

## TECHNICAL DATASHEET

# PENOSIL Premium StyroFix 615

The polyacrylate-dispersion-based ready-to-use solvent-free adhesive. Can be used for bonding various materials such as, for example, polystyrene, wood, unpolished stone, concrete, gypsum plasterboards, ceramics, silicates, bricks, and so on.

Can be used on moist surfaces, however, a possibility for quick drying should be established. Cured sealant is UV and moisture proof.

### Field of applications

Can be used to bond and fasten polystyrene mouldings, moulds and insulation materials, panels etc.; also, for filling cracks in gypsum plasterboards and holes in panels, etc.

Elements will have a rigid connection, which is why the adhesion is not suitable for moving connections. Not suitable for surfaces in permanent contact with water, also not for underwater application.

### Application conditions

Application temperature between +5 °C and +35 °C.

During the curing process of the adhesive, humidity is released. Therefore, rooms should be sufficiently ventilated to reduce the humidity. The curing process may be retarded when both surfaces in contact are not porous.

### Application instructions

The surfaces must be clean from dust, loose particles and oil.

Cut off the threaded end of the cartridge and screw on the application nozzle for directing adhesive. Cut the threaded end in a way where a suitable opening for application is produced. Place the cartridge together with the applicator in the gun and fill the installation nozzle with adhesive, by repeatedly pressing the gun trigger.

Apply the adhesive to the surface to be connected and immediately press to the substrate. When gluing heavy plates, apply adhesive on both surfaces and use a trowel similar to the one used for applying tile adhesive. Press the surfaces together and support them before the adhesive starts to cure. Lighter elements should be supported for 2–3 hours, heavy and hanging elements until final curing (curing speed 2,5 mm/24h). Protect the adhesive against moisture and ensure a good ventilation during the curing period. To cover larger surfaces, use a notched trowel with tines of 4–5 mm. Adhesive consumption at a rate of about 2–4 m<sup>2</sup>/kg. After curing, the adhesive may be painted with acrylic paints.

### Cleaning

Use Penosil Premium Cleaning Wipes or solvents such as acetone or white spirit for removing uncured adhesive. Cured adhesive should be removed mechanically.

### Technical data

Properties	Unit	Value
Application time	minute	1–2
Curing time	hour	24
Density (DIN 53 479-B)	g/cm <sup>3</sup>	1,69
<b>Properties of cured sealant</b>		
Hardness (Shore A)		40±2
Temperature resistance after curing	°C	-30 up to +70

The parameters indicated have been measured at +23 °C and 50% relative air humidity.

## Colour

White.

## Package

280 ml cartridge, 12 pcs in a box.  
1 kg, 3 kg and 10 kg plastic bucket.

## Storage conditions

Guaranteed storage time 12 months starting from the date of manufacture if stored in a closed original package in a dry place between +5 °C and +30 °C, avoid freezing.  
Short-term resistance to freezing, max 10 days at temperatures over -18 °C. Freeze-thaw resistance 5 cycles at temperatures -18 °C and +23 °C, one cycle lasting 48 hours (24 hours at -18 °C and 24 hours at +23 °C).

## Waste treatment

Completely empty the package and dispose according to requirements.

## Safety regulations

Ensure sufficient ventilation during application. Keep out of the reach of children. Avoid contact with skin and eyes. In case of contact with eyes, rinse immediately with water and seek medical advice. Detailed safety information is available on safety data sheet (SDS).

Note: The instructions in the present documentation are based on tests carried out by the manufacturer and are presented in good faith. Due to variations in materials and substrates as well as the various application possibilities that are beyond our control, the manufacturer is not liable for the results achieved. In any case, it is recommended to test the product suitability at the place of application.