



RAMSAUER®
DICHTSTOFFE

640 DICHT KLEBER

(Sealing Adhesive)

Tested for application in clean rooms; tested to provide burglar-resistant joints of resistance class ("WK") 2; tested to EMICODE EC1-R "very low emission"

- Basis: Hybrid adhesive – silane terminated polymers
- Shore-A hardness: 40 ± 5 (ISO 868)
- Elastic recovery: $> 60\%$ DIN EN ISO 7389
- Temperature resistance: -40°C to $+90^{\circ}\text{C}$ (permanent resistance)
- up to $+200^{\circ}\text{C}$ (in the course of powder coating: 15 to 20 minutes)
- Density at 25°C : 1.444 g/cm^3 ISO 1183, method B
- Consistency: sag resistant ISO 7390, section U20
- Volume change during curing: $< 1\%$
- Movement capability: 20%
- Tensile strength according to DIN EN ISO 8339: 1.47 N/mm^2
- Elongation at break according to DIN EN ISO 8339: $\sim 190\%$
- Processing temperature: minimum $+5^{\circ}\text{C}$, maximum $+35^{\circ}\text{C}$
- Skin over time: approx. 7 - 10 min. (23°C , 50% relative humidity)
- Curing: after 24h 3-4mm; after 48h 5-6mm at 23°C , 50% relative humidity
- Packaging: 80ml mini-foil bags, 310ml aluminium cartridges, and 600ml foil bags
- Colours: white, black, and grey
- Storage life: 12 months in original container in a cool and dry place.

Characteristics

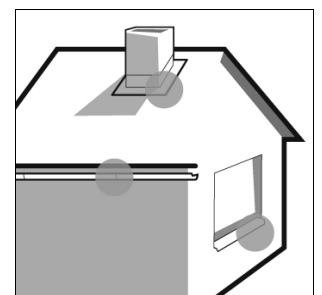
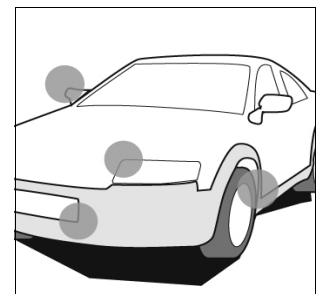
640 DICHT KLEBER is characterised by excellent adhesion to a wide variety of substrates and excellent mechanical properties within a wide temperature range. Unlike silicone sealants 640 DICHT KLEBER can be covered with a wide variety of commercially available water soluble varnishes according to DIN 52452. Due to the wide variety of varnishes and paints on the market it is imperative to conduct preliminary experiments. 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 as a **joint sealant**: floor joints, connection joints in metal, wood, concrete, and plastics. **Sealing of 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 gluing large areas 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.

Limitations of application

640 DICHT KLEBER is not authorised for use with natural stone. In case of special applications or use with natural stone it is imperative to conduct





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preliminary experiments and/or to consult our application engineering department.

The product is suitable for producing burglar-resistant glue joints of resistance class 2 ("WK 2"). 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 the manufacturer of the building components. 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. If you intend to prepare joints exposed to UV radiation or seal glass or transparent plastics get in touch with our application engineering department. The product is not suitable for use in permanently wet areas nor for underwater applications.

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.

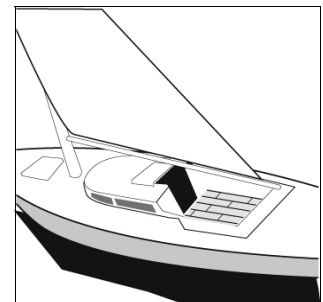


Safety advice

Refer to the current EC-safety data sheet. Data sheets are available at any time on our website at www.ramsauer.at.

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 impairment is ruled out. When gluing large areas of vapour-proof substrates one adherent surface must be moistened (Attention: Avoid the formation of pools!).



Priming table

Substrate

Glass	+
Tiles	+
Pinewood	+
Concrete, wet ground	+
Concrete, smooth according to formwork	+
Steel DC 04	+
Hot dip galvanised steel	+
High grade steel	+
Zinc	+



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Aluminium	+
Aluminium AlMg1	+
Aluminium AlCuMg1	+
Aluminium 6016	+
Aluminium anodised	+
Brass MS 63 hardness F 37	+
Rigid PVC Kömadur ES	+
Plasticised PVC	+
PC Makrolon Makroform 099	RP 100
Polyacryl PMMA XT 20070 Röhm	RP 100
Polystyrene PS Iroplast	RP 100
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 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 properties 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 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.