



RAMSAUER®
DICHTSTOFFE

645 FLÄCHEN KLEBER (Area adhesive)

Tested to EMICODE EC1-R "very low emission"

Technical data

- Basis: Hybrid adhesive - silane-terminated polymers
- Film characteristics: the cured film is elastic
- Colour: white
- Consistency: low viscosity - pasty
- Density (DIN 52451): 1.41g/cm³
- Skin over time (20°C, 50% relative humidity): approx. 25 min
- Shore A (ISO 848): approx. 25
- Elongation at tear/break (DIN 53504-S1): approx. 200 %
- Tensile strength (DIN 53504-S1): 1.1 N/mm²
- Processing temperature: +5°C to + 35°C
- Cleaning: acetone, ethanol, spirit; the cured adhesive can be removed by mechanical means only
- Packaging: 600ml foil bags, 20 units per cardboard box; 20l-hobbock
- Storage life: 12 months in a cool and dry place

Application

645 FLÄCHEN KLEBER serves for gluing full areas of a wide variety of materials including wood, stone, concrete, plaster, metal, plastics, PVC, polyester, and polystyrene. Suitable for gluing enamelled glass and lacobel glass. Before gluing mirrors get in touch with our application engineering department.

Characteristics

645 FLÄCHEN KLEBER has high initial adhesive force and 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.

Substrates/preparation

The substrate must be level, clean, solid, free from cracks, 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!

Processing

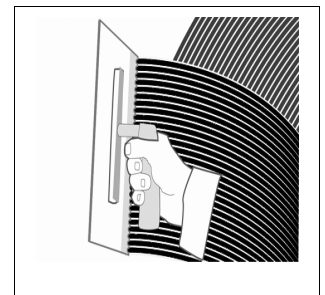
645 FLÄCHEN KLEBER is characterised by extraordinary adhesion to a wide variety of substrates. For optimum adhesion, particularly to absorbent/porous and predominantly alkaline substrates we recommend to apply a primer.

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, and must be brought to the required 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.





RAMSAUER®
DICHTSTOFFE

Introduce the workpiece(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.

Consumption

Consumption largely depends on the substrate and thickness of the layer. Generally you can assume that approx. 800 to 900 grams of adhesive will be needed per square metre. Consumption increases by up to 30 % with rough substrates and coarse toothed spreaders. It is recommended to use spreaders with fine toothing for small elements and/or level substrates, and spreaders with coarse toothing in case of large areas and/or hardly level or rough substrates.

Important note

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

Limitations of application

Consult our application engineering department before using the product with natural stone ! 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 glued joints in glass or transparent plastics get in touch with our application engineering department. When intending to use 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

Refer to the current EC Safety Data Sheet. Safety data sheets are available at any time at our website 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

Glass	+
Tiles	+
Pinewood	+
Concrete, wet ground	RP 70
Concrete, smooth according to formwork	+
Steel DC 04	+
Hot dip galvanised steel	+
High grade steel	+



RAMSAUER[®]
DICHTSTOFFE

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	+
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	+
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.

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.