



RAMSAUER®
DICHTSTOFFE

655 KRAFT FIX (Power adhesive)

- Basis: hybrid sealant – silane terminated polymers
- Shore-A-hardness: 80 (ISO 868)
- Density: 1,560 g/cm³ (ISO 1183/method B)
- Viscosity: 200 Pa.sec (Rheotron)
- Curing: approx. 2.5 mm after 24 hours (23°C / 50% relative humidity)
- Skin over time: approx. 5 min. (23°C / 50% relative humidity)
- Shrinkage: approx. 4 %
- Tensile strength: 3.0 N/mm² (DIN 53504-S1)
- Elongation at break: 20 % (DIN 53504-S1)
- Tear strength: 15 N/mm (ISO 34/method C)
- Temperature resistance: -30°C to +90°C
- Storage life: 12 months in a cool and dry place
- Packaging: 290ml cartridges, 600ml foil bags, 20 units per cardboard box
- Colours: grey

Application

655 KRAFT FIX is a ready for use 1-component sealant on an MS-hybrid basis with high shore hardness and excellent initial tack. This high performance adhesive opens up a wide range of applications. Thanks to its excellent adhesion properties it permits preparing joints with many different materials both indoors and outdoors. 655 KRAFT FIX is a neutrally cross-linking odourless adhesive, it does not contain any solvents, silicone or isocyanates. The product is suitable for gluing mirrors.

Limitations of application

655 KRAFT FIX is not approved for natural stone. In case of special applications and for projects involving natural stone it is imperative to make preliminary experiments and/or to contact our application engineering department. Liability that mirrors will not be tarnished can be assumed only subject to the condition that the mirror coating is sufficiently thick (50 µm) and free from damage. When gluing mirrors and/or mirror elements take into account the applicable standards and guidelines such as the Technical Guidelines of the Glazier's Trade (*“Technische Richtlinien des Glaserhandwerks”*) No. 11 Mounting of Mirrors (*“Montage von Spiegeln”*). If you intend to glue coated glass get in touch with our application engineering department. Not suitable for gluing aquariums. Not suitable for permanently wet areas. If you intend to use the product for gluing or sealing UV-exposed joints with glass or transparent plastics get in touch with our application engineering department.

ATTENTION: The responsibility for compatibility of the adhesive with the edge seal of glazing, inserted glazing spacers, and surface coating of the frame structure is with the manufacturer of the building component.

Processing

The materials to be sealed must be solid, and free from dust, grease, oil, and separating agents before applying 655 KRAFT FIX. 655 KRAFT FIX adheres extraordinarily well to a wide variety of substrates. Adhesion of the product must be tested by the user prior to application. In case of poor adhesion use a suitable primer. Application by means of manual or compressed air press.

Safety advice

Consult our current EC-safety data sheet. Our data sheets can be downloaded from our website www.ramsauer.at at any time.



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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 areas of vapour-proof substrates one side of the substrate must be moistened (attention: avoid the formation of pools!).

Priming table

Substrate

Glass	+
Tiles	+
Pinewood	+
Concrete, wet ground	RP 70
Concrete, smooth according to formwork	RP 70
Steel DC 04	WP 40
Hot dip galvanised steel	+
High grade steel	+
Zinc	+
Aluminium	+
Aluminium AlMg1	+
Aluminium AlCuMg1	+
Aluminium 6016	+
Aluminium anodised	WP 40
Brass MS 63 Hardness F 37	+
Rigid PVC Kömadur ES	RP 100
PVC plasticised	+
PC Makrolon Makroform 099	+
Polyacryl PMMA XT 20070 Röhm	+
Polystyrene PS Iroplast	+
ABS Metzoplast ABS 7 H	RP 100
PET	+
PU cut-back quality	+
Copper	+
Polycarbonate	RP 100
PMMA Röhm sanitary quality	+
Mirrors	+
Natural stone	-

Legend: + = adheres well without a primer
- = not suitable
WP/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, stress, 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.



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Liability for defects

The information provided including but not limited to the proposals for processing and using our products are 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 at any time.