

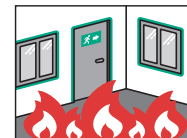


RAMSAUER®

345

LASTING BONDS.

Hitze- und Ölbeständig



1-component neutral silicone sealant

Technical data sheet

Version: 04-2023

Tests:

- Fulfils the French VOC requirement Class A+



1. Mechanical Properties

Basis	Neutral cure oxime silicone sealant
Skin formation time	~ 7 Min. (23°C/50% relative humidity)
Full curing time	~2 mm/24 hours (at +23°C/50% relative humidity)
Density	~ 1.07 (EN ISO 1183-1)
Shore A hardness	~ 39 (DIN EN ISO 868)
Volume shrinkage	~ 6.3% (EN ISO 10563)
Tear propagation resistance	~ 9.1 N/mm (ISO 34-1)
Tensile stress at break	~ 0.60 N/mm ² (DIN EN ISO 8339)
Resistance to high and low temperatures	-50 °C to +250 °C
Application temperature (substrate, environment)	Lower +5°C, upper +35°C
Colours	Black
Packaging	290 ml cartridge, other containers on request
Shelf life of cartridges and foil bags	6 months in original packaging in cool and dry storage conditions
Shelf life of industrial container	6 months, cool and dry in sealed original container

2. Properties

345 Hitze- und Ölbeständig is a permanently elastic, neutral 1-component silicone sealant. After full curing, it is characterised by high oil resistance, temperature resistance up to +250°C and excellent adhesion properties on a wide range of substrates.



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3. Priming table

Key

+	Good adhesion without priming
-	No adhesion
Primer	Recommended primer

Glass	+
Tiles	+
Pine wood	+
Wet ground concrete	+
Concrete, formwork smoothness	+
Steel DC 04	+
Hot-dip galvanised steel	+
Stainless steel	+
Zinc	+
Aluminium	+
Aluminium AlMg1	+
Aluminium AlCuMg1	+
Aluminium 6016	+
Anodised aluminium	+
Brass MS 63 Hardness F 37	+
PVC Kömadur ES	Primer 100 / Primer 105
PVC soft	Primer 100 / Primer 105
PC Makrolon Makroform 099	+
Polyacrylic PMMA XT 20070 Röhm*1	Primer 40
Polystyrene PS Iroplast	Primer 100 / Primer 105
ABS Metzoplast ABS 7 H	Primer 100 / Primer 105
PET	+
PU waste quality	+
Copper	+
Polycarbonate	+
PMMA Röhm sanitary quality	Primer 100 / Primer 105
Mirrors*2	-
Natural stone	-

This table is based on adhesion tests with Rocholl test specimens under laboratory conditions. In practice, the adhesive properties depend on a large number of external influences (weathering, contamination, loads, etc.). Therefore, this table is for guidance only and does not constitute a binding statement. For further information please contact our application engineering department. The tests carried out above only refer to the adhesive properties and have no significance in terms of compatibility with the stated substrates.

*1: Different PLEXIGLAS® types exhibit certain differences in their chemical resistance. Stresses must be expected in some applications. The resulting stresses, in combination with certain agents, can lead to "stress cracking". The duration, temperature and concentration of the acting substance have a fundamental influence on any "stress cracks". When using our products in combination with PLEXIGLAS®, the suitability must therefore be checked in advance.

*2: The compatibility with various mirror coatings by different manufacturers is regularly tested in our laboratory. Advance testing is recommended due to production processes of the various manufacturers, into which we have no insights, and as a function of the existing substrate and bonding variants.

4. Application

345 Hitze- und Ölbeständig is particularly suitable for use in the equipment, automotive and mechanical engineering industries, a variety of technical applications, and industrial production.



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5. Meets the requirements of IVD instruction sheet

No. 35	Sealing and bonding in construction - Systems - Classification - Application
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6. Processing

General instructions: The expiry date of the material must be observed, otherwise the stated mechanical properties of the product can no longer be guaranteed. Observe the ambient temperature and substrate temperature. **Pre-treatment of the adhesion surfaces:** the adhesion surfaces must be load-bearing, dry, and free of dust, grease, and oil. If required, carefully pre-treat the adhesion surfaces using a suitable primer. **Joint design:** For motion compensating joints, the dimensions must be designed to absorb the maximum motion expected. The glazing spacer tape must be made of a heat-resistant material (ceramic fibre tape, type 1040 Brandschutzband). A minimum cross-section of 3x5 mm must be adhered to for the joint. For more details, see the installation instructions for fire-resistant glass. **Application of the sealant:** Working within the application temperature limits, the product must be applied uniformly to the joint avoiding inclusions. If the substrate is pretreated with primer, its flash-off time must be observed. The tooling work must be completed within the stated skin formation time. When reworking, good contact with the adhesive surfaces/joint edges must be ensured (using Ramsauer tooling agent). When using tooling agents, any water streaks that have formed must be removed immediately after sealing, as visual flaws can otherwise be expected.

7. Application restrictions

Caution: If the bond is poor, the substrate must be primed with an adhesive coat. In the case of surfaces painted in white, the elements must be stored upright after sealing to allow for exhaust ventilation – minimum distance 5 cm. In rooms where emulsion paints have been used, it is important to ensure that the coats are completely dry and have flashed off, as the sealant can discolour in combination with the product during grouting or sealing work indoors. Not suitable for contact with petrol and diesel! Permanent contact with lubricants or coolants containing oil can cause the compound to swell. Before applying the sealant, it must be ensured that the building materials touching the sealant are compatible and do not negatively impact on it. Avoid contact with tar and bituminous substrates. Not suitable for use with natural stone or mirrors.

8. Safety instructions

Please refer to the current EC safety data sheets. Data sheets are available at any time from our website at www.ramsauer.eu.

9. Application notes

Good ventilation must be ensured during processing and curing. Due to the large number of possible influences during processing and application, the processor must always carry out a test processing before use. Note the expiry date of the material. 1-component sealants are not suitable for full-surface bonding. The curing speed increases with increasing coating thickness. If the 1-component material is used in coating thicknesses of more than 15 mm, please contact our application engineering department. If the products are stored and/or transported over a longer period of time (several weeks) at higher temperatures/humidity, the shelf life may be reduced or the material properties may change. During application of the NIRO hue, the colour pigment used here can cause visual flaws, dark separating lines, etc., where two silicone layers overlap. This is not a reason for complaint, but a typical product property.



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10. Liability for defects

The information, in particular the suggestions for the processing and use of our products, is based on our knowledge and experience in normal use cases at the time of printing. Depending on the specific circumstances, in particular with regard to substrates, processing and environmental conditions, the results may differ from this information. Therefore the guarantee of a work result or a liability, for whatever legal reasons, can be justified neither from these references, nor from a verbal consultation, unless we are guilty of intent or gross negligence in this respect. Ramsauer guarantees that its products comply with the technical properties specified in the technical data sheets until the expiry date.

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