaugurated officially state-of-the-art plant, a multi crores (55 Cr.) investment, for manufacturing sealants, adhesives and PU foams in India. The plant spreads across 200,000 sq. ft. & is one of Asia's largest manufacturing plants in its category, with a capacity close to 20 million (2 Cr.) cartridges per year of sealants & adhesives, later to be expanded by PU foams in India.

# Production sites all over the world



Soudal PU foam production: TKK Srpenica

## TKK Srpenica (Slovenia)- since 2013

Soudal is proud to announce the acquisition of TKK Srpenica, the largest independent manufacturer of PU Foams, Sealants and concrete additives in South Eastern Europe. TKK is located in Srpenica in the Republic of Slovenia, employs over 200 co-workers and is expected to reach a turnover of some €50 Mio in 2013.



Soudal sealant production: Elizabethtown (USA)

## Accumetric LLC (USA)- since 2014

Accumetric LLC, an independent manufacturer of silicones, sealants & lubricants in Elizabethtown, Kentucky. Accumetric has 150 employees globally & has revenue of approximately \$50 million (37 million EURO) in 2014.



Soudal sealant production: Latvia

## Tenachem (Latvia)- since 2015

Soudal announces the full acquisition of Tenachem (Latvia), a leading producer of sealants specially developed for sealing double glazing. With this purchase, Soudal has added a new technology to its already impressive product portfolio. Tenachem has 73 employees and currently exporting 95% of its products in around 40 countries worldwide.

## 13 production sites across the globe



Soudal in the World

# Continuous investment in Research & Development

Soudal constantly invests in R&D activities, in order to offer the latest innovations & to improve, underline the quality of the existing product range.

## ISO certification

In 1992 Soudal received ISO 9002 approval. The ISO certificate is a first impression of solid quality awareness. This however does not stop some important business partners from conducting their own audits. Soudal and McCoy Soudal are always prepared to cooperate in such activities, confident that its transparency will only enhance the quality relationships with its partners.

McCoy Soudal has since its start in 2010 ISO 9001:2008 certification in India.

## TÜV SÜD Quality label

In 2008 Soudal underlined the quality of its PU Foams even further by letting TÜV SÜD - a worldwide renowned -

company in the field of testing and certification according to the very strict European Norm EN417 – conduct an entire range of tests.

## Soudal R&D center

In 2011 Soudal opened a new R&D building offering room to more than 30 R&D engineers working day in day out on researching and developing better and new formulas.

The new 5-story high project with a floor area of over 3000 m<sup>2</sup> represents an investment of € 10 million.

In 2013 McCoy Soudal has opened the first sealant R&D center in India (Bawal) which will be further expanded in the years to come to continuously further improve our products to the extreme Indian climate condition.



State-of-the-art laboratories



R&D team



McCoy Soudal R&D center since January 2013



# Product application guide

## Soudal sealants application matrix

<b>Bonding applications:</b>			
Substrate 1	Substrate 2	Soudaflex Polyurethanes	Soudaseal MS/Hybrid Polymers
<b>GLASS to</b>	FRP - GI - MS - ALU - SS	Soudaflex 280 (600ml)	Soudaseal 665 (600ml)*
<b>FRP to</b>	FRP - ALU - GI - MS - SS - PLYWOOD	Soudaflex 621 (600ml)	Soudaseal 660 (600ml), Soudaseal 665 (600ml)
<b>ALU to</b>	FRP - ALU - GI - MS - SS - PLYWOOD	Soudaflex 621 (600ml)	Soudaseal 660 (600ml), Soudaseal 665 (600ml)
<b>GI to</b>	FRP - ALU - GI - MS - SS - PLYWOOD	Soudaflex 621 (600ml)	Soudaseal 660 (600ml), Soudaseal 665 (600ml)
<b>MS to</b>	FRP - ALU - GI - MS - SS - PLYWOOD	Soudaflex 621 (600ml)	Soudaseal 660 (600ml), Soudaseal 665 (600ml)
<b>SS to</b>	FRP - ALU - GI - MS - SS - PLYWOOD	Soudaflex 621 (600ml)	Soudaseal 660 (600ml), Soudaseal 665 (600ml)
<b>PLYWOOD to</b>	FRP - ALU - GI - MS - SS - PLYWOOD	Soudaflex 621 (600ml)	Soudaseal 660 (600ml), Soudaseal 665 (600ml)
<b>CLEAR GLASS to</b>	FRP - GI - MS - ALU - SS	Fix ALL High Tack & Fix ALL Crystal	

<b>Sealing applications:</b>			
Substrate 1	Substrate 2	Soudaflex Polyurethanes	Soudaseal MS/Hybrid Polymers
<b>GLASS to</b>	FRP - GI - MS - ALU - SS	Soudaflex 621 (600ml)	Soudaseal 665 (600ml)*
<b>FRP to</b>	FRP - ALU - GI - MS - SS - PLYWOOD	-	Soudaseal 660 (600ml), Soudaseal 665 (600ml)
<b>ALU to</b>	FRP - ALU - GI - MS - SS - PLYWOOD	Soudaflex 621 (600ml)	Soudaseal 660 (600ml), Soudaseal 665 (600ml)
<b>GI to</b>	FRP - ALU - GI - MS - SS - PLYWOOD	Soudaflex 621 (600ml)	Soudaseal 660 (600ml), Soudaseal 665 (600ml)
<b>MS to</b>	FRP - ALU - GI - MS - SS - PLYWOOD	Soudaflex 621 (600ml)	Soudaseal 660 (600ml), Soudaseal 665 (600ml)
<b>SS to</b>	FRP - ALU - GI - MS - SS - PLYWOOD	Soudaflex 621 (600ml)	Soudaseal 660 (600ml), Soudaseal 665 (600ml)
<b>PLYWOOD to</b>	FRP - ALU - GI - MS - SS - PLYWOOD	Soudaflex 621 (600ml)	Soudaseal 660 (600ml), Soudaseal 665 (600ml)
<b>VINYL to</b>	FRP - ALU - GI - MS - SS - PLYWOOD	Soudaflex 621 (600ml)	Soudaseal 660 (600ml), Soudaseal 665 (600ml)

**ALU:** Aluminium

**FRP:** Fibre Reinforced Plastic

**GI :** Galvanized Iron

**MS:** Mild Steel

**SS:** Stainless Steel

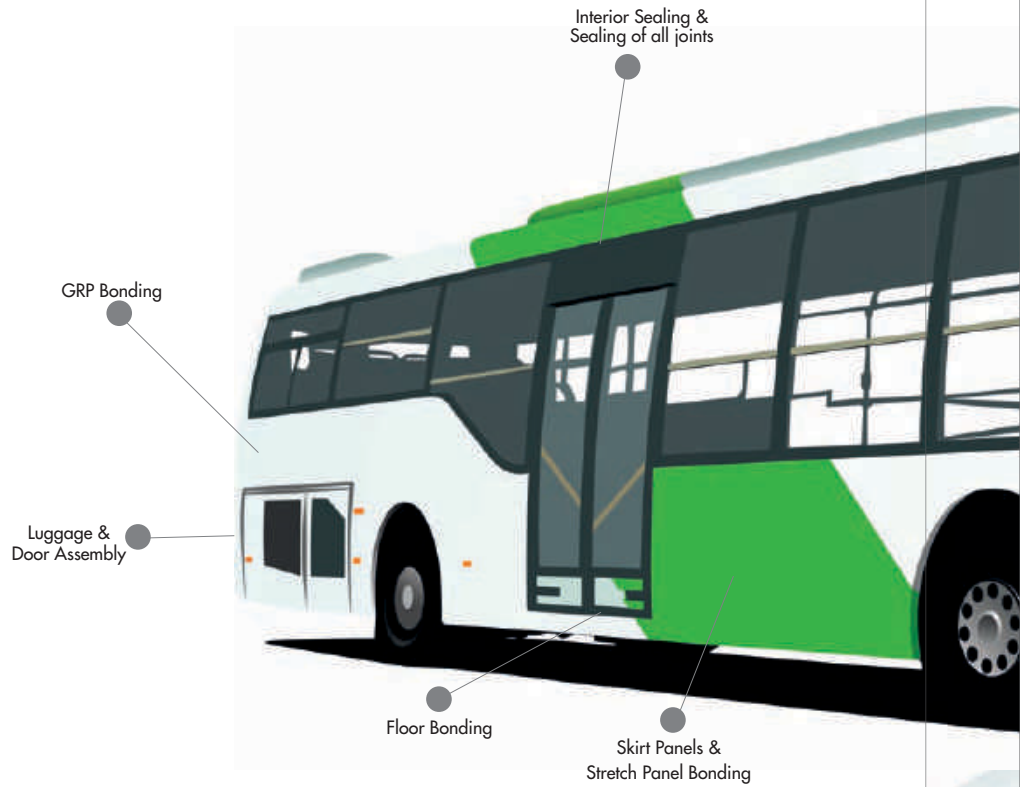
\*Recommend to use up to 15 Kg. weight of glass.  
For glass weight more than 15 Kg. Soudaflex 280 along with primer.

\*Recommend to use of primer depend upon the type of substrates.  
For more information please contact our technical department.

**Disclaimer:** 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. In every case it is recommended to carry out preliminary experiments.

# Bus & coach application

Adhesives and sealants for direct glazing and panel bonding



## Panel bonding

**Recommended product:**  
Soudaflex 621, Soudaseal 665\*



## Floor bonding

**Recommended product:**  
Soudaflex 621, Soudaseal 665\*



## Seam sealing

**Recommended product:**  
Soudaflex 621, Soudaseal 665\*



## Structural bonding

**Recommended product:**  
Soudaflex 621, Soudaseal 665\*



## FRP bonding

**Recommended product:**  
Soudaflex 621, Soudaseal 665\*



## Roof sealing

**Recommended product:**  
Soudaflex 621, Soudaseal 665\*

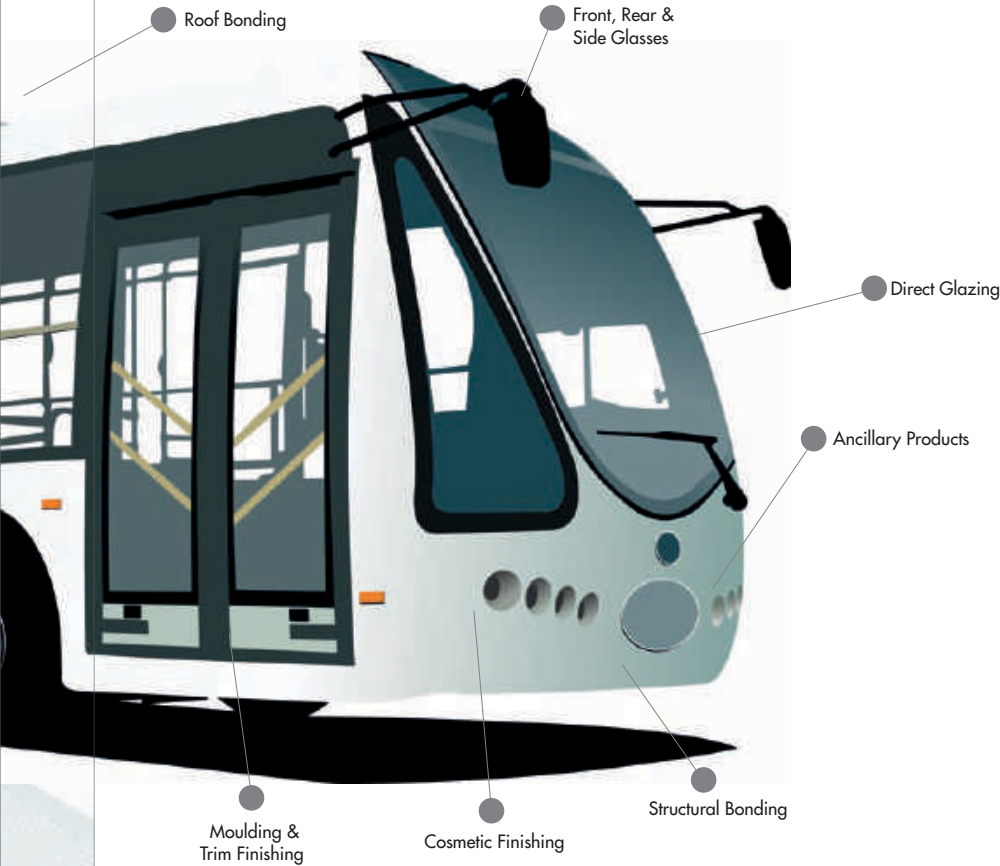


## Luggage & door assembly

**Recommended product:**  
Soudaflex 621, Soudaseal 665\*







## Wheel arch

**Recommended product:**

Soudaflex 621, Soudaseal 665\* & 660



## Cosmetic finishing

**Recommended product:**

Soudaflex 621, Soudaseal 660



## Stretch panel

**Recommended product:**

Soudaflex 621, Soudaseal 660



## Bonnet

**Recommended product:**

Soudaflex 621, Soudaseal 665\* & 660



## Trunk lid

**Recommended product:**

Soudaflex 621, Soudaseal 665\* & 660



## Skirt panel

**Recommended product:**

Soudaflex 621, Soudaseal 665\* & 660



## Fuel tank lid

**Recommended product:**

Soudaflex 621, Soudaseal 665\* & 660



## Rain channel

**Recommended product:**  
Soudaflex621, Soudaseal 660



## Wind screen

**Recommended product:**  
Soudaflex 621, Soudaflex 280



## Cab glass sealing

**Recommended product:**  
Soudaflex 621, Soudaseal 665



## Interiors

**Recommended product:**  
Soudaflex 621, Soudaseal 665



## Rear screen

**Recommended product:**  
Soudaflex 621, Soudaflex 280



## Moulding & trim finishing

**Recommended product:**  
Soudaflex621, Soudaseal 665



## Window outer sealing

**Recommended product:**  
Soudaflex 621, Soudaseal 665



## Bus AC & roof sealing

**Recommended product:**  
Soudaflex, Soudaseal 250 XF



## HVAC

**Recommended product:**  
Soudaflex 621, Soudaseal 665, Silirub IS



## Side glass

**Recommended product:**  
Soudaflex 621 & 280, Soudaseal 665



## Fire foam

**Recommended product:**  
Soudafoam FR



### Note:

- Soudaflex 621 is to be used along with Soudal Universal Primer.
- Soudaseal 665 is hybrid sealant and to be used without Soudal Universal Primer.

# Product range

## Complete sealing & bonding solutions for bus & coach

### Soudaflex 280

Soudaflex 280 has been specially developed for Indian subtropical conditions after a decade of research, practical application understanding of Indian climate, it is most suitable in high temperatures and extreme humid conditions.

- Especially designed for direct glazing of windshield and front, side and rear glasses in automotive industry.
- Suitable for cold weather application.
- Suitable for elastic structural bonding.

### Soudaflex 621

Soudaflex 621 has been specially developed for Indian subtropical conditions, it is most suitable in high temperature & extreme humid conditions.

- Especially developed for automotive and bus industry, bodywork, container applications.
- Suitable for making permanent elastic seals of high adhesive strength.
- High mechanical/dynamic stress resistance - shock/impact resistant.

### Soudaseal 265

Soudaseal 265 is a Primer-less elastic adhesive based on Silyl-Terminated Polymer specifically made for the windshield replacement after-market of inorganic and organic glass.

- Direct glazing and general structural elastic bonding adhesive.
- Quick bonding of windscreen, side and rear windows on vehicle bodies.
- Suitable for structural elastic bonding.
- Excellent weathering resistance- extremely good colour stability and UV resistance Free from.

### Soudaseal 660

Soudaseal 660 is a high quality single component adhesive-sealant with high viscosity and very high adhesive strength. It is based on MS-Polymer®, chemically neutral and fully elastic.

- Structural elastic bonding between metal surfaces, coated surfaces and many plastics (not PE, PP, Teflon).
- Structural bonding in vibrating constructions.
- Structural bonding in vibrating constructions.

### Soudal Universal Primer 175

Soudal Universal Primer 175 is a black primer which offers quick and lasting adhesion to our one component polyurethane sealants.

Soudal Universal Primer 175 is a one-step primer (on clean substrates) with a long open time: 3 days. It provides protection against UV rays if necessary.

### Soudaseal 665

Soudaseal 665 is a primerless elastic adhesive based on Silyl-Terminated Polymer specifically studied for the windshield replacement after-market of inorganic and organic glass. Formulated with a high viscosity which confer to the product an excellent high initial tack. It combines very high holding power to excellent mechanical cohesion properties.

- Suitable for direct glazing and general structural elastic bonding.
- Quick bonding of windscreen, side and rear windows on vehicle bodies.
- Excellent weathering resistance- extremely good colour stability and UV resistance Free from.

### Soudal Universal Cleaner 165

Soudal Universal Cleaner 165 is an adhesion enhancer necessary in the preparation of the glass where Soudal Universal Primer 175 will be used.



# Benefits

## Flexible engineering adhesive and sealant systems



Rail solutions

### Direct glazing

Soudal has been providing products rail, OEM and sub supplier assembly lines with adhesive/sealant solutions for direct glazing & sealing.

### Exterior component bonding & sealing

Rail vehicle manufacturers face complex and varied challenges in the design and assembly of the roof and mask systems for modern rail vehicles. High speeds, harsh environments and aerodynamic structural stresses within the vehicle have to be accommodated when selecting the correct adhesive solution.

### Interior component bonding

Modern rail vehicle interiors need high durability and service life expectancy in order to meet the day-to-day requirements of transporting large numbers of people in comfort and safety. Rail vehicle operators demand high performance and reliability from their rolling stock to reduce down time and remain competitive.

### Interior sealing and fire resistant applications

The finish and integrity of a rail vehicle is crucial to its long-term durability. A robust, watertight seal protects sensitive components such as wiring looms, vital electronic equipment and other systems situated beneath the floor and behind interior panels.

### Floor bonding

Modern rail vehicles require the use of a number of high performance flooring materials during manufacturing to ensure travelling comfort, lower vibration and better sound damping in service. Soudal has formulated a range of elastic solutions for floor bonding that enable these and other benefits to be delivered to the customer.

### Product range

- Soudaflex 621
- Soudaseal 660
- Soudaseal 665



# Automotive solutions

## Complete sealing & bonding solutions for automotive after market

Soudal has gained more than 25 years of experience in supplying the automotive aftermarket industry with adhesive and sealing systems. Based on this knowledge.

Soudal has developed product systems for the use in the automotive repair and replacement industry.

Today, we are a leading player in automotive aftermarket applications with sealing, bonding, dampening and protecting thanks to continuous innovation and listening to customer needs and requirements all over the world.

- Glass replacement specialists.
- Trust in Soudal products which are formulated to meet and/or exceed OEM requirements.
- Authorized dealer repair shops.
- Body and paint workshops.
- Maintenance and overhaul repair shops.



Automotive after market solutions



Automotive after market solutions

### Product range

- Soudaseal 265
- Soudaflex 280
- Soudal Universal Cleaner 165
- Soudal Universal Primer 175

### Soudaflex kit



Soudaflex kit



# Reliable fire retarding solutions



Fire range

## SODASEAL FR

- Fire retardant hybrid sealant
- Paintable with most coatings
- Very good elastic properties in expansion joints
- Does not require any fire retardant backing rod
- Isocyanate-solvent & silicone free

## SODAFOAM FR

- Fire retardant one-component PU foam
- Light red contoured for easy recognition
- Excellent heat & sound insulation properties
- Easy application in door frames & connection joints
- Excellent adhesion to a wide range of building materials

## FIRECRYL FR

- Water based fire retardant acrylic sealant and crack filler
- Intumescent in a fire situation
- Does not require any fire retardant backing rod
- Suitable for interior joints with low/medium movement

## FIRE SILICONE B1 FR

- Fire retardant silicone
- Very good elastic properties in expansion joints
- Does not require any fire retardant backing rod
- Excellent adhesion to a wide range of building materials
- The fire range also includes the following heat-resistant products: (HT)

## FIRECEMENT HT

Hard setting sealant for the sealing of ovens, furnaces etc. Resists temperatures of up to 150°C. Excellent adhesion to a wide range of building materials. Suitable for interior applications.

## SILIRUB HT-N

Black neutral cure silicone with high temperature resistance for the sealing and joining of a wide range of materials, which are exposed to high temperatures. Withstands temperatures of up to 280°C.

## GASKETSEAL

Red acetic cure high temperature silicone for the sealing of gaskets, hot water installations, motors, etc. Withstands temperatures of up to 285°C.

## FIRE BLANKET

Fire Blanket is a fire retardant, intumescent plasto-elastic blanket based on an acrylic dispersion. The product has a self-adhering backside.

- Resist the passage of fire & smoke
- Intumescent in contact with fire
- Stays elastic & can be painted over
- Color fast & waterproof after curing
- Very good adhesion on many porous surfaces



# Application area

## Complete industrial solutions

### Clean room & cold room

**Recommended product:**  
Silirub IS (FDA approved)



### Telecom shelter

**Recommended product:**  
Silirub PS



### Lights & lamp

**Recommended product:**  
Silirub PS, Silirub IS



### Roofing joints (PEB)

**Recommended product:**  
Silirub PS, Soudaseal 250XF & 660



### Bus & side screen

**Recommended product:**  
Powersil



### Sealing turbo bent

**Recommended product:**  
Soudaseal 250XF



### Induction cooker

**Recommended product:**  
Silirub IC



### Industry

**Recommended product:**  
General Purpose Plus, Silirub IS



# Application area

## Complete industrial solutions

### AC ducting & sealing

**Recommended product:**

Soudafoam 1K, Soudafoam PRO, FR



### Signage

**Recommended product:**

Super Bond, Fix ALL HT



### Elevator

**Recommended product:**

Soudaflex 621, Soudaseal 665, Fix ALL HT



### Fire doors

**Recommended product:**

Soudafoam FR, Fire Silicone B1 FR



### Visi cooler & coolers

**Recommended product:**

Silirub PS, Silirub IS



### Generator & transformer

**Recommended product:**

Soudaflex 621, Soudaseal 665



### Porta cabin

**Recommended product:**

Silirub PS



### De humidifier

**Recommended product:**

Silirub PS, Silirub IS



### Railway coaches

**Recommended product:**

Soudaflex 621, Soudaseal 665



### Refrigeration

**Recommended product:**

Silirub PS, Soudafoam 1K



### Commercial equipment

**Recommended product:**

Silirub PS, Silirub IS



### PU foam application

**Recommended product:**

Soudafoam 1K, Soudafoam PRO





# Silirub 2 PV silicone sealant for solar industry

High-quality neutral cure, highly elastic one-component joint sealant based on silicones. Ideal for expansion, perimeter, connection & movement joints between various building materials.

**Resistant against UV-radiation, rain, frost, wind, ozone and extreme temperatures.**

## Silirub 2 PV:

Silirub 2 PV is a high-quality neutral cure, highly elastic one-component joint sealant based on silicones. It has been developed for weather sealing of expansion joints in the façade industry.

### Benefits:

- Weatherseal in frame bonding and junction box bonding.
- Ideal for expansion, perimeter, connection and other movement joints between various building materials.
- Compatible with double glazed window units.
- Resistant against UV-radiation, rain, frost, wind, ozone and extreme temperatures.

- Excellent adhesion properties on glass, laminated glass, coated aluminium, galvanised steel, aluminium composite panels (ACP), stones, concrete and masonry.
- Permanent colors, UV-resistant.
- Low modulus according to ISO standards.
- Stays elastic after curing.



Solar wind mill application



Junction box bonding & sealing



Frame to module bonding & sealing



Encapsulation



# Product range

## Complete sealing & bonding solutions for Industry

### Silirub IS

Silirub IS is a high performance neutral cure silicone sealant with outstanding adhesive/sealing properties for most of the industrial critical applications.

- Excellent UV resistance
- Sealing of solar panels & junction boxes

### Powersil

Powersil is a high quality elastic one-component acetoxy silicone sealant.

- Excellent UV resistance
- Suitable for both interior and exterior applications

### Silirub PS

Silirub PS is a high performance neutral cure silicone. Telecom shelters, uPVC & aluminum door & window frames, ACP, glass, brick, concrete, wood.

- UV & weather resistance
- Excellent adhesion (uPVC, wood, aluminium, metal, concrete)

### General Purpose Plus

General Purpose Plus is a high quality elastic one-component acetoxy silicone sealant.

- Excellent UV resistance
- Suitable for both interior and exterior applications

### Fire Silicones B1 FR

Fire silicone B1 FR is a high quality, neutral, elastic, one-component sealant.

- Fire retardant silicone
- Very good elastic properties in expansion joints

### Soudafoam PRO

Soudafoam PRO is a one-component, self-expanding, ready to use polyurethane foam.

- Excellent adhesion on most substrates such as concrete, wood, PVC, Aluminum, (except PE, PP & Teflon)
- High thermal & acoustical insulation

### Soudafoam 1K

Soudafoam 1K is a one-component, self-expanding, ready to use polyurethane foam with CFC-free propellants, which are completely harmless to the ozone layer.

- Excellent adhesion on most substrates (except Teflon, PE & PP)
- High thermal & acoustical insulation

### Soudafoam FR

Soudafoam FR is a single-component, self-expanding, ready to use polyurethane foam with propellants which are completely harmless to the ozone layer.

- Excellent heat & sound insulation properties
- Easy application in door frames & connection joints

### Super Bond

Super Bond is a solvented instant grab, high strength construction adhesive based on synthetic rubbers.

- High bond strength & good initial grab
- Replaces nails & screws

### Fix ALL High Tack

Fix ALL HT is a high quality adhesive & sealant with high strength and initial tack based on MS-Polymer®.

- Fast curing, quick build-up of end strength, high shear strength
- Paintable with all water based paints

### Soudaseal 250XF

Soudaseal 250XF is high quality, neutral, one-component adhesive / sealant with a high initial tack based on MS-Polymer® technology.

- High green strength, quick build-up of end strength, high shear strength after full cure
- Flexible elastic rubber – movement accommodation up to 20%





Experts in Sealants, Adhesives & PU Foams  
www.mccoysoudal.com

SILIRUB		PS	WSL+	AP	IS	B&K	Color
①	White		●				
②	Brilliant White	●		●	●	●	
③	Transparent	●		●	●	●	
④	Ivory						●
⑤	Grey (RAL 7047)						●
⑥	Grey		●				
⑦	Black	●	●	●			
⑧	Brown (RAL 8017)						●
⑨	Brown (RAL 8007)						●

\*Other colours available on request and subject to minimum order quantities (COL-005)

# Wide range of products

Experts in sealants, adhesives & foams



**Product available in more than 120 countries**  
 For more information kindly log on [www.mccoysoudal.com](http://www.mccoysoudal.com) | [www.soudal.com](http://www.soudal.com)

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