

2020-05-07

**Stilleryd Industrispackel 720i<sup>®</sup>** is a pumpable self-levelling compound.



### Area of use

**Industrispackel 720i<sup>®</sup>** is intended for indoor use on substrates of concrete. The product may be used as a wear surface\* in light industrial use and as a self-levelling underlayment for epoxy and polyurethane surfaces.

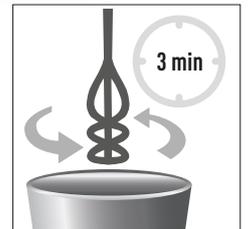
\* The product is not color-determined - color deviations can not be ruled out.

### Pre-treatment

The substrate should be clean and free of dust, cement skin, grease and other impurities that can prevent adhesion. Adhesion and surface resistance of the substrate should be no less than 1.5 MPa. Always prime the underlying substrate with **Stilleryd Primer<sup>®</sup>** and allow to dry before pouring. In terms of the primer forming a film and the curing of the selflevelling, the temperature of the substrate must not fall below 10 °C. For best results, the ambient temperature in the work area should be between 10 and 25 °C. At higher or lower temperatures, the time for curing will shorten or extend. With the risk for cracks due to shrinkage or settings in the subfloor, a concrete surface should not be leveled within the first 28 days after casting. As a recommendation the RH in the concrete should have reached RH 90 % as the upper limit for pouring the **720i<sup>®</sup>**. Use the **Stilleryd Form Foam<sup>®</sup> 015/030/050** for edging. In order to avoid drainage pipes from getting clogged, always make sure the drains are properly sealed before pouring.



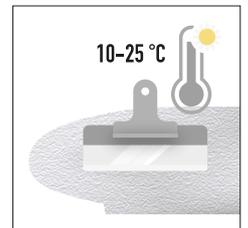
Water requirements  
3,6 l/20 kg



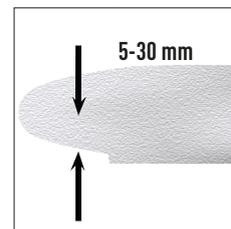
Mixing time 3 min



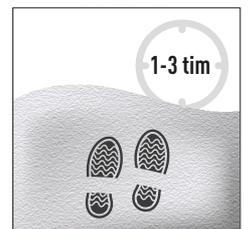
Working time  
15-25 min



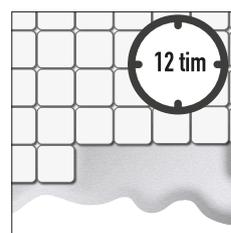
Workplace temperature  
10-25 °C



Thickness  
5-30 mm



Final set 1-3 hrs



Coverable (tiles)  
12 tim



## Mixing

Mix the dry powder with max 3.6 liters of water (max 18 %) per 20 kg bag. Mix with a drilling machine and a whisk, or a mixing pump intended for this purpose. The correct water mixture can be tested using a slump test with a cylinder with Ø 30 mm and a height of 50 mm on a 300 x 300 mm plexiglas plate. With the correct water mixture, the spread should be max 135 mm. The slump test also checks that the material is well blended and that there is no separation.

## Application

The mixed material is applied by hand, or pumped out onto the substrate in lengths. Each new ribbon is added to the old one as soon as possible so that the material can blend together and create an even surface. The width of the ribbons can be adjusted to the capacity of the mixing pump and the thickness of the covering. The material requires a light treatment with a toothed trowel to provide maximum smoothness.

## Post-treatment and curing

You can easily shape or cut the semi hardened self-leveling underlayment material before it fully dries. The product is paintable with epoxy or similar after 3–5 days depending on the thickness. Always make sure that the material is sufficiently dry before it gets overcoated. The guiding value assumes a curing temperature of approximately 20 °C, 40 % RH and proper air flow. Newly produced surfaces must be protected against wind, sun and rain.

## Storage time and packaging

Store in a dry environment, on an unopened plastic-coated pallet, six months from the date of production. The date of production is printed on the packaging. May be used after 6 months but properties such as flow rate, hardening and drying times will be extended. **Industrispackel 720i<sup>®</sup>** is delivered in 20 kg bags and in big bags.

## Residual products and safety information

Empty bags can be burned. Any remaining, dry powder that has been stored properly can be used again. Hardened material should be disposed of as construction waste. Do not wash the product into the sewage system. The cement in the product has a reduced level of chromate. Follow regulations in each respective country.

## Health, environment, safety and technical service documents

For current version of product information, contact Stilleryd AB at [info@stilleryd.se](mailto:info@stilleryd.se). Previously undated and dated issues are no longer valid. For more information contact our sales organization.

## Product specification

Release of corrosive substances	CT (as per EN 13813)
Compressive strength class	C30 (as per EN 13813)
Compressive strength average	36 MPa (as per EN 13813)
Flexural strength class	F8 (as per EN 13813)
Flexural strength average	10 MPa (as per EN 13813)
Fire resistance class	A1fl (as per EN 13813)
RWA	10 (as per EN 13813)
Adhesion to surface	B1.5 (as per EN 13813)
Thickness	5-30 mm
Grain size	< 2 mm
Material consumption	1,7 kg/m <sup>2</sup> /mm
Weight (dry state)	1700 kg/m <sup>3</sup>
Flow rate	max. 135 mm
Water requirements	3,6 l/20 kg
Workplace temperature	10-25° C
Mixing time	3 min
Working time	15-25 min
Final set	1-3 hrs
Coverable (tiles)	12 hrs
Carpetable	1-3 hrs
Paintable with epoxi or similar	3-5 days
pH	ca. 11
Water damage resistant	Yes
Surface Tensile Bond Strength, 28 days (sanded, loaded surface)	> 2,0 MPa
Shrinkage	0,03-0,05 %
TVOC 28 days	10 µg/(m <sup>2</sup> h)

This product sheet contains general information. Products can be used in a number of changing conditions and situations. Stilleryd AB is not responsible for the storage, use in construction, processing or design, interactions with other products, required use due to local conditions or other external factors. Stilleryd AB is also not responsible for cases where the above information has been misinterpreted or neglected by the user

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