



# 630 MONTAGE KLEBER RAMSAUER®

DICHTSTOFFE

(Mounting adhesive)

1-component adhesive on an acrylate basis

## TESTS, COMPLIANCE WITH STANDARDS

EMICODE EC1-R "very low emission"

## TECHNICAL DATA

Basis: acrylate dispersion  
Skin over time: ~ 15 min. (23°C/50 % relative humidity)  
Curing rate: ~5 mm/24 hours (at +23°C / 50 % relative humidity)  
Density: ~ 1.34 (EN ISO 1183-1)  
Shore hardness: ~ 67 (EN ISO 868)  
Shrinkage: ~ 6% (EN ISO 10563)  
Sag resistance: <3  
Tear strength: ~ 7.05 N/mm (ISO 34-1)  
Stress at break: ~ 0.88 N/mm<sup>2</sup> (DIN 53504-1 S2)  
Modulus: ~ 0.43 N/mm<sup>2</sup> (DIN 53504-1 S2)  
Elongation at break: ~ 680 % (DIN 53504-1 S2)  
Temperature resistance: max. +65° C  
Curing time: with absorbent substrates on both sides: approx. 15 min.  
Curing time: with absorbent substrate on one side: approx. 30 min.  
Suitable for indoor and outdoor application  
Processing temperature: + 5° C to + 35° C  
Consumption: 100 – 300 g/m<sup>2</sup>, 20 – 40 g/lineal metre  
Specific weight: 1.27 g/cm<sup>3</sup>  
Packaging: 310ml-cartridges  
Colour: white  
Storage life: 12 months in a cool and dry place; protect from frost

## CHARACTERISTICS

The solvent-free universal mounting adhesive 630 MONTAGE KLEBER provides a solid glue joint once it has cured. 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 (see table below).

## LIMITATIONS OF APPLICATION

Not suitable for gluing mirrors, glass, various plastics (PE, PP, PA, Teflon, ...), silicone, acrylic glass, substrates containing oil or bituminous substrates. The product may cause corrosion of iron and non-ferrous metals without corrosion protection. 630 MONTAGE KLEBER must be protected from 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 adhesive is known to be compatible with the coating material. Before starting work it is imperative to make sure that the



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materials used close to the adhesive, their ingredients and/or fumes will not affect or modify the adhesive (e.g.

discolouration etc.).

### SAFETY ADVICE

Consult the current EC Safety Data Sheet which is available at any time on our website at [www.ramsauer.at](http://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. This product is not suitable for full surface bonding. The curing time increases with the thickness of the layer. Before using the product in layers with a thickness of more than 15 mm get in

touch with our application engineering department. Acrylates are subject to colour changes during the curing/drying phase due to the nature of the material. The product will have its final colour only after drying 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	630 Montage Kleber diluted with water, 1:1
Concrete, smooth according to formwork	630 Montage Kleber diluted with water, 1:1
Steel DC 04	-
Hot dip galvanised steel	-
High grade steel	-
Zinc	-
Aluminium	-
Aluminium AlMg1	-
Aluminium AlCuMg1	-
Aluminium 6016	-
Aluminium anodised	RP 40
Brass MS 63 Hardness F 37	-
Rigid PVC Kömadur ES	+
PVC plasticised	-
PC Makrolon Makroform 099	-
Polyacrylic PMMA XT 20070 Röhm	-
Polystyrene PS Iroplast	-
ABS Metzoplast ABS 7 H	-
PET	-
PU blend quality	-
Copper	-
Polycarbonate	-
PMMA Röhm sanitary quality	-
Mirrors	-
Natural stone	-

Legend: + = adheres well without a primer  
- = not suitable  
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 is 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).



## QUALITY YOU CAN RELY ON

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