



645 FLÄCHEN KLEBER RAMSAUER®

DICHTSTOFFE

(SURFACE ADHESIVE)

1-component adhesive on a hybrid basis

TESTS, COMPLIANCE WITH STANDARDS

EMICODE EC1-PLUS R "very low emission"
Suitable for gluing CALOSTAT® thermal insulation boards manufactured by Evonik Industries

TECHNICAL DATA

Basis: hybrid adhesive – silane terminated polymers
Film characteristics: the cured film is elastic
Skin over time: approx. 15 min. (at +23°C/50% relative humidity)
In-depth curing: ~ 2.5 mm after 24 hours (at +23°C/50% relat. humidity)
Density (DIN 52451): 1.55 g/cm³
Shore A (ISO 848): approx. 50
Shrinkage: -3%
Consistency: low viscosity – pasty
Tear strength (ASTM D 624): ~ 6.50 N/mm
E-modulus σ_{50} : 0.34 N/mm² (DIN 53504-S2)
E-modulus σ_{100} : 0.49 N/mm² (DIN 53504-S2)
Elongation at tear (DIN 53504-S1): approx. 350 %
Shear strength: ~ 0,86 N/mm² (DIN 52455-3)
Processing temperature: +5°C to + 35°C
Temperature resistance: -40°C to +90°C
Packaging: 600ml-foil bags, cartons of 20 pcs. each; 1,800ml-foil bags, cartons of 6 pcs. each; 20 I-hobbocks. Alternative packaging upon request
Colour: white
Storage life: 12 months in a cool and dry place

CHARACTERISTICS

645 FLÄCHEN KLEBER boasts high initial tack. Thanks to its 1-component system it can be used immediately. Due to the high stability in rib shape the product can be applied very well by means of a toothed spreader. The adhesive does not contain water or solvents, does not cause wood to swell, and it is compatible with materials sensitive to solvents.



645 FLÄCHEN KLEBER is permanently elastic, balances tension, can be applied with a spreader; it is weather resistant, non-corrosive, does not contain any silicone, solvents or isocyanate.

APPLICATION

645 FLÄCHEN KLEBER serves for gluing full surfaces of a wide variety of materials including wood, concrete, plaster,

metal, plastics, PVC, polyester, and polystyrene. The product is suitable for gluing enamelled glass and Iacobel glass.

MEETS THE REQUIREMENTS OF IVD-INSTRUCTION SHEET

As of the date of publication of this data sheet, this IVD-instruction sheet is available in German only.

No. 30: Montageklebstoff für Klebungen und Abdichtungen (Mounting Adhesive for Gluing and Sealing)

PROCESSING

The substrate must be level, clean, solid, free from cracks, and must have sufficient tensile strength and compressive strength. In order to ensure optimum curing the substrate should be moistened by means of a wet cloth or spray bottle. ATTENTION: Avoid the formation of pools! 645 FLÄCHEN KLEBER is characterised by extraordinary adhesion to a wide variety of substrates. For optimum adhesion, particularly to

absorbent/porous and predominantly alkaline substrates we recommend to apply a primer. The following climatic conditions must be present for using the adhesive: Air temperature: min. +10°C, max. +25°C; Substrate temperature: min. +10°C, max. +25°C. 645 FLÄCHEN KLEBER has been developed for a processing temperature of +20°C. If necessary, it must be brought to the adequate



temperature before use. Subsequently apply adhesive with a toothed spreader fully covering an area of a size which can be covered with the element(s) to be glued within 15 minutes. Introduce the work piece(s) to be glued into the adhesive bed

within that time and knock it/them down thoroughly. The product is applied by means of a manual or compressed air press. The curing time can be reduced by supplying moisture and increasing the temperature.

LIMITATIONS OF APPLICATION

Before using the product with natural stone consult our application engineering department. Before gluing coated or varnished glass the user must conduct compatibility and adherence tests. In view of the wide variety of different varnish and coating systems we cannot assume any liability. 645 FLÄCHEN KLEBER does not adhere to polyolefins and Teflon. Before preparing UV-exposed glue joints with glass or

transparent plastics get in touch with our application engineering department. Before using the product in permanently wet areas of for underwater applications get in touch with our application engineering department. 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.

SAFETY ADVICE

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

VISCOSITY

The viscosity of the paste is temperature dependent. At low temperatures viscosity is higher; at high temperatures it is lower.

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	RP 70
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	+
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	+
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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