



**RAMSAUER®**  
**DICHTSTOFFE**

# 350 FASSADE

**Tested to DIN 18545 Part 2 Group E, supplementary testing glass-aluminium, and determination of peel strength. Tested for compatibility with edge seals of various manufacturers by ift Rosenheim.**

- Basis: Neutrally cross-linking alkoxy system
- Shore-A-hardness: ~ 35 (DIN A 52505)
- Movement capability: max. 25%
- Peel strength: 37 N/cm
- Temperature resistance: - 40°C to + 150°C
- Density: 1.44 g/cm<sup>3</sup> (DIN 52451)
- Tensile behaviour:  $\sigma_{+23} = 0.40$  N/mm<sup>2</sup> (DIN EN ISO 8339)
- Tensile behaviour:  $\sigma_{-20} = 0.56$  N/mm<sup>2</sup> (DIN EN ISO 8339)
- Elongation at break (DIN EN ISO 8339): ~ 170 %
- Processing temperature: + 5°C to + 35°C
- Skin-over time: ~ 45 minutes (23°C, 50 % relative humidity)
- Storage life: 9 months in a cool and dry place
- Colour: black
- Packaging: 310ml cartridges, 600ml foil bags

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## Characteristics

350 FASSADE is a silicone sealant characterised by superior elongation behaviour and excellent adhesion, particularly suitable for weather resistant sealing of full-glass facades and glass roofs.

350 FASSADE is characterised by perfect adhesion to glass, aluminium and paint-coated metals, and high UV-, weather-, and ageing resistance. The product is highly compatible with PVB foils in laminated safety glass units. With respect to cast resins get in touch with our application engineering department. Compatible with a high number of edge sealing materials used for insulating glass. 350 Fassade does not have any corrosive properties.

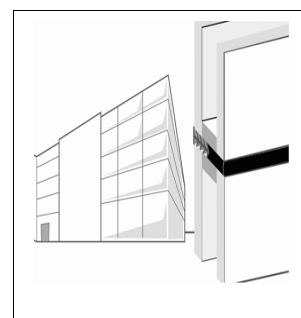
350 FASSADE adheres to a wide variety of substrates without priming (glass, anodised aluminium, polyester GRP, paint-coated metals, and epoxy resin paints).

In case of highly absorbent substrates we recommend to use our PRIMER 70 to enhance adhesion.

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## Application

When sealing insulating glass the points of adhesion to glass must be absolutely free from sealant residues (edge seal). The surfaces must be clean, dry, and free from grease, dust and frost cover. We recommend to cover the areas immediately adjoining the seal with suitable adhesive tape in order to prevent contamination of the substrate and to achieve a neat seal edge. Remove the cover tape immediately after work before skin formation of the sealant sets in. For backfilling use Ramsauer glass joint sections ("Glasstoss Profile") or closed-cell PE backer rods. When using a backer rod make sure that it is introduced with an edgeless tool in order to avoid piercing (formation of bubbles). Introduction of the sealant: 350 FASSADE must be introduced into the joint evenly and without bubbles while the product is within the processing temperature range. When priming the substrate take into account the open time of the primer. Ensure good adhesion to the adherent surfaces/joint edges during the finishing work. The excessive sealant must be removed within 10 minutes from application (smoothing with Ramsauer smoother). When using a smoother remove any





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streaks of water immediately after sealing. If cleaning is delayed permanent streaks may remain.

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#### **Limitations of application**

When sealing joints between two insulating glass elements it is imperative to test compatibility between 350 FASSADE and the edge sealant. The product is compatible with our edge sealant 380 RANDVERBUND and with our 2-component adhesive 670 2-K-KLEBER.

350 FASSADE is not suitable for gluing joints of structural glazing elements. Before applying the sealant it must be ensured that the building materials in the contact zone are compatible with the product and will not adversely affect it. Avoid contact with tarry and bituminous substrates. Not suitable for natural stone or mirrors. Joints with PVB-foils will be chemically resistant only with a perfect joint between the inserted PVB-foil and glass. Since PVB-foils are sensitive to water the edge of the laminated safety glass pane must be made accurately in order to protect the PVB-foil from the penetration of water.

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#### **Protection at work and health protection**

Avoid swallowing the product and avoid any prolonged or repeated skin contact. Keep out of the reach of children. Ask for our Safety Data Sheet!

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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. 1-component silicone sealants are not suitable for gluing full areas. The curing time increases with the thickness of the layer. Before using the 1-component silicone sealant in layers with a thickness of more than 15 mm get in touch with our application engineering department. 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.

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#### **Priming table**

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



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PET	RP 100
PU cut-back quality	+
Copper	+
Polycarbonate	-
PMMA Röhm sanitary quality	-
Mirrors	-
Natural stone	-
<b>Legend:</b> +    = 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, 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.

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#### **Safety advice**

Refer to our current EC Data Sheet. Data sheets are available at any time on our website **[www.ramsauer.at](http://www.ramsauer.at)**.

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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](http://www.ramsauer.at)** at any time.