

TECHNICAL DATA SHEET

PENOSIL SpeedFix ThermoProfile 728

PENOSIL SpeedFix ThermoProfile 728 is a one-part elastic adhesive with immediate grab and high strength, which quickly reaches the final performance, based on MS polymer technology.

An extra strong, high-strength adhesive that quickly reaches its ultimate performance level and is ideal for numerous bonding and sealing applications indoors and outside.

With neutral and odourless curing, PENOSIL SpeedFix ThermoProfile 728 meets health requirements and is environmentally friendly.

Main benefits

- Very strong and instant initial grip, in 3 seconds.
- Rapid curing, in about 15 minutes.
- High ultimate strength.
- Elastic and durable bonding.
- Multi-material. Excellent primerless adhesion to a wide range of porous and non-porous materials.
- Excellent resistance to UV-rays, weather and ageing.
- Good chemical resistance.
- Silicone-, isocyanate- and solvent-free.
- Non-corrosive.
- Absorbs impacts and vibrations.
- Easy to apply. For interior and exterior applications.
- Can be applied on wet surfaces.
- Paintable (prior test required).

Fields of application

- Elastic adhesive for numerous applications in construction, such as panels' fixing, profiles, skirting boards, thermo profiles, 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.

Adhering

Adheres well to most common construction materials without primer, such as:

- Concrete
- Cement
- Bricks
- Natural or artificial stone
- Ceramic tiles
- Roof tiles
- Gypsum
- Metals
- Wood
- PVC and plastics
- Polystyrene
- Glass, 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 that is as flat as possible.

PENOSIL SpeedFix ThermoProfile 728 adheres to most of common unprimed construction materials. However, it is recommended to verify the adhesion on each specific substrate beforehand. Sometimes, it may be necessary to treat the surfaces with a primer first, to obtain better adhesion results. If needed, please contact us for technical assistance.

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.

Cartridge: 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.

Foil package: open the end of the foil pack and place the pack inside the gun so that the dosing nozzle keeps covering its open portion. Place the dosing nozzle on the open end and screw on the cap to close the tube. Cut the nozzle to create a suitable opening for dosing sealant. 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.

If necessary, use adhesive tape, blocks or other accessories to hold the assembled element 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.

The product cures fast, the elements are fixed in 15 minutes. The ultimate performance is obtained after 24 hours.

Cleaning

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

Technical data

Properties	Value	Unit
Basis	Hybrid polymer	
Consistency	Non-slump paste	
Density (ISO 2811-1)	~ 1,50	g/ml
Skin forming time (WGM 226)	~ 14	min
Curing rate (WGM 207)	2...3	mm/24h
Resistance to flow +5 °C (ISO 7390)	0	mm
Resistance to flow +50 °C (ISO 7390)	0	mm
Application temperature	+5...+40	°C
Service temperature	-40...+90	°C
Shore A hardness (ISO 868)	60...70	
E-Modulus 100% (ISO 37)	2,8	N/mm ²
Tensile strength (ISO 37)	3,2	N/mm ²
Elongation at break (ISO 37)	>180	%

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

- EMICODE® EC 1 Plus - very low emission
- French A+ - low emission

Colour

Black, white.

Package

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

Limitations

- Do not use as a glazing sealant, on bituminous substrates or on building materials which might bleed oils, plasticizers or solvents (for example, natural rubber, chloroprene, EPDM, etc).
- There is no adhesion to PE, PP, PTFE(Teflon®) or silicone.
- Due to the wide variety of possible substrates, we recommend a preliminary compatibility test.
- Due to the large number of paints and varnishes available we strongly suggest a compatibility test before application.

Safety regulations

Ensure sufficient ventilation during application and wear necessary personal protective equipment. Avoid contact with skin and eyes. Keep out of the reach of children

More specific safety information is available on the safety data sheet (SDS). Before using the product, we advise you to carefully read the SDS and the safety labels on the packaging.

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.