

640 DICHT KLEBER



RAMSAUER®
DICHTSTOFFE

(Sealing Adhesive)

1-component adhesive on a hybrid basis

TESTS, COMPLIANCE WITH STANDARDS

Ecode EC1-R PLUS “very low emission“

VOC-Testing IAC-EU

Tested for application in the food industry

Tested for application in clean rooms

DIN EN ISO 846

Tested to provide burglar-resistant joints

Meets the French VOC-requirements for class A+

TECHNICAL DATA

Basis: Hybrid adhesive – silane terminated polymers

Skin over time: ~ 8 min. (23°C/50 % relative humidity)

Curing time: ~3.7 mm/24 hours (at +23°C / 50 % relative humidity)

Density: ~ 1.498 (EN ISO 1183-1)

Shore hardness: ~ 44 (EN ISO 868)

Shrinkage: ~ 1.5% (EN ISO 10563)

Sag resistance: <3

Tear strength: ~ 9.1N/mm (ISO 34-1)

Stress at break: ~ 0.70 N/mm² (DIN EN ISO 8339)

Modulus: ~ 0.68 N/mm² (EN ISO 8339)

Elongation at break: ~ 263 % (DIN EN ISO 8339)

Processing temperature: min. + 5°C, max. + 35°C

Temperature resistance: - 40°C to +90°C (permanent exposure)

Consistency: sag-resistant ISO 7390, Profile U20

Movement capability: 20 %

Tensile force according to DIN EN ISO 8339: 1.47 N/mm²

Packaging: 80 ml mini-foil bags, 310 ml aluminium cartridges, 600 ml foil bags

Colours: white, anthracite, black, and grey

Storage life: 12 month in original package in a cool and dry place



CHARACTERISTICS

640 DICHT KLEBER is characterised by excellent adhesion to a wide variety of substrates and excellent mechanical properties within a wide temperature range. Unlike silicone sealants 640 DICHT KLEBER can be covered with a wide variety of commercially available water soluble paints

according to DIN 52452. In view of the wide variety of varnishes and paints on the market previous testing is indispensable. Neutrally cross-linking, odourless, almost no shrinkage, does not contain any solvents, silicone or isocyanates. Suitable for indoor and outdoor application.

APPLICATION

640 DICHT KLEBER opens up a wide variety of applications. Its excellent adhesion to a wide range of substrates permits preparation of glue joints involving the most different materials both indoors and outdoors. The product can be used for sealing seams in the automotive industry, manufacturing of containers, car bodies, machines, and apparatus. Durable glue joints: in cable ducts and ventilation systems. 640 DICHT KLEBER is

suitable for gluing mirrors (take into account the guidelines for application according to our Data Sheet: 660 Spiegel Kleber). 640 DICHT KLEBER can also be used for surface bonding in which case at least one side of the substrates must present a little moisture (dew moisture) which works as a catalyst for the system. Before gluing glass with enamel or other coating get in touch with our application engineering department.



MEETS THE REQUIREMENTS OF IVD-INSTRUCTION SHEETS

As of the date of publication, these instruction sheets are available in German only
No. 19-1: Sealing of joints and connections in roofs. Range of applications of sprayable sealants
No. 30: Mounting adhesives for gluing and sealing

PROCESSING

The materials to be sealed must be solid and free from dust, grease and oil before applying 640 DICHT KLEBER. Compatibility with different coatings such as paint coats, varnishes, plastics, etc. must be tested before application, or the coating must be known to be compatible with the sealant. 640 DICHT KLEBER is characterised by excellent adhesion to a wide variety of different substrates. We recommend to apply a primer for optimum adhesion particularly to absorbent/porous

and primarily alkaline substrates. The adhesive must be applied in beads to one side of the substrate and the joint must be completed within the skin over time. When gluing mirrors take into account the current version of the technical guidelines of the glaziers' trade. The product is applied by means of a manual press or compressed air press. The curing rate can be increased by supplying moisture and increasing the temperature.

LIMITATIONS OF APPLICATION

640 DICHT KLEBER is not authorised for use with natural stone. Before using the product for special applications or with natural stone it is imperative to try the specific application in an experiment and/or to consult our application engineering department.

The product is suitable for producing burglar-resistant RC2-/RC3-glue joints. ATTENTION: Ensuring compatibility of the adhesive with the edge seals of glazing, with spacers and with the surface coat of the frame is the responsibility of building component manufacturers. When preparing concrete joints it must be ensured that the edges are free from impurities.

Furthermore, the alkalinity of concrete should not be too high. In case of a pH above 9 we recommend to apply alkali-proof "Primer 160". 640 DICHT KLEBER does not adhere to polyolefins and Teflon. Before preparing joints exposed to UV radiation or sealing glass or transparent plastics get in touch with our application engineering department. The product is not suitable for use in permanently wet areas and underwater applications. Before using the product with roofing membranes or roofing films get in touch with our application engineering department. The product is not suitable for structural glazing bonds. With respect to powder coating get in touch with our application engineering department.

SAFETY ADVICE

Consult the current EC Safety Data Sheet which is available at any time on our website at www.ramsauer.at.

PROTECTION AT WORK AND HEALTH PROTECTION

Avoid swallowing and prolonged or repeated skin contact. Keep out of the reach of children. Consult our Safety Data Sheet.

ADVICE FOR APPLICATION

Ensure sufficient ventilation during processing and curing. In view of the large number of factors which may affect processing and application the user must always try the specific application in an experiment before using the product. Take into account the expiry date of the product. Storage and/or transportation of products at increased temperature/air humidity for a prolonged period of time (several weeks) may result in a reduction of

storage life and/or changes of characteristics of the product. Prior to application, the user must make sure that the sealant/adhesive is compatible with the building materials and substances (gaseous, liquid or solid) with which it will be in contact, and that any damage or negative effects are ruled out. When gluing full surfaces of vapour-proof substrates one side of the substrate must be moistened (attention: avoid the formation of pools!).

PRIMING TABLE

Glass	+
Tiles	+
Pine wood	+
Concrete, wet-ground	+
Concrete, according to formwork	+
Steel DC 04	+
Hot dip galvanised steel	+
High grade steel	+

Zinc	+
Aluminium	+
Aluminium AlMg1	+
Aluminium AlCuMg1	+
Aluminium 6016	+
Aluminium anodised	+
Brass MS 63 hardness F 37	+
Rigid PVC Kömadur ES	+
PVC plasticised	+
PC Makrolon Makroform 099	RP 100 / RP 105
Polyacrylic PMMA XT 20070 Röhm	RP 100 / RP 105
Polystyrene PS Iroplast	RP 100 / RP 105
ABS Metzoplast ABS 7 H	RP 100 / RP 105
PET	+
PU blend quality	+
Copper	+
Polycarbonate	RP 40
PMMA Röhm sanitary quality	+
Mirrors	+
Natural stone	-

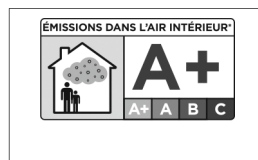
Legend: + = adheres well without a primer
- = not suitable
RP = Ramsauer primer

This table is based on adhesion tests with test solids of Rocholl corporation under laboratory conditions. Under field conditions the adhesion characteristics are dependent on a variety of external factors (weather, impurities, burdens, etc.). Therefore this table serves for guidance only and does not constitute any binding statement. For more information get in touch with our application engineering department.

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.



QUALITY YOU CAN RELY ON

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