



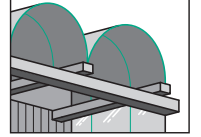
RAMSAUER®

400

LASTING BONDS.

Acrylglas

1-component neutral alkoxy sealant



Technical data sheet

Version: 11-2023

Tests:

- Tested for stress cracking of PLEXIGLAS® products
- Fulfils the French VOC requirement Class A+



1. Mechanical Properties

Basis	Neutral cure alkoxy silicone sealant
Skin formation time	~ 11 Min. (23°C/50% relative humidity)
Full curing time	~3.2 mm/24 hours (at +23°C/50% relative humidity)
Density	~ 1.03 (EN ISO 1183-1)
Shore A hardness	~ 23 (DIN EN ISO 868)
Volume shrinkage	~ 5.0% (EN ISO 10563)
Tear propagation resistance	~ 5.46 N/mm (ISO 34-1)
Tensile stress at break	~ 0.63 N/mm ² (DIN EN ISO 8339)
Module	~ 0.51 N/mm ² (EN ISO 8339)
Elongation at break	~ 200% (DIN EN ISO 8339)
Resistance to high and low temperatures	-50°C to +150°C (long-term exposure)
Application temperature (substrate, environment)	Lower +5°C, upper +35°C
Colours	Transparent
Packaging	310ml cartridge; 400 & 600ml foil bag; industrial container 20-l drum; 200-l drums
Shelf life of cartridges and foil bags	8 months in original packaging in cool and dry storage conditions
Shelf life of industrial container	6 months, cool and dry in sealed original container

2. Properties

400 Acrylglas is characterised by its very good weathering, ageing and UV resistance. Neutral cure without corrosive properties. When fully cured, 400 Acrylglas has a neutral odour and is inert.



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3. Priming table

Key

+	Good adhesion without priming
-	No adhesion
Primer	Recommended primer

Glass	+
Tiles	+
Pine wood	+
Wet ground concrete	+
Concrete, formwork smoothness	Primer 70
Steel DC 04	+
Hot-dip galvanised steel	+
Stainless steel	+
Zinc	+
Aluminium	+
Aluminium AlMg1	+
Aluminium AlCuMg1	+
Aluminium 6016	+
Anodised aluminium	+
Brass MS 63 Hardness F 37	+
PVC Kömadur ES	+
PVC soft	+
PC Makrolon Makroform 099	+
Polyacrylic PMMA XT 20070 Röhm*1	+
Polystyrene PS Iroplast	Primer 100
ABS Metzoplast ABS 7 H	+
PET	+
PU waste quality	+
Copper	+
Polycarbonate	+
PMMA Röhm sanitary quality	+
Mirrors*2	-
Natural stone	-

This table is based on adhesion tests with Rocholl test specimens under laboratory conditions. In practice, the adhesive properties depend on a large number of external influences (weathering, contamination, loads, etc.). Therefore, this table is for guidance only and does not constitute a binding statement. For further information please contact our application engineering department. The tests carried out above only refer to the adhesive properties and have no significance in terms of compatibility with the stated substrates.

*1: Different PLEXIGLAS® types exhibit certain differences in their chemical resistance. Stresses must be expected in some applications. The resulting stresses, in combination with certain agents, can lead to "stress cracking". The duration, temperature and concentration of the acting substance have a fundamental influence on any "stress cracks". When using our products in combination with PLEXIGLAS®, the suitability must therefore be checked in advance.

*2: The compatibility with various mirror coatings by different manufacturers is regularly tested in our laboratory. Advance testing is recommended due to production processes of the various manufacturers, into which we have no insights, and as a function of the existing substrate and bonding variants.

4. Application

Special sealant for use with PVC windows, Plexiglas® and double-skin sheet material. 400 Acrylglas is a silicone rubber specially designed for application on smooth, non-absorbent surfaces such as glass and aluminium, but especially for multi-skin sheet material in greenhouses, glass domes and conservatories. Suitable for sealing single glazing, insulating glazing and parapet elements in wooden, aluminium, steel and hard PVC frame construction and U section glazing (the joint cross-section must be standards-compliant) and for sealing expansion and butt joints in structural aluminium facades. For applications with laminated safety glass and/or insulating glass units, please consult our application engineering department.



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5. Meets the requirements of IVD instruction sheet

6. Processing

General instructions: The expiry date of the material must be observed, otherwise the stated mechanical properties of the product can no longer be guaranteed. Observe the ambient temperature and substrate temperature. **Pre-treatment of the adhesion surfaces:** the adhesion surfaces must be load-bearing, dry, and free of dust, grease, and oil. If required, carefully pre-treat the adhesion surfaces using a suitable primer. On absorbent substrates, please use our adhesive coating Primer 70. Use Primer 140 on copper, lead and galvanised metals. **Joint design:** For motion compensating joints, the dimensions must be designed to absorb the maximum motion expected. A minimum cross-section of 3x5 mm must be adhered to for the joint. The joint design must comply with the applicable standards and regulations. **Application of the sealant:** Working within the application temperature limits, the product must be applied uniformly to the joint avoiding inclusions. If the substrate is pretreated with primer, its flash-off time must be observed. When reworking, good contact with the adhesive surfaces/joint edges must be ensured (using Ramsauer tooling agent). The joint must be tooled within the skin formation time. **Rework:** Any contamination caused by the use of tooling agents must be removed and cleaned up immediately. Contamination from adjacent substrates must be cleaned up when fresh, this is also recommended for contaminated processing equipment.

7. Application restrictions

Caution: When using an adhesive coating, make sure that it does not come into contact with pre-stressed glass or plastics! Hairline cracks occur and can subsequently cause breakage of the part in question. In case of joints or seals exposed to high chemical or mechanical stress, please contact our application engineering department. Not suitable for aquarium bonding and grouting in permanently wet areas. Not suitable for natural stone. Avoid contact with softeners or materials containing bitumen and plasticizers, e.g., EPDM, butyl, neoprene, insulating paints or bituminous coating.

8. Safety instructions

Please refer to the current EC safety data sheets. Data sheets are available at any time from our website at www.ramsauer.eu.

9. Application notes

Good ventilation must be ensured during processing and curing. Due to the large number of possible influences during processing and application, the processor must always carry out a test processing before use. Note the expiry date of the material. 1-component sealants are not suitable for full-surface bonding. The curing speed increases with increasing coating thickness. If the 1-component material is used in coating thicknesses of more than 15 mm, please contact our application engineering department. If the products are stored and/or transported over a longer period of time (several weeks) at higher temperatures/humidity, the shelf life may be reduced or the material properties may change. During application of the NIRO hue, the colour pigment used here can cause visual flaws, dark separating lines, etc., where two silicone layers overlap. This is not a reason for complaint, but a typical product property.



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10. Liability for defects

The information, in particular the suggestions for the processing and use of our products, is based on our knowledge and experience in normal use cases at the time of printing. Depending on the specific circumstances, in particular with regard to substrates, processing and environmental conditions, the results may differ from this information. Therefore the guarantee of a work result or a liability, for whatever legal reasons, can be justified neither from these references, nor from a verbal consultation, unless we are guilty of intent or gross negligence in this respect. Ramsauer guarantees that its products comply with the technical properties specified in the technical data sheets until the expiry date.

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