

TECHNICAL DATA SHEET

PENOSIL StyroFix 615

Solvent-free ready to use adhesive based on polyacrylate dispersion for indoor application.

- Excellent adhesion to a wide range of materials.
- Low odour.
- Solvent free.
- Paintable (test previously).
- UV and moisture proof.

Fields of application

- Suitable for bonding different construction materials.
- Mounting wooden construction elements.
- Wooden-, plaster and decorative panels by strengthening screw connections and reducing screw usage.
- Installation of carpentry elements
- door and floor fillets.
- Adhesion of plaster decorations and decorative panels.

Adhering

Adheres well to polystyrene, wood, unpolished stone, concrete, gypsum plasterboards, ceramics, masonry, paper, cardboard.

Application instructions

Application conditions

Application temperature between +5 °C and +30 °C.

During the curing process of the adhesive, humidity is released. Therefore, rooms should be sufficiently ventilated to reduce the humidity. Curing may slow down when the connected surfaces are non-porous.

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 water or use PENOSIL Cleaning Wipes. Cured adhesive should be removed mechanically.

Technical data

Properties	Value	Unit
Basis	Acrylic	
Consistency	Paste	
Density (DIN 53 479-B)	1,69	g/ml
Open time	2...3	min
Curing rate	2...3	mm/24h
Application temperature	+5...+30	°C
Service temperature	-30...+70	°C
Shelf life	12	months
Shore A hardness (ISO 868)	40	
Properties of cured sealant		
Tensile strength (ISO 37)	2,6	N/mm ²
Elongation at break (ISO 37)	40	%
Cured adhesive shear strength (WGM214)	32	kg/cm ²
Cured adhesive tensile strength (WGM214)	8	kg/cm ²

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.

Colour

White

Package

280 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. Avoid freezing.

Short-term cold resistance 10 days at temperatures -18 °C...0 °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).

Limitations

- Not suitable for surfaces in permanent contact with water.
- There is no adhesion to PE, PP, PTFE (Teflon®).
- Elements will have a rigid connection, which is why the adhesion is not suitable for moving connections.
- 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.