

## TECHNICAL DATA SHEET

# PENOSIL SpeedFix Hybrid Adhesive 726

PENOSIL SpeedFix Hybrid Adhesive 726 is an adhesive with single-sided application use for porous and non-porous surfaces. The adhesive hardens to a water-resistant, solvent-resistant and semi-rigid adhesive film when exposed to humidity (from the air or materials being bonded). The cross-linking process can be accelerated by means of targeted moisture supply (in the form of a fogging system) or by higher temperatures (+40 °C up to max. +80 °C). Final setting time of the bonded parts is possible after approximately 1-2 hours, final strength is achieved after approximately 24 hours.

### Main benefits

- Fast and bubble-free curing
- UV and weather resistant
- Paintable (Due to the variety of paints and coating systems available on the market, preliminary tests are necessary.)

### Fields of application

- Can be used in the production of wall elements and other nonloadbearing structures made of wood and wooden materials.
- Manufacture of wood products that are exposed to the weather, such as windows, doors, fence elements and terrace components, each with a suitable surface protection.
- Adhesion of wooden products and elements that are subject to high loads or are temporarily exposed to increased moisture, such as Parquet flooring, sauna and bathroom furniture.
- Bonding of mineral building boards, ceramic and concrete materials and hard foams.

### Adhering

Due to the large number of different materials and process-related influencing factors for the respective user, the values can vary within a certain range. If necessary, they are to be adapted accordingly by the user and checked independently regarding suitability.

### Application instructions

#### Application conditions

Application temperature (applies to environment and substrates): +5 °C to +30 °C. All substrates must be solid, clean, dry, and free from grease and dust.

Remove loose particles from surfaces. Always test adhesion prior to application. For proper curing one of the substrates must be 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

The application can be done with brush, roller, spatula or directly from the bottle. The substrates to be bonded have to be tempered to at least 18 °C room temperature. For wood-based materials the material moisture shouldn't be below 5 %. Remove release agent from the substrates to be bonded if present. For large-area bonding, at least one substrate must have sufficiently permeable properties (e.g. solid wood, wood-based material, EPS, concrete or masonry).

## Cleaning

Uncured material and tools can be cleaned by using PENOSIL Foam Cleaner. Cured material can only be mechanically removed. Hands can be cleaned with PENOSIL Cleaning Wipes.

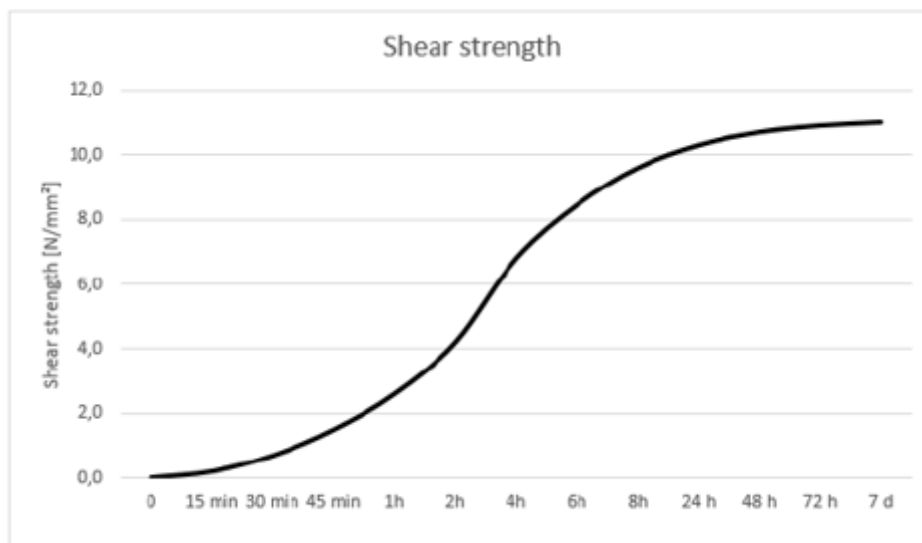
## Technical data

Properties	Value	Unit
Coverage	100...200	g/m <sup>2</sup>
Basis	STP monocomponent	
Density (DIN 53 479-B)	1,5	g/ml
Open time	8	min
Press time at 20 °C	90	min
Press time at 40 °C	60	min
Press time at 60 °C	45	min
Press time at 80 °C	30	min
Application temperature	+5...+30	°C
Service temperature	0...+80	°C
Viscosity Brookfield RVT at 6,8 s	10500	mPa·s

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.

## Shear strength (DIN EN 204/205)

Orientation for a 0,1 mm thick adhesive joint between to beech wood test specimens at 23 °C and 50 % relative humidity.



## Paintability

Paintable. (Due to the variety of paints and coating systems available on the market, preliminary tests are necessary.)

## Technical classification and certificates

- EMICODE® EC 1 Plus - very low emission
- Bond quality D4 according to DIN EN 204

## Colour

Beige.

## Package

500ml plastic bottles, 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 airtight package in a cool and dry place at approx. +20 °C. Carefully protect from humidity. Opened packages should be used up as soon as possible. PENOSIL Speedfix Hybrid Adhesive 726 is not frost sensitive at temperatures above -25 °C.

## Limitations

- Do not process below +5°C.
- The following information is based on experience and is to be understood as an indication.

## 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.