

# Technical Information

## Permarock Adhesive



### Product Description

#### Field of Application:

Permarock Adhesive is a polymer-modified cement-based compound for bonding thermal insulation boards (Mineral Fibre, EPS, etc) to mineral-based substrates and suitable sheathing/carrier boards and as part of Permarock External Wall Insulation (EWI) systems.

#### Properties:

- Good adhesive strength on mineral substrates including brick, cement block, autoclaved aerated concrete (aircrete) block, dense and no-fines concrete, cementitious and mineral sheathing boards, etc.
- Limited combustibility / Non flammable
- Highly stable
- Long open time
- Good application properties
- Water vapour permeable

#### Colours:

- Cement Grey

#### Storage:

Store off the ground, dry and protected from moisture.

#### Shelf Life:

6 months after manufacture date

#### Product Code:

RE/ADHESIVE

#### Pack Size:

25kg sacks

#### Technical Data:

Fire Behaviour:	A2-s1,d0 (EN 13501-1) *
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#### Typical Adhesive Strength:

Common Brick	0.9 MPa
Engineering Brick	1.2 MPa
Concrete Brick	1.0 MPa
Dense Concrete	0.8 MPa

Consumption approx. 3.5 - 4.5kg / m<sup>2</sup> (when tested / assessed as part of a Permarock Mineral Fibre External Wall Insulation system)

# Application

## Suitable Substrates:

All mineral substrates, e.g. masonry of manufactured cement block, clay brick, sand-lime brick, dense and no-fines concrete, autoclaved aerated concrete (AAC), cement-bonded particle board, calcium silicate board, new mineral renders / plasters, as well as cementitious reinforcement layers of EWI / ETICS, and sound, existing renders / plasters

## Preparation of Substrates:

Substrates must be even, clean, firm, sound and free from all materials that may prevent good adhesion, such as formwork oil residues.

Remove unsound, flaking / peeling or otherwise defective coatings.

Hack off loose, cracked or otherwise defective renders back to a sound substrate and reinstate with Permarock Dubbing-out Compound.

Substrates may be temporarily moist but not wet. Substrates must be frost-free. Highly absorbent, sandy or chalking substrates should be thoroughly cleaned back to a sound solid base and treated with Permarock CT-Konzentrat-111. Organic growths (moss, mildew, algae, etc.) should be removed by brushing and / or pressure washing and the surface treated with Permarock Moss & Mould Remover. Voids or deep joints in the substrate should be filled flush to the surface.

## Preparation of Material:

The material can be mixed with continuous mixers (automatic mixers) and can also be prepared manually. For manual preparation, the contents of a 25kg bag of Permarock Adhesive is gradually added, with mixing (slow speed electric paddle mixer) to approx. 4 litres of clean water in a clean, smooth bottomed mixing vessel. The material is mixed for 3 to 4 minutes and until a smooth, homogeneous mixture, free of lumps, is achieved.

The mix shall be allowed to stand for ten minutes before mixing for a further minute. At this stage, small quantities of tap water can be added to adjust to a working consistency.

## Adhesive Bonding of Insulation Boards:

Apply Permarock Adhesive to the back face of the

insulation boards.

The material can be applied using the 'ribbon' method or by the 'ribbon and dab' method.

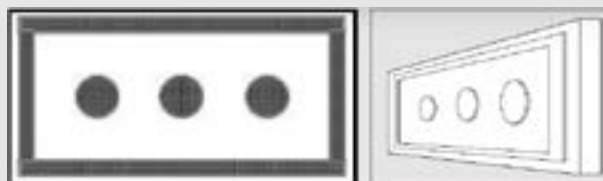
Ribbon method: Permarock Adhesive is applied as a continuous ribbon, approx. 60-70 mm wide, to the full perimeter of the back of the board. (1200mm x 600mm) Additional ribbons of material are applied at ca. 300 mm centres.



Adjust the thickness of the applied material to the tolerances of the substrate, such that > 35% of the surface area is in contact with the adhesive.

Ribbon and Dab: Permarock Adhesive is applied as a continuous ribbon, approx. 80-100 mm wide, to the full perimeter of the back of the board. (1200mm x 600mm)

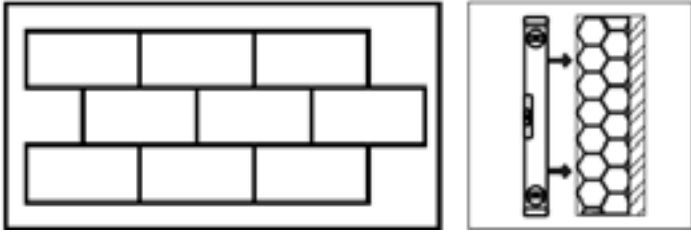
In addition 3 no. dabs of material, min 100 mm, are applied along the centre line of the back of the board.



Adjust the thickness of the applied material to the tolerances of the substrate, such that > 35% of the surface area is in contact with the adhesive. Local surface irregularities of up to approx. ± 10 mm can be accommodated by this application method.

The insulation boards should be pressed onto the wall surface and floated into place so that the adhesive is spread out onto the substrate forming a good bond. Insulation board joints are to be staggered in a stretcher bond pattern

with ca. 50% overlaps, and the boards are interlocked at all internal and external corners.



Remove all adhesive from board edges.

Maintain regular checks on the alignment and plumbness of the installed insulation.

### Consumption

Bonding of insulation boards: approx. 3.5-4.5 kg/m<sup>2</sup>

Consumption values vary depending on the roughness of the substrate and method of application. The exact rate of consumption is best determined by a trial application.

### Working Temperature

Permarock adhesive should only be used when the material, surface air temperature at the workface are 3°C and above on a rising thermometer.

Substrates must be frost free. Cease work if the temperature reaches 5°C on a falling thermometer. Do not apply onto sun heated surfaces or frozen surfaces or during rainfall or when rainfall or frost are imminent.

### Protection:

Protect adjacent surfaces. Remove splashes immediately with clean water.

### Drying / Curing Times:

Protect adjacent surfaces. Remove splashes immediately with clean water.

At 20°C and 65% RH the adhesive reaches sufficient strength to allow the application of insulation fixings after ca. 24 hours, and is thoroughly dry and ready for stress after 2-3 days. Lower temperatures prolong curing / drying time

### Pot Life:

Approx. 2-3 hours, depending on water content and weather conditions

### Cleaning of Tools & Equipment

Clean tools immediately after use with water.

### Advice

#### Further details:

See material safety data sheet.

#### Technical Information Permarock Adhesive - Issue: December 2025

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