



**RAMSAUER®**  
**DICHTSTOFFE**

# 625 PUR LEIM

## (PUR GLUE)

**Polyurethane based 1-component adhesive**

### TESTS, COMPLIANCE WITH STANDARDS

**Certified to DIN EN 204, durability class D4**

### TECHNICAL DATA

Colour: brown  
Density at +20°C: 1.13 ±0.03  
Viscosity at +20°C: Brookfield RVT/spindle 4 /10 r.p.m.: 10500 ± 3500 mPa.s  
Dry solids content: 100%  
Open time at +20°C/50% relative humidity: ~16 min.  
Press time at +20°C: ~60 min.  
Curing time at +20°C: 24 hours  
Water resistance: excellent  
Temperature resistance: -40°C to +100°C  
Consumption: 120 – 250 g/m<sup>2</sup> (depends on the material)  
Storage life: 12 months in the original package at 25°C max.  
If necessary, warm the product slowly prior to use until it reaches a suitable temperature.  
Packaging: 1000 g bottle

### CHARACTERISTICS

625 PUR LEIM is a polyurethane based one-component adhesive. It cures through exposure to air humidity.

### APPLICATION

625 PUR LEIM is suitable specifically for the waterproof bonding of wood to DIN EN 204, durability class D4, and of insulating boards (PU foam, rigid polystyrene foam etc.) onto wood, steel, aluminium sheets, concrete, and other materials

### PREPARATION OF THE SUBSTRATE

The surfaces to be bonded must be flat, dry, free from dust and grease, as well as free from contaminations of whatever kind that might compromise the bond. For cleaning the substrates, our "Grund Reiniger 828" or, optionally, acetone can be used. Use only cleaners or solvents that comply with the local regulations. It must be verified in advance that the

### HOW TO APPLY THE PRODUCT

625 PUR LEIM is applied on one side only, using a brush or a spreader. If none of the two surfaces is porous, a thin mist of water (up to 15 g/m<sup>2</sup>) is sprayed onto the surface of the adhesive coat. Join both materials within the "open time". For wood-on-wood bonding, apply a pressure of 5 daN/cm<sup>2</sup>. After joining other material types, apply a maximum and even pressure on the surface that will not cause any lasting deformation of the materials. Curing speed depends on the

### LIMITATIONS OF APPLICATION

After processing, clean the processing tools using methyl ethyl ketone (MEK) or acetone as long as the compound has not polymerized yet. Once it has polymerized, it will have to be removed using mechanical means.

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commonly used in the construction industry. 625 PUR LEIM must not be used in toys or baby products that children could put into their mouths.

cleaner used is compatible with the substrates. Grind metallic substrates where necessary. After grinding, clean them again and allow them to dry. When using solvents, turn off all ignition sources and observe the safety instructions and instructions for use provided by the manufacturer.

temperature. Therefore, check in advance:  
if the temperature is below +20°C = observe or increase the required press time;  
if the temperature is above +20°C = observe the open time of the adhesive.  
Failure to do so may lead to insufficient bonding results.



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## PRESS TIME

Temperature		Pressing time	
Adhesive + Wood	Press	With water	Without water
+20°C	20°C	40 min.	55 min.
+20°C	30°C	30 min.	40 min.
+20°C	40°C	20 min.	30 min.
+20°C	50°C	14 min.	22 min.
+20°C	60°C	9 min.	15 min.

Material: 3mm Balsa Wood, Coverage: ~ 150g/m<sup>2</sup>

## SAFETY ADVICE

Hazardous to health. For further safety advice, consult the current Safety Data Sheet which is available at all times on our website at [www.ramsauer.at](http://www.ramsauer.at).

## LIABILITY FOR DEFECTS

The information provided including but not limited to the proposals for processing and using our products is based on our knowledge and experience, usually at the time of going into print. The results of work may deviate from this information depending on the specific circumstances, in particular with respect to substrates, processing and environmental conditions. Therefore, neither this information nor any oral counselling shall constitute warranty or give rise to any liability on

whatever legal ground for any specific result of work, unless we acted intentionally or by gross negligence. Ramsauer warrants that its products will have the technical characteristics according to the Technical Data Sheets up to their expiry date. Product users must consult the latest data sheet which is available upon request. Our current General Terms and Conditions apply which are available for download on our website [www.ramsauer.at](http://www.ramsauer.at).



## QUALITY YOU CAN RELY ON

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