PENOSIL
We save energy / Wolf Group

www.penosil.com

Wolf Group Head Office
Suur-Paala 10
13619 Tallinn
Estonia

tel +372 605 9300
fax +372 605 9315
info@penosil.com

TECHNICAL DATA SHEET

PENOSIL SpeedFix High Tack Crystal 717

PENOSIL SpeedFix High Tack Crystal 717 is a powerful one component elastic adhesive with instant grip and a high level of ultimate performance. An extra strong, high strength adhesive that quickly reaches its ultimate performance level and is ideal for numerous bonding.

Main benefits

- Transparent adhesive
- Can be used on moist substrates
- Does not cause corrosion on metals
- Does not shrink during the curing process

Fields of application

- Elastic adhesive for numerous applications in construction, such as fixing panels, profiles, skirting boards, insulation panels, windowsills, frames, rooftiles, etc.
- Any type of high-strength bonding with flexibility in industry.
- Quick and non-rigid bonding in structures subject to vibrations that require strong bonding (car bodies, containers, metal-to-metal bonding, etc).
- Panelling on trailers, motorhomes, commercial vehicles, etc.
- Bonding applications in the shipping industry.
- Smooth aspect.
- No residual tack.

Adhering

Adheres well to most building materials, such as glass, lacquered aluminium, wood, ceramics, etc.

Application instructions

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

Surface preparation
The surfaces must be dry, clean from polishes, dust, loose particles, grease and other contaminants that may affect adhesion. It is recommended that the substrates are preferably dry or slightly damp, but not wet. Painted surfaces must be fully cured with no flaking paint. If necessary, fill all holes and irregularities in the substrate to achieve a substrate as flat as possible.

Priming: SpeedFix High Tack Crystal 717 adheres on most of common substrates such as glass, lacquered aluminium, wood, ceramics, etc.
It will be recommended to proceed to an adhesion test before to start any bonding process. It could happen, that some substrates will need to be primed to obtain better adhesion results.

Application method
After preparing the substrate, apply the adhesive uniformly with an application gun. Observe the open time of any possible primer used, before applying the adhesive. 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 in strips or small dots every few centimetres on the surface to be joined. Immediately put the surfaces together in the required position and press firmly.

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If necessary, use adhesive tape, blocks or other accessories to hold the assembled elements during the first hours of curing. An incorrectly positioned element can be easily detached and repositioned in the first few minutes after the application. Reapply pressure.

Cleaning
Uncured product can easily be removed with alcohol. Cured adhesive must be removed mechanically.

Technical data

Properties	Value	Unit
Viscosity	Thixotropic paste	
Basis	Hybrid polymer	
Density (ISO2811-1)	1,01	g/cm^3
Skin forming time (WGM 226)	10	min
Curing rate (WGM 207)	2…3	mm/24h
Resistance to flow at +5 °C (ISO 7390)	0	mm
Resistance to flow at +50 °C (ISO 7390)	0	mm
Application temperature	+5…+40	°C
Service temperature	-40…+90	°C
Initial grab (ad-hoc internal test)	588	g
Shore A hardness (ISO 868)	61	
E-Modulus 100% (ISO 37)	1,88	N/mm²
Tensile strength (ISO 37)	4,87	N/mm²
Elongation at break (ISO 37)	304	%

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

Transparent, slightly cloudy.

Package

290 ml cartridge, 12 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 cool and dry place, protected from direct sunlight and at temperatures between +5 °C and +25 °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).