



RAMSAUER®
DICHTSTOFFE

655 KRAFT FIX

(POWER ADHESIVE)

1-component adhesive on a hybrid basis

TESTS, COMPLIANCE WITH STANDARDS

Emicode EC1-PLUS R “very low emission“

TECHNICAL DATA

Basis: 1-component hybrid adhesive – silane terminated polymers
Shore-A-hardness: ~ 75 (ISO 868)
Skin-over time: approx. 5 min. (23°C/50 % relative humidity)
Density: ~ 1.56 (EN ISO 1183-1)
Tear strength (ASTM D 624): ~ 19 N/mm
Temperature resistance: - 30°C to + 90°C (permanent exposure)
Shrinkage: -3%
Consistency: sag-resistant ISO 7390, Profile U20
Packaging: cartridge 290ml, 600ml-foil bags
Colours: grey, white
Storage life: 12 months in original package in a cool and dry place

CHARACTERISTICS

655 KRAFT FIX is a ready for use 1-component sealant on an MS-hybrid basis with high shore hardness and excellent initial tack. 655 KRAFT FIX is neutrally cross-linking and odourless; it does not contain any solvents, silicone or isocyanates. It can be covered with a wide variety of commercially available water-soluble paints (according to DIN 52452). Nevertheless, the vast diversity of paints and coatings on the market makes previous testing indispensable.

APPLICATION

This high performance adhesive opens up a wide range of applications. Thanks to its excellent adhesion properties it permits preparing joints with a wide variety of materials both indoors and outdoors. It is suitable for gluing mirrors.

MEETS THE REQUIREMENTS OF IVD-INSTRUCTION SHEET

As of the date of publication of this data sheet, this IVD-instruction sheet is available in German only.
No. 30: Montageklebstoff für Klebungen und Abdichtungen (Mounting Adhesive for Gluing and Sealing)

PROCESSING

The materials to be sealed must be solid, and free from dust, grease, oil, and separating agents before applying 655 KRAFT FIX. This high performance adhesive adheres extraordinarily well to a wide variety of substrates. Adhesion of

the product must be tested by the user prior to application. In case of poor adhesion use a suitable primer. The product is applied by means of a manual or compressed air press. The curing time can be reduced by supplying additional moisture.

LIMITATIONS OF APPLICATION

In case of special applications and for projects involving natural stone it is imperative to try the specific application in an experiment before use and/or to contact our application engineering department. Liability that mirrors will not be tarnished can be assumed only subject to the condition that the mirror coating is sufficiently thick (50 µm) and free from damage. When gluing mirrors and/or mirror elements take into account the applicable standards and guidelines such as the

Technical Guidelines of the Glazier's Trade (*“Technische Richtlinien des Glaserhandwerks“*) No. 11 Mounting of Mirrors (*“Montage von Spiegeln“*). If you intend to glue coated glass get in touch with our application engineering department. The product is not suitable for gluing aquariums; not suitable for permanently wet areas. If you intend to use the product for gluing or sealing UV-exposed joints with glass or transparent plastics get in touch with our application engineering





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department. ATTENTION: The responsibility for compatibility of the adhesive with the edge seal of glazing, inserted glazing

spacers, and surface coating of the frame structure is with the building components manufacturer.

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. The curing time increases with the thickness of the layer. Before using the 1-component adhesive in layers with a thickness of more than 15 mm get in touch with our application engineering department. Avoid contact with bituminous materials and with materials releasing plasticisers such as butyl, EPDM,

neoprene, insulating paints or bituminous coating materials for sealing basements, swimming pools etc. 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. Extreme fluctuations of temperature, repeated contact with water, high tensile and shear forces, the effects of weather, etc. place high demands on elastic glue joints. The product is not suitable for glue joints in permanently wet areas.

PRIMING TABLE

Glass	+
Tiles	+
Pine wood	+
Concrete, wet-ground	+
Concrete, according to formwork	+
Steel DC 04	+
Hot dip galvanised steel	+
High grade steel	+
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	+
Polyacrylic PMMA XT 20070 Röhm	+
Polystyrene PS Iroplast	+
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.

* In view of countless possible effects on natural stone which are not foreseeable to us, and taking into account the different characteristics of different types of natural stone it is indispensable to conduct comprehensive tests prior to application.

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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