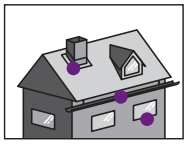

# 600

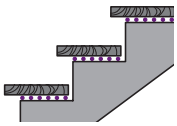
RAMSAUER®

LASTING BONDS.

# Silikon Kleber

**1-component industrial alkoxy-based adhesive**





## Technical data sheet

Version: 09-2024

### Tests:

· Emicode EC1PLUS „very low emissions“

## 1. Technical data

| | |
|---|---|
| Basis | Silicone adhesive – alkoxy-based |
| Skin formation time | ~ 10 Min. (23°C/50% relative humidity) |
| Full curing time | ~ 1.5 mm/24 hours (at +23°C/50% relative humidity) |
| Density | ~ 1.25 (EN ISO 1183-1) |
| Shore A hardness | ~ 40 (DIN EN ISO 868) |
| Volume shrinkage | ~ 7.2% (EN ISO 10563) |
| Tear propagation resistance | ~ 9.5 N/mm (ISO 34-1) |
| Tensile strength/100% | ~ 0.78 N/mm² (DIN 53504-S2) |
| Tensile strength/breakage | ~ 2.37 N/mm² (DIN 53504-S2) |
| Elongation at break | ~ 420% (DIN 53504-S2) |
| Resistance to high and low temperatures | -40°C to +120°C (long-term exposure) |
| Application temperature (substrate, environment) | Lower +5°C, upper +35°C |
| Non-sag property | < 3 mm |
| Colours | Black, white, grey |
| Packaging | 310ml cartridge, other containers on request |
| Shelf life of cartridges and foil bags | 12 months in original packaging in cool and dry storage conditions |

## 2. Properties / applications

600 Silikon Kleber is a neutral alkoxy-based silicone rubber for the strip bonding of wall panels, wood-based materials, tiles, glass, ceramics, metals, concrete and much more. The product is sound-insulating, and UV-resistant, weather-resistant and resistant to high and low temperatures. The adhesive does not contain any corrosive components and therefore does not cause discolouration of brass, copper or metal, which makes it ideally suited for metal, aluminium and structural facades. Due to its excellent resistance to high and low temperatures, the product is a great choice for use in plumbing work. 600 Silikon Kleber remains elastic even after curing and can therefore easily absorb vibration, shocks or thermal elongation.


# 600

RAMSAUER®

LASTING BONDS.

# Silikon Kleber

## 3. Substrate preperation

The adhesion surfaces must be dry, capable of bearing, and free of dust, oil and grease. Pre-cleaning with 828 Grundreiniger is generally recommended on non-absorbent substrates, but compatibility with sensitive surfaces should be checked in advance to avoid surface damage. If required, carefully pretreat the adhesion surfaces using a suitable primer. Sanding with a fine sanding fleece can further improve adhesion on smooth surfaces. Due to the many different coating systems, an adhesion test is recommended before application to painted surfaces.

| Substrate | Preperation |
|---|---|
| Glass | 828 Grundreiniger |
| Tiles | 828 Grundreiniger |
| Pine wood | Dust free |
| Wet ground concrete | Dust free / Primer 70 |
| Concrete, formwork smoothness | Dust free / Primer 70 |
| Steel DC 04 | 828 Grundreiniger / Primer 140 |
| Hot-dip galvanised steel | 828 Grundreiniger |
| Stainless steel | 828 Grundreiniger |
| Zinc | 828 Grundreiniger |
| Aluminium | 828 Grundreiniger |
| Aluminium AlMg1 | 828 Grundreiniger / Primer 140 |
| Aluminium AlCuMg1 | 828 Grundreiniger / Primer 140 |
| Aluminium 6016 | 828 Grundreiniger / Primer 140 |
| Anodised aluminium | 828 Grundreiniger |
| Brass MS 63 Hardness F 37 | 828 Grundreiniger |
| PVC Kömadur ES | 828 Grundreiniger |
| PVC soft | 828 Grundreiniger |
| PC Makrolon Makroform 099 | 828 Grundreiniger |
| Polyacrylic PMMA XT 20070 Röhm*[1] | 828 Grundreiniger |
| Polystyrene PS Iroplast | 828 Grundreiniger / Primer 100 |
| ABS Metzoplast ABS 7 H | 828 Grundreiniger / Primer 100 |
| PET | 828 Grundreiniger |
| PU waste quality | 828 Grundreiniger |
| Copper | 828 Grundreiniger |
| EPDM Semperit E 9614 | 828 Grundreiniger |
| PMMA Röhm sanitary quality | 828 Grundreiniger |
| GRP | 828 Grundreiniger |

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.


# 600

RAMSAUER®

LASTING BONDS.

# Silikon Kleber

## 4. Processing

**General instructions:** The expiry date of the material must be observed, otherwise the properties of the product can no longer be guaranteed. If the products are stored and/or transported over a longer period of time at higher temperatures/humidity, the shelf life may be reduced or the material properties may change. Strong environmental influences (e.g. high temperature, UV exposure, chemical influences such as vapours) can affect the properties of the material to varying degrees. Before applying, the user must ascertain that the building materials (solid, liquid or in gaseous form) are compatible with the sealant in the contact area. Pay attention to the ambient and substrate temperature during application because as excessively high or low temperatures can lead to changes in properties. Due to the large number of possible influences during processing, it is always advisable for the processor to carry out a test processing before use. Good ventilation must be ensured during processing and curing.

**Pre-treatment of the adhesion surfaces:** The substrate must be pretreated in accordance with the instructions in section 3 of this technical data sheet.

**Applying the adhesive:** The 600 Silikon Kleber must be applied evenly and without bubbles into the adhesive joint or onto the adhesive surface while adhering to the processing conditions. When pre-treating the substrate with primer, the flash-off time must be taken into account. It is essential to ensure perfect contact with the adhesive-surfaces or -flanks.

**After-treatment:** When using a tooling agent, apply it fresh, unused and sparingly. Once the joint has been formed, any residue of tooling agent must be removed before it dries, otherwise visual flaws are to be expected.

## 5. Meets the requirements of IVD instruction sheet

Not relevant

## 6. Maintenance and care

Ramsauer sealants and adhesives are manufactured carefully and using the most modern manufacturing processes. This results in high-quality products that, when processed appropriately, enable long-lasting and resistant bonds and joints. However, in order to ensure the functionality of the joints and bonds, it is necessary to check, clean and, if necessary, replace them at regular intervals depending on the loads (chemical, mechanical, thermal, UV radiation) (see also the information sheet “Care and maintenance of joint sealing”).

## 7. Application restrictions

- Not suitable for natural stone adhesion
- Not suitable for bonding mirrors, aquarium and terrarium construction
- Not approved for use in combination with insulating glass edge composite systems
- No adhesion to plastics with low-energy surfaces such as PE, PP or PTFE
- Before use on painted surfaces, it is recommended to carry out preliminary tests
- For white painted surfaces, ensure that the adhesive is sufficiently ventilated (yellow discoloration of the painted surface is possible!).

## 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. 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, with regard to the substrate, processing and environmental conditions, the results may differ from our information. No warranty or liability claim for any reason whatsoever arises from these instructions or from any instructions issued verbally. Ramsauer guarantees that its products comply with the technical properties specified in the technical data sheets until the expiry date. Product users must consult the latest technical data sheet, which can be requested from us. Our current General Terms and Conditions apply; you can download these at any time from our homepage at **www.ramsauer.eu**. On publication of a new version/ revision of the technical data sheet, all previous versions of the respective product lose their validity.

Ramsauer GmbH & Co KG • Alte Bundesstraße 147 • 5350 Strobl, Austria • Email: office@ramsauer.eu • Tel.: +43 (0)6135 8205-0 • www.ramsauer.eu