



RAMSAUER®
DICHTSTOFFE

635 KRAFT ELAST KLEBER (Elastic Power Adhesive)

1-component adhesive on a hybrid basis

TECHNICAL DATA

Basis: Hybrid adhesive
Skin-over time: ~ 5 min. (23°C/50 % relative humidity)
Curing time: ~2.8 mm/24 hours (at +23°C / 50 % relative humidity)
Density: ~ 1.04 (EN ISO 1183-1)
Shore hardness: ~ 42 (EN ISO 868)
Shrinkage: ~ 3.6% (EN ISO 10563)
Sag resistance: <3
Tear strength: ~ 8.74 N/mm (ISO 34-1)
Stress at break: ~ 0.68 N/mm² (EN ISO 8339)
Modulus: ~ 0.45 N/mm² (EN ISO 8339)
Elongation at break: ~ 270% (EN ISO 8339)
Temperature resistance: -40°C to +90° C (permanent exposure)
Packaging: 290ml-cartridges, 20 pcs./box
Colour: crystal clear
Storage life: 12 months in original packaging in a cool and dry place

CHARACTERISTICS

635 KRAFT ELAST KLEBER is a virtually odourless, weather-resistant, crystal-clear RTV-1-adhesive on a hybrid basis. After curing, the adhesive remains elastic and boasts excellent permanent adhesion. 635 KRAFT ELAST KLEBER is suitable for a wide variety of indoor applications. It does not contain any silicone, isocyanate or solvents.

APPLICATION

635 KRAFT ELAST KLEBER is suitable for a vast range of applications. It is easy to use, and thanks to its sag-resistance and pastiness it is capable of levelling out unevenness and perfect for filling voids. Suitable for gluing static and vibrating structures. 635 KRAFT ELAST KLEBER is a highly versatile adhesive e.g. for gluing door frames, panels, decorative strips,



window sills, floor mouldings, slabs, wood structures,
insulation materials, etc.

MEETS THE REQUIREMENTS OF IVD INSTRUCTION SHEET

No. 30: Mounting adhesives for gluing and sealing (available in German only)

PROCESSING

635 KRAFT ELAST KLEBER is ready for use and can be applied without any further preparation to any clean and solid substrate which must be free from oil and grease. For optimum adhesion especially to absorbent/porous and primarily alkaline substrates we recommend priming with our Primer 70. Apply the adhesive in beads to the parts to be glued or to the substrate and subsequently join work pieces in a sliding movement, align, press against the substrate, and secure until the adhesive has cured. The product can be applied by means of manual press, compressed air press or battery-driven press. 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 materials used close to the adhesive, their ingredients and/or fumes will not affect or modify the adhesive (e.g. discoloration etc.).

The curing time can be shortened by adding moisture and increasing the temperature.



LIMITATIONS OF APPLICATION

After 635 KRAFT ELAST KLEBER has cured the adhesive can be covered with paint coats according to DIN 52452. In view of the wide variety of paint systems the user must make his own tests. Not approved for natural stone. For gluing mirrors please use our products "640 Dichtkleber" (Sealing Adhesive) or "660 Spiegelkleber" (Mirror Adhesive). Not approved for RC2-glue joints. In case of exposure to UV

radiation or higher temperatures the adhesive may turn yellow or embrittle. For sealing joints with glass or gluing glass exposed to UV radiation we recommend our tested silicone sealants. Get in touch with our application engineering department for this purpose. The product is not approved for application with Plexiglas®.

SAFETY ADVICE

Consult the current EC Safety Data Sheet which is 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 negative effects are ruled out. In case of transparent substrates or relatively wide adhesive joints it is not possible to rule out changes of mechanical properties and/or discolouration e.g. due to UV radiation. Non-ferrous metals may cause discolouration of the adhesive. When gluing full surfaces of vapour-proof substrates one side of the substrate must be moistened (attention: avoid the formation of pools!).

PRIMING TABLE

Glass	+
Tiles	+
Pine wood	-
Concrete, wet-ground	RP 70
Concrete, according to form work	RP 70
Steel DC 04	RP 140 / RP 145
Hot dip galvanised steel	+
High grade steel	+
Zinc	+
Aluminium	+
Aluminium AlMg1	+
Aluminium AlCuMg1	+
Aluminium 6016	+
Aluminium anodised	RP 140 / RP 145
Brass MS 63 hardness F 37	+
Rigid PVC Kömadur ES	RP 100 / RP 105
PVC plasticised	RP 100 / RP 105
PC Makrolon Makroform 099	+
Polyacrylic PMMA XT 20070 Röhm	-
Polystyrene PS Iroplast	RP 100 / RP 105
ABS Metzoplast ABS 7 H	RP 100 / RP 105
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.



QUALITY YOU CAN RELY ON

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