

## TECHNICAL DATA SHEET

**PENOSIL SpeedFix Duragrip 617**

## Multipurpose acrylic adhesive

High strength water-based one-component construction adhesive, which minimizes the need for nails and screws in many interior applications. It provides high-strength bonds for a wide variety of construction materials. At least one surface must be porous.

**Main benefits**

- Water based and solvent free. Low odor.
- Fast grab and strong bonding.
- It is long lasting and moisture resistant.
- Adheres well to most construction and finishing materials.
- Elastic.
- Fills irregularities on uneven surfaces.
- Easy to use and faster to clean up.
- Paintable and sandable when dry.

**Fields of application**

- Installation of wood and plaster board panels, reinforcement of screw joints and reducing of the number of screws needed.
- Up on finishing works, for the installation of door and floor moldings and various decorative details.
- For quick repair jobs.

**Colour**

White.

**Package**

300 ml cartridge, 24 pcs in a box.

**Storage conditions and shelf life**

Guaranteed shelf life 18 months from the manufacturing date when stored in closed original package in a dry place and protected from direct sunlight at temperatures between +5 °C and +25 °C.

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## Adhering

- Wood
- Drywall
- Concrete
- Cement
- Masonry
- Stones
- Cork
- Glass
- Ceramics
- Metals
- Carpet
- Polystyrene foam boards

## Technical classifications and certificates

- French VOC-emission class A+

## Technical data

Properties	Value	Unit
Basis	Acrylic	
Consistency	Non-Slump paste	
Density (DIN 53 479-B)	1,55	g/ml
Open time	10...15	min
Application temperature	+10...+35	°C
Service temperature	-20...+80	°C
Shore A hardness (ISO 868)	60	
Tensile strength (ISO 37)	1,1	N/mm <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.

## Application instructions

### Application conditions

Application temperature between +10 °C and +35 °C.

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## Surface preparation

Substrates must be clean, dry, and free of dust, grease and other contaminant which may affect the adhesion. We also recommend sanding painted and varnished surfaces. Use organic solvents (alcohol or MEK) to remove all contaminants. Never use soaps, detergents or water. Porous substrates must be mechanically cleaned from loose particles.

## Application method

Cartridge: cut off the threaded end of the cartridge and screw on the application nozzle for directing product. 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 product, by repeatedly pressing the gun trigger.

Cut the nozzle to create a suitable opening for dosing adhesive.

Apply adhesive along the length of one of the surfaces to be bonded. On broad flat surfaces apply beads every 10 - 20 cm.

Bring surfaces together as soon as possible (within the first 5 minutes), and press firmly.

Materials should be glued together within 60 minutes of adhesive application.

Allow the adhesive to dry (at least 24 hours) before removing any temporary fasteners or clamping. The time it takes to form a strong bond depends on temperature, humidity, porosity of substrate and amount of adhesive applied.

## Cleaning

Uncured acrylic can be removed with water or with PENOSIL Cleaning Wipes. Cured acrylic should be first removed mechanically and then with a moist cloth.

## Limitations

- Do not apply at temperatures below +10 °C.
- Not recommended for continuously wet areas or water immersion.
- Not recommended for bonding two non-porous surfaces.
- Not suitable for use on mirrors, polyethylene, polypropylene, PTFE and bituminous surfaces. Previous compatibility and adhesion tests are recommended.
- Please observe the expiration date!

## 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.

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