



RAMSAUER®
DICHTSTOFFE

670 2-KOMPONENTEN KLEBER

(2-component adhesive)

Tested to DIN 1279-2/3 & 4

- Basis: Neutrally cross-linking alkoxy system
- Shore A hardness: approx. 35 (DIN 53505)
- E-modulus 100%: 0.5 N/mm² (DIN 53504)
- Elongation at tear/break: 200% (DIN 53504)
- Movement capability: 25 %
- Tear strength: 7.5 N/mm² (ISO 34 method C)
- Tensile strength at +23°C: 0.95 N/mm² (ISO 8339 method A)
- Density 380ml-cartridge: 1.35 g/cm³
- Temperature resistance: - 50° C to + 150° C
- Processing temperature: +5° C to + 35° C
- Pot life: approx. 25 minutes
- Density component A (compound): 1.348 g/cm³
- Density component B (hardener): 1.000 g/cm³
- Colour: black
- Packaging: 380ml-coaxial cartridges; 12 units per box; 20l-hobbock, 200l-drums
- Storage life: 6 months in a cool and dry place

Characteristics

670 2-KOMPONENTEN KLEBER is a quickly curing moisture-independent silicone rubber particularly suitable for gluing and sealing a wide variety of materials. 670 2-KOMPONENTEN KLEBER is characterised by excellent adhesion to glass. A primer must be used for absorbent substrates (wood, plaster, concrete, etc.) as well as for plastics and metallic substrates. Ageing, weather, and UV-resistant, suitable for laminated safety glass. Can be used with spacers of aluminium, high-grade steel and plastic. After curing, the material is odourless, physiologically safe and inert.

Application

670 2-KOMPONENTEN KLEBER is particularly suitable for gluing substrates (gluing of areas) where the access of air moisture is blocked. Especially suitable for UV-resistant gluing of insulating glass panes. Suitable for sealing single panes and insulating glass (even laminated safety glass with PVB foils) in wood and metal frames, as well as for sealing frame structures, showcases, aquariums, terrariums, in the motor vehicle industry, shipbuilding, gluing of Ceran cook tops, iron structures, tanks, and for a wide variety of industrial applications.

Primers

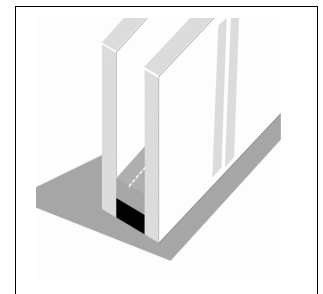
Non-absorbent metallic substrates: **Primer 140** (for plastics please enquire with us!)

Absorbent substrates: **Primer 160**

Processing

Preparation of adherent surfaces: The adherent surfaces must be solid, dry and free from dust and grease. Prime the adherent surfaces carefully. The product is not suitable for tarry and bituminous substrates.

Processing: By means of the **special compressed air press "2-K 485"**. This press permits neat and professional workmanship using the product from the coaxial cartridge. Mixing is performed by means of the forced mixer supplied





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with the product (can also be ordered separately).
IMPORTANT: The first approx. 15 cm of product thread (components not yet mixed 100 %) must be discarded.

When **mixing by means of a 2-component dosing and mixing device**, dosage is at a ratio of 10:1 (volume), 12:1 (weight).

Introducing the sealant: 670 2-KOMPONENTEN KLEBER must be introduced into the joint and distributed evenly and free from bubbles while within the processing temperature range. When applying a primer to the substrate take into account its open time. During finishing work make sure that there is good contact with the adherent surfaces/joint edges (smoothing with Ramsauer smoother). When using a smoother remove any strips of water immediately after sealing. If cleaning is delayed permanent streaks may remain.

IMPORTANT: In case of processing by machine stir component B before use !

Limitations of application

Not suitable for structural gluing of structural glazing elements. Prior to application, the user must make sure that any and all building materials and substances (gaseous, liquid or solid) with which the product will be in contact are compatible with it and that any damage or impairment is ruled out. Paints, varnishes, plastics and any other coating materials must be compatible with the adhesive/sealant. 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.

Safety advice

Refer to our current EC Data Sheet. Data sheets are available at any time on 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. Component A does not react with air humidity and is stable under normal conditions (23°C / 50 % relative humidity). Component B is sensitive to air humidity and must be protected against humidity. A uniform and accurate mixture must be ensured. For this purpose it is recommended to take a sample each time when using the product and to compare it with a master sample. The products must be stored in the original container without any exception. In case of storage and/or transportation at increased temperatures or increased air humidity it is not possible to rule out a reduction of storage life and/or changes of material characteristics.

Priming table

Glass	+
Tiles	+
Pinewood	+
Concrete, wet ground	RP 70
Concrete, smooth according to formwork	RP 70
Steel DC 04	RP 140
Hot dip galvanised steel	RP 140
High grade steel	+
Zinc	RP 140
Aluminium	+
Aluminium AIMg1	RP 140



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Aluminium AlCuMg1	RP 140
Aluminium 6016	RP 140
Aluminium anodised	+
Brass MS 63 Hardness F 37	+
Rigid PVC Kömadur ES	RP 100
PVC plasticised	RP 100
PC Makrolon Makroform 099	-
Polyacryl PMMA XT 20070 Röhm	-
Polystyrene PS Iroplast	RP 100
ABS Metzoplast ABS 7 H	RP 100
PET	RP 100
PU cut-back quality	RP 100
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.