



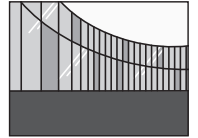
# 350



LASTING BONDS.

## Fassade

1-component neutral alkoxy sealant

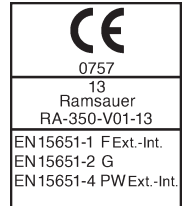


## Technical data sheet

Version: 04-2023

### Tests:

- DIN EN 15651-1 F25LM Ext.-Int.
- DIN EN 15651-2 G25LM
- DIN EN 15651-4 PW12.5E Ext.-Int.
- DIN 18545-2 Group E
- Peel strength test
- Tested with many insulating glass edge sealing systems
- Fulfils the French VOC requirement Class A+



## 1. Mechanical Properties

Basis	Neutral cure alkoxy silicone sealant
Skin formation time	~ 30 Min. (23°C/50% relative humidity)
Full curing time	~2.3 mm/24 hours (at +23°C/50% relative humidity)
Density	~ 1.35 (EN ISO 1183-1)
Shore A hardness	~ 23 (DIN EN ISO 868)
Volume shrinkage	~ 4.5% (EN ISO 10563)
Tear propagation resistance	~ 7.85 N/mm (ISO 34-1)
Tensile stress at break	~ 0.68 N/mm <sup>2</sup> (DIN EN ISO 8339)
Module	~ 0.63 N/mm <sup>2</sup> (EN ISO 8339)
Elongation at break	~ 530% (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
Admissible total deformation	25%
Colours	Black
Packaging	310ml cartridge; 400 & 600ml foil bag; industrial container 20-l drum; 200-l drums
Shelf life of cartridges and foil bags	9 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

350 Fassade is characterised due to its extreme adhesion to glass, aluminium and painted metal as well as by UV, weathering and ageing resistance. The material offers good compatibility with laminated safety glass PVB films; for applications with cast resins, please contact our application engineering department. Compatible with a wide range of insulating glass edge sealing materials. 350 Fassade has no corrosive properties. 350 Fassade adheres to a wide range of substrates without primer (glass, anodised aluminium, polyester GRP, painted metal and epoxy paints).



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### 3. Priming table

Key

+	Good adhesion without priming
-	No adhesion
Primer	Recommended primer

Glass	+
Tiles	+
Pine wood	+
Wet ground concrete	Primer 70
Concrete, formwork smoothness	+
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	Primer 100 / Primer 105
PC Makrolon Makroform 099	Primer 100 / Primer 105
Polyacrylic PMMA XT 20070 Röhm*1	Primer 40
Polystyrene PS Iroplast	Primer 100 / Primer 105
ABS Metzoplast ABS 7 H	Primer 100 / Primer 105
PET	Primer 100 / Primer 105
PU waste quality	+
Copper	+
Polycarbonate	+
PMMA Röhm sanitary quality	Primer 100 / Primer 105
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

350 Fassade is a silicone sealant with high elongation behaviour and excellent adhesion properties; it is especially suitable for weather-resistant sealing on all-glass roofs and structural facades.



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## 5. Meets the requirements of IVD instruction sheet

No. 13	Sealing glazing on wooden/metal window constructions with sealants
No. 22	Perimeter joints in structural steel and aluminium facades and structural glazing. Possible applications of sprayable sealants
No. 27	Sealing of connection and expansion joints on the facade with sprayable sealants
No. 28	Renovation of defective joint sealing on the facade

## 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. **Pretreatment of the adhesive surfaces:** It is essential for the glass joints of the insulating glass units to be free of sealant residues (on the edge seal). The adhesion surfaces must be dry, capable of bearing, and free of dust, oil and grease. If required, carefully pre-treat the adhesion surfaces using a suitable primer. We recommend covering the surfaces immediately adjacent to the seal with a suitable masking tape to prevent contamination of the substrate and to achieve a clean sealing edge. Remove the masking tape immediately after process before sealant skin formation starts. **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. Ramsauer glass joint profiles or closed-cell PE backer-up rods are recommended for backfilling. If you are using a backer-up rod, make sure that it is applied with a blunt caulking tool in order to avoid puncturing (bubble formation). **Application of the sealant:** Working within the application temperature limits, the sealant must be applied uniformly to the joint avoiding inclusions. If the substrate is pretreated with primer, its flash-off time must be observed. The tooling work must be completed within the stated skin formation time. When reworking, good contact with the adhesive surfaces/joint edges must be ensured (using Ramsauer tooling agent). When using tooling agents, any water streaks that have formed must be removed immediately after sealing, as visual flaws can otherwise be expected.

## 7. Application restrictions

**Caution:** For seals between two insulating glass elements, please check the compatibility of 350 Fassade with the sealing compound of the edge seal. Compatibility with our 670 2-Kleber is assured. 350 Fassade is not suitable for structural bonding of structural glazing elements. Before applying the sealant, it must be ensured that the building materials touching the sealant are compatible and do not negatively impact on it. Avoid contact with tar and bituminous substrates. Not suitable for use with natural stone or mirrors. The condition for chemical resistance to PVB films is a flawless bond between the PVB film and the glass. Since PVB films are sensitive to water, the edge of the laminated safety glass pane must be correctly implemented to protect the PVB film against water ingress.

## 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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## 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.

## 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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