

Hydewa FIX

Special Adhesive



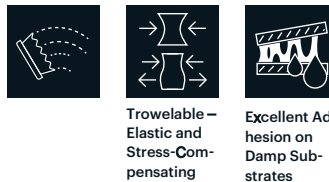
Technical Data Sheet

Version: 02-2025



Tests:

- EMI CODE EC1PLUS – “very low emission”
- Meets French VOC requirements, Class A+
- Suitable for use in food-processing areas



Trowelable –
Elastic and
Stress-Compensating

Excellent Adhesion on
Damp Substrates

1. Technical Data

Base	Hybrid adhesive – silane-terminated polymers
Skin formation time	~ 16 Min. (23°C/50%RLF)
Curing rate	~ 1,4 mm/24 h (at +23°C/50%RLF)
Density	~ 1,5 (EN ISO 1183-1)
Shore A-hardness	~ 41 (DIN EN ISO 868)
Volume shrinkage	~ 2,3% (EN ISO 10563)
Sag resistance	< 3 mm
Tear resistance	~ 9,4 N/mm (ISO 34-1)
Tensile strength	~ 1,14 N/mm ² (DIN 53504-S2)
Modulus	~ 0,69 N/mm ² (DIN 53504-S2)
Theoretical consumption (Notched trowel)	A3: ~570g (380ml)/m ² ; B2: ~780g (520ml)/m ² ; B12: ~870g (580ml)/m ²
Elongation at break	~ 200% (DIN 53504-S2)
Temperature resistance	-40°C to +90°C (continuous exposure)
Application temperature (substrate/ambient)	min. +5°C, max. +35°C
Colors	White
Packaging	Foil cartridges 600 ml & 1800 ml
Shelf life	12 months in unopened original packaging, stored cool and dry

2. Properties / Areas of Application

Hydewa FIX offers high initial tack and, thanks to its 1-component system, is immediately ready for use. Its excellent rib stability makes it ideal for application with a notched trowel. The adhesive is water- and solvent-free, causing no swelling of wood or incompatibility with solvent-sensitive materials.

Hydewa FIX remains permanently elastic, stress-compensating, trowelable, weather-resistant, non-corrosive, and free from silicone, solvents, and isocyanates. It is suitable for full-surface bonding of various materials such as wood, concrete, plaster, metal, plastic, PVC, polyester, polystyrene, etc. Key benefits include minimal shrinkage and fast curing.

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3. Substrate Preparation

The substrate must be flat, clean, load-bearing, crack-free, and tensile/compression resistant. For bonding on vapor-tight substrates, lightly moisten the surface (approx. 5–8 g/m² water) to ensure proper curing. On non-absorbent substrates, pre-cleaning is always recommended. If necessary, treat bonding surfaces with a suitable primer.

Light sanding with fine abrasive fleece can further improve adhesion on smooth surfaces.

For painted substrates, preliminary adhesion testing is strongly recommended.

Substrate *	Pretreatment
Glass	+
Tile	+
Pine wood	+
Concrete, wet ground	dust free / PR 70
Concrete, formwork smooth	dust free
Steel DC 04	+
Steel galvanized	+
Stainless steel	+
Zinc	+
Aluminium	+
Aluminium AlMg1	+
Aluminium AlCuMg1	+
Aluminium 6016	+
Aluminium anodized	+
PVC Kömadur ES	+
PVC soft	+ / PR 100
PC Makrolon Makroform 099	+
Polyacryl PMMA XT 20070 Röhm* ¹	+ / PR 40
Polystyrol PS Iroplast	+ / PR 100
ABS Metzoplast ABS 7 H	+ / PR 100
PET	+
PU (foam quality)	+ / PR 100
PMMA Röhm sanitary grade	+
FRP	+
EPDM Semperit E 9614	+

Legend: + = good adhesion without primer
 PR = Primer

***For substrates not listed in this table, preliminary tests must always be carried out by the applicator to verify the suitability of the adhesive for use.**

This table is based on adhesion tests carried out with test specimens by Rocholl GmbH under laboratory conditions. In practice, the adhesive properties depend on a wide range of external factors (such as weather conditions, contamination, etc.). Therefore, this table serves for guidance only and does not constitute a binding statement. The tests mentioned above refer solely to adhesive properties and do not provide any information regarding compatibility with the listed substrates.¹: Different types of PLEXIGLAS® show certain variations in their chemical resistance. In some applications, internal stresses may occur. These stresses can, in combination with certain agents, lead to stress cracking. The exposure time, temperature, and concentration of the acting substance have a significant influence on the formation of such cracks. When using our products in combination with PLEXIGLAS®, suitability must therefore always be verified in advance.²: Compatibility with various mirror coatings from different manufacturers is regularly tested in our laboratory. However, due to production processes beyond our control and the wide range of substrates and bonding configurations, preliminary tests are strongly recommended.

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4. Application

General Information: The expiry date of the material must be strictly observed, as otherwise the product properties can no longer be guaranteed. If the products are stored and/or transported for an extended period at elevated temperatures and humidity, this may result in a reduction of shelf life or changes to the material properties. Strong environmental influences (e.g. high temperatures, UV exposure, chemical vapors, etc.) can affect the material's performance in various ways.

Before application, the user must ensure that all building materials (solid, liquid, or gaseous) in the contact area are compatible with the adhesive. Attention must be paid to the ambient and substrate temperatures during application, as excessively high or low temperatures can alter the product properties. Due to the many possible influencing factors during processing, a trial application is always recommended before use. Ensure adequate ventilation during application and curing.

Preparation of Bonding Surfaces: Substrate preparation must be carried out in accordance with the instructions given in Section 3 of this data sheet.

Additional Application Instructions: The adhesive is optimized for a material temperature of +20°C. The viscosity of the uncured adhesive is temperature-dependent: it increases at low temperatures and decreases at high temperatures. If necessary, the adhesive should be tempered before use. No more adhesive should be applied than can be covered within approximately 15 minutes. Application must be full-surface using a notched trowel. The adhesive layer must ensure complete wetting of both bonding surfaces. Please note that for large-area applications, vulcanization and therefore the development of final bond strength may be delayed.

Consumption: Consumption depends heavily on substrate condition and application thickness.

In general, approximately 800–900 g/m² can be assumed. Uneven substrates increase consumption. Fine notches are recommended for small-format elements and/or smooth surfaces, while coarse notches are suitable for large-format, uneven, or rough substrates.

Application Recommendations:

Stable, uneven substrate (up to ~3 mm, e.g. concrete, screed) with stable, even top layer (e.g. parquet, laminate): Notched trowel B12

Stable, even substrate with stable, even top layer: Notched trowel B2

Stable, even substrate with flexible top layer (e.g. PVC flooring, linoleum): Notched trowel A1–A2

These recommendations are intended as guidelines. The appropriate notch size for each specific project should be determined through preliminary testing.

5. Meets the requirements of the IVD guideline

Nr. 30	Mounting adhesive for bonding and sealing applications
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6. Limitations of Use

- Not approved for natural stone bonding
- Not suitable for mirror bonding
- Bitumen or tar-containing substrates are unsuitable
- Always perform adhesion tests on coated substrates
- No adhesion to low surface energy plastics such as PE, PP, PTFE
- Not suitable for permanent bonding or sealing of copper and brass

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7. Safety Information

Refer to the latest EU Safety Data Sheets, available at www.hydewa.com

8. Warranty Disclaimer

The information provided, in particular the recommendations for processing and use of our products, is based on our knowledge and experience at the time of printing.

Depending on specific circumstances – especially regarding substrates, application methods, and environmental conditions – the actual results may differ from the information stated here. Therefore, no warranty can be given for the quality of the results achieved when these are influenced by the aforementioned factors. No legal claims of any kind may be derived against Hydewa GmbH from these instructions or from any verbal advice, unless intent or gross negligence on our part can be proven. Hydewa GmbH guarantees that its products comply with the specified technical properties according to the Technical Data Sheets until the expiry date.

Product users must always consult the latest version of the relevant Technical Data Sheet, which can be requested from us at any time. Our current General Terms and Conditions (GTC) apply and can be downloaded at www.hydewa.com.

Upon the release of a new or revised version of this Technical Data Sheet, all previous versions of the respective product become invalid.

