



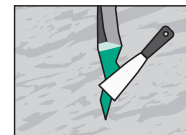
**RAMSAUER®**

# 323

LASTING BONDS.

# Struktur Hybrid

1-component hybrid sealant

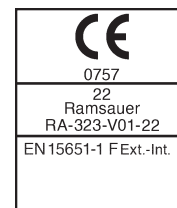


## Technical data sheet

Version: 09-2023

### Tests:

- EN 15651-1:2012-12 F25LM Ext.-Int.
- EMICODE EC1<sup>PLUS</sup> "very low emissions"
- Fulfils the French VOC requirement Class A+



## 1. Mechanical Properties

Basis	Hybrid MS polymer
Skin formation time	~ 11 Min. (23°C/50% relative humidity)
Full curing time	~2.1 mm/24 hours (at +23°C/50% relative humidity)
Density	~ 1.38 (EN ISO 1183-1)
Volume shrinkage	~ 2% (EN ISO 10563)
Non-sag property	< 3 mm
Resistance to high and low temperatures	-40°C to +90°C (long-term exposure)
Application temperature (substrate, environment)	Lower +5°C, upper +35°C
Admissible total deformation	25%
Colours, (grain size in mm)	White, fine (0.25-0.5 mm), coarse (0.5-1.0 mm)
Packaging	310 ml cartridge, other containers on request

## 2. Properties

323 Struktur Hybrid is silicone-free, odourless, cures almost without shrinkage, resistant to morning dew and weatherproof. 323 Struktur Hybrid shows very good adhesion to many different substrates, even if slightly moist. The sealant is paint-compatible according to DIN 52452 Part 4. Compatibility with the paint or coating system must be checked in advance.



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# 323

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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	+
Steel DC 04	+
Hot-dip galvanised steel	+
Stainless steel	+
Zinc	+
Aluminium	+
Aluminium AlMg1	+
Aluminium AlCuMg1	+
Aluminium 6016	Primer 140
Anodised aluminium	+
Brass MS 63 Hardness F 37	+
PVC Kömadur ES	+
PVC soft	Primer 100
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

323 Struktur Hybrid is suitable for perimeter joints according to EN 15651-1: 2012-12, and for interior and exterior joints where a textured surface is desired. As this product is absolutely silicone-free, it can also be used in areas of paint and powder coatings. Due to the silicone-free formula, the product can also be used on damp substrates and immediately forms a surface that is resistant to moisture impact. 323 Struktur Hybrid is ideally suited for filling cracks in, and repair work, on textured and friction-effect plasters/renderers.



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# 323

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### 5. Meets the requirements of IVD instruction sheet

No. 12	Overpaintability of motion-compensating sealants in building construction. Requirements and impacts.
No. 16	Perimeter joints in dry construction. Possible applications of sprayable sealants
No. 20	Joint seal on wooden components and wood-based materials. Possible applications of sprayable sealants
No. 28	Renovation of defective joint sealing on the facade
No. 29	Joint work in painting and decorating trade

### 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. Before applying, it must be ensured that all building materials in the contact area are compatible with the sealant. **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. Adhesion and compatibility with plastics should be tested on a case-specific basis. Substrates containing tar and bitumen are unsuitable as adhesion substrates or must be tested independently in advance. **Joint design:** For motion compensating joints, the dimensions must be designed to absorb the maximum motion expected. The joint cross-section must be planned in advance and adhered to. Joint dimensions that do not comply with the state of the art are impermissible. Back filling must be effected with a suitable PE-based closed-cell profile. **Application of the sealant:** Working within the application temperature limits, the material 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.

### 7. Application restrictions

**Caution:** Not suitable for sealing and bonding natural stone (edge zone contamination). When coating the sealing compound with alkyd resin paints, incompatibilities may occur (curing problems, sticky surfaces, discolourations, etc.). Due to the variety of paints and coatings available on the market, we recommend preliminary tests. Due to the elastic properties of the material the sealant should not be painted over the entire surface. The sealant should be matched to the coating where possible. Not suitable for sealing glass rebates and in sanitary and permanently wet areas. Avoid contact with materials containing bitumen and plasticizers, e.g. butyl, EPDM, neoprene, insulating paints or bituminous coating, etc. Environmental influences (e.g., high temperature, UV exposure, chemical influences such as vapours, etc.) can affect the colours, but this has no negative effect on the product properties. In case of bonded joints exposed to UV, or for sealing glass, please contact our application engineering department. Before applying, the user must ascertain that the building materials (solid, liquid or in gaseous form) are compatible with the sealant in the contact area. High substrate or base temperatures during processing can lead to impairments of the mechanical properties.

### 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](http://www.ramsauer.eu).



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# 323

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# Struktur Hybrid

## 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.

## 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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