

## TECHNICAL DATA SHEET

# PENOSIL Acrylic 671

It is a one-component sealant, based on acrylic emulsions which, in contact with atmospheric humidity, forms an elastic joint.

Preserves all properties of elasticity and adherence with no ageing problems, remaining stable in front of atmospheric agents.

- Water based
- Low odour
- Adhesion to most common building substrates
- High flexibility
- Compatible with paints
- Non-corrosive
- Easy tooling
- Wash-up with water
- Extremely long service life
- Low VOC emission

### Fields of application

- Perimeter and connection joints for wood and PVC carpentry
- Sealing between porous and non-porous substrates including concrete, masonry, PVC and many other synthetic substrates
- Caulking joints in interior carpentry
- Sealing of joints between prefabricated elements
- Finishing joints between skirting/wall, doorframe/wall, stair/wall, ...

### Adhering

- Wood
- PVC
- Concrete
- Masonry
- Bricks
- Plasterboard
- Ceramic
- Treated metals

### Application instructions

#### Application conditions

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

#### Surface preparation

Substrates (joint flanks) must be clean, dry, and free of dust, grease and other contaminant which may affect the adhesion. Non-porous surfaces (such as aluminium, glass, etc.) should be cleaned with a suitable solvent and thoroughly dried with a clean cloth. Porous substrates (such as concrete, brickwork, etc.) must be mechanically cleaned from loose particles. Mask off the joint edges.

#### Application method

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

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

Apply sealant in the joint by repeatedly and evenly pressing on gun trigger and smoothly dragging the nozzle along the joint.

After application, smooth the surface with a suitable tool (e.g., spatula) and remove excess material. The joint should be tooled and smoothed before skin formation, ensuring good contact with the surface to seal. Remove masking tape.

Paintable after the final curing. Early painting can cause cracking of the paint.

It is strongly recommended to cover cured caulk with a suitable paint to guarantee its longevity and similar colour shade with the background surface.

### Cleaning

Uncured acrylic can be removed with water or with special cleaning wipes.

Cured acrylic should be first removed mechanically and then with a moist cloth.

### Technical data

Properties	Value	Unit
Basis	Acrylic	
Consistency	Non-slump paste	
Density (DIN 53 479-B)	1,63	g/ml
Tack free time	5...10	min
Skin forming time	30...40	min
Curing rate	2	mm/24h
Resistance to flow (ISO 7390)	0	mm
Application temperature	+5...+35	°C
Service temperature	-20...+80	°C
Movement capability (ISO 11600)	7,5	%
Shore A hardness (ISO 868)	20	
<b>Properties of cured sealant</b>		
E-Modulus 100% (EN ISO 8339)	>0,25	N/mm <sup>2</sup>
Tensile strength (EN ISO 8339)	0,3	N/mm <sup>2</sup>
Elongation at break (EN ISO 8339)	450	%

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

Sealant for façade for interior and exterior application  
EN 15651-1:2012: Type F-EXT-INT CLASS: 7,5P

SNJF certified (Façade) category F 7,5P  
Façade n° 4249

French VOC-emission class A+

### Colour

White.

### Package

300 ml cartridge, 12 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 at temperatures between +5 °C and +25 °C.

### Limitations

- Fresh product must be protected from water and continuous exposure to moisture, until a solid skin has formed.
- The product cures by means of desiccation (water evaporation). High humidity, low temperatures and high joint depth can delay skin formation and curing significantly.
- During drying, the colour will slightly change.
- The product is compatible with most paint systems. Due to the large number of paints and varnishes available, we strongly suggest a compatibility test before application.
- It should not be applied on bituminous or tar containing substrates, and to materials that bleed oils or plasticizers.
- It must not be used in contact with untreated metals (oxidation risk).
- 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.