



**RAMSAUER®**  
**DICHTSTOFFE**

# **630 MONTAGE KLEBER**

## **(Mounting Adhesive)**

- Basis: Acrylate dispersion
- Temperature resistance: up to max. +65°C
- Curing time: with absorbent substrate on both sides: approx. 15 min.  
with absorbent substrate on one side: approx. 30 min.
- For indoor and outdoor application
- Processing temperature: + 5°C to + 35°C
- Consumption: 100 – 300 g/m², 20 – 40 g/lineal metre
- Specific weight: 1.34 g/cm³
- Packaging: 310ml cartridges
- Colour: beige
- Storage life: 12 months, store in a cool and dry place protected from frost

### **Characteristics**

The solvent-free universal mounting adhesive 630 MONTAGE KLEBER remains flexible after curing. It can be used both indoors and outdoors and excels by quick curing. 630 MONTAGE KLEBER is highly resistant to the effects of water and heat. After curing the material is totally odourless, physiologically safe, and inert.

### **Application**

Ramsauer 630 MONTAGE KLEBER permits to mount wood ledges and sections, rigid PVC sections, polyurethane beams, polystyrene (styrofoam), chip boards, and ceiling tiles onto wood, stone, tiles, plaster, etc. without using nails or screws.

### **Processing**

The substrates must be solid, dry, and free from dust. One adherent surface must be absorbent. Apply 630 MONTAGE KLEBER in sufficient quantity to the parts to be glued or substrate. Subsequently join work pieces in a sliding movement, align, press against the substrate, and secure for the curing time specified above. Remove any issuing adhesive immediately. In order to improve adhesion we recommend to prime porous and/or highly absorbent substrates with a 1 : 1 primer mixture of 630 MONTAGE KLEBER and water.

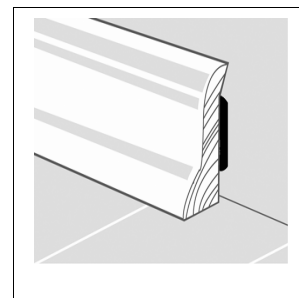
### **Limitations of application**

Not suitable for gluing mirrors, glass, various plastics (PE, PP, PA, Teflon, ...), silicone, acrylic glass, substrates containing oil or bituminous substrates. May cause corrosion of iron and non-ferrous metals without corrosion protection. 630 MONTAGE KLEBER must be protected against the effects of rain and solvents until a solid skin has formed (approx. 12 hours). Not suitable for civil engineering works and underwater joints.

Compatibility with various coats such as paints, varnishes, plastics, etc. must be tested before application unless the product is known to be compatible with the coating material. Before starting work it is imperative to make sure that the materials used close to the adhesive, their ingredients and/or fumes will not affect or modify the adhesive.

### **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. Not suitable for gluing full





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areas. The curing time increases with the thickness of the layer. Before using the sealant in layers of more than 15 mm get in touch with our application engineering department. Acrylates change colour during curing/drying. The final colour will be reached only when the product has cured completely. 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.

#### Priming table

|  |                          |
|--|--------------------------|
| Glass                                  | -                        |
| Tiles                                  | -                        |
| Pinewood                               | +                        |
| Concrete, wet ground                   | 1 : 1 diluted with water |
| Concrete, smooth according to formwork | 1 : 1 diluted with water |
| Steel DC 04                            | -                        |
| 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                   | +                        |
| PVC plasticised                        | -                        |
| PC Makrolon Makroform 099              | -                        |
| Polyacryl PMMA XT 20070 Röhm           | -                        |
| Polystyrene PS Iroplast                | -                        |
| ABS Metzoplast ABS 7 H                 | -                        |
| PET                                    | -                        |
| PU cut-back quality                    | -                        |
| Copper                                 | -                        |
| Polycarbonate                          | -                        |
| 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, 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.

#### 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).

#### 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.

