

## TECHNICAL DATA SHEET

# PENOSIL SpeedFix Crystal 799

General-purpose one-component elastic adhesive for indoor and outdoor applications. Based on hybrid technology.

- Transparent adhesive.
- Can be used on moist substrates.
- Does not cause corrosion on metals.
- UV- and weather resistant.
- Paintable.
- Does not shrink during the curing process.
- Does not contain harmful components.
- Great adherence on most building materials.

### Fields of application

- Suitable for gluing and sealing indoors and outdoors.
- Construction adhesive with high adhesion power is used for gluing in places which require extra strong bond.
- Adheres well to most construction materials.
- Panel bonding for caravans, motor homes, commercial vehicles.
- The gluing and sealing mass have good vibration and noise-suppressing properties.

### Adhering

Adheres well to concrete, masonry, ceramics, wood, aluminium, galvanized steel, polycarbonate, glass.

### Application instructions

#### Application conditions

Application temperature between +5°C and +40°C.

#### Surface preparation

The surfaces must be dry, clean from dust, loose particles and oil. Non-porous surfaces should be cleaned with solvent and a clean, non-fluffy cotton cloth. Solvent excess should be removed before evaporating with a clean cloth.

#### Application method

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. Support until product is fully cured. Protect the adhesive against moisture and ensure a good ventilation during the curing period.

#### Cleaning

Clean the uncured adhesive with solvent such as acetone or use PENOSIL Cleaning Wipes. Cured adhesive can only be removed mechanically.

## Technical data

Properties	Value	Unit
Basis	Hybrid	
Consistency	Paste	
Density (DIN 53 479-B)	1,05	g/ml
Open time	10	min
Curing rate	2...3	mm/24h
Application temperature	+5...+40	°C
Service temperature	-40...+80	°C
Shelf life	12	months
Shore A hardness (ISO 868)	50	
<b>Properties of cured sealant</b>		
E-Modulus 100% (ISO 8339)	1	N/mm <sup>2</sup>
Tensile strength (ISO 8339)	1	N/mm <sup>2</sup>
Elongation at break (ISO 8339)	60	%
E-Modulus 100% (ISO 37)	1	N/mm <sup>2</sup>
Tensile strength (ISO 37)	2,5	N/mm <sup>2</sup>
Elongation at break (ISO 37)	270	%
Cured adhesive shear strength (WGM214)	43	kg/cm <sup>2</sup>
Cured adhesive tensile strength (WGM214)	13	kg/cm <sup>2</sup>

The values specified were obtained at +23 °C and 50% relative humidity, unless otherwise specified. These values may vary depending on environmental factors such as temperature, moisture and type of substrates.

## Technical classification and certificates

- EMICODE® EC 1 Plus - very low emission

## Colour

Transparent

## Package

290 ml cartridge, 12 pcs in a box.

400 ml foil package, 28 pcs in a box.

600 ml foil package, 20 pcs in a box.

## Storage conditions and shelf life

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.

## Limitations

- Do not use for sealing aquariums and underwater joints.
- Test before using on natural stone.
- There is no adhesion to PE, PP, PTFE (Teflon®).
- Due to the wide variety of possible substrates, we recommend a preliminary compatibility test.

## Safety regulations

Ensure sufficient ventilation during application and wear necessary personal protective equipment. More specific safety information is available on the 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. Manufacturer reserves the right to modify products without prior notice. This TDS replaces and supersedes all previous data sheets on the same product.