



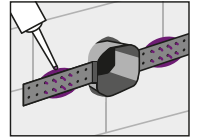
RAMSAUER®

652

LASTING BONDS.

Tech Fix

1-component SMP-based adhesive



Technical data sheet

Version: 07-2024

Tests:

- Emission EC1 Plus "very low emissions"
- Fulfils the French VOC requirement Class A+



1. Mechanical Properties

Basis	Hybrid adhesive - MS polymer
Skin formation time	~ 8 Min. (23°C/50% relative humidity)
Full curing time	~ 2 mm/24 hours (at +23°C/50% relative humidity)
Density	~ 1.53 (EN ISO 1183-1)
Shore A hardness	~ 73 (DIN EN ISO 868)
Volume shrinkage	~ 3.5% (EN ISO 10563)
Tear propagation resistance	~ 21 N/mm (ISO 34-1)
Tensile shear strength after 2h	~ 0.98 N/mm ² (DIN EN ISO 17178)
Tensile shear strength after 3h	~ 1.37 N/mm ² (DIN EN ISO 17178)
Tensile stress at break	~ 2.7 N/mm ² (DIN 53504-1 S2)
Module	~ 2.4 N/mm ² (DIN 53504-1 S2)
Elongation at break	~ 300% (DIN 53504-1 S2)
Resistance to high and low temperatures	-40°C to +90°C (long-term exposure)
Application temperature (substrate, environment)	Lower +5°C, upper +35°C
Colours	White
Packaging	310 ml cartridge, other containers on request
Shelf life of cartridges	12 months in original packaging in cool and dry storage conditions

2. Properties

652 TECH FIX is a 1-component adhesive on SMP basis with a high shore hardness. 652 TECH FIX is an odourless, silicone-free and high-performance adhesive that is immediately ready-for-use featuring fast initial setting and excellent tensile shear strengths after just 2 hours. The special material properties guarantee economical and clean processing. The product exhibits excellent adhesion on many plastics, metals, concrete, tiles, natural stone, masonry and wood (including damp substrates). Due to the odourless properties of our 652 TECH FIX, our material is a great choice for use in interior seals in inhabited areas. 652 TECH FIX is paint-compatible according to DIN 52452 Part 4 and can be plastered over. The supplied sealing cap stops the curing process meaning that the material can be reused several times.



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652

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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	Primer 140
Aluminium 6016	Primer 140
Anodised aluminium	+
Brass MS 63 Hardness F 37	+
PVC Kömadur ES	+
PVC soft	+
PC Makrolon Makroform 099	+
Polyacrylic PMMA XT 20070 Röhm*1	+
Polystyrene PS Iroplast	+
ABS Metzoplast ABS 7 H	Primer 100
PET	+
PU waste quality	Primer 100
Copper	+
Polycarbonate	Primer 40
PMMA Röhm sanitary quality	+
GRP	+
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

652 TECH FIX is ideally suited for a wide range of electrical installation and building services tasks. The material is specially designed for moving flush-mounted sockets, and fixing installation hoses and cable conduits. The adhesive is also suitable for bonding skirting boards and light strips, wall panels, company signs, PVC rigid foam pictures, acrylic glass back panels and polystyrene profiles.



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652

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5. Meets the requirements of IVD instruction sheet

No. 12	Overpaintability of motion-compensating sealants in building construction. Requirements and impacts.
No. 16	Perimeter joints in dry construction. Possible applications of sprayable sealants
No. 23	Sealing joints and connections to natural stone
No. 29	Joint work in painting and decorating trade
No. 35	Sealing and bonding in construction - Systems - Classification - Application

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. **Pretreatment of the adhesion surfaces:** The adhesion surfaces must be load-bearing, dry, and free of dust, grease, and oil. The user must test the adhesion of the adhesive before use. If required, carefully pretreat the adhesion surfaces using a suitable primer. **Bonding:** After appropriate pretreatment/cleaning of the substrate, apply the adhesive in vertical beads or spots on one side of the substrate; press onto the adherend/substrate and align within the specified skin formation time. Any contamination caused by the adhesive must be removed immediately. Our "504 REINIGUNGSTÜCHER" are suitable for this.

7. Application restrictions

Caution: 652 TECH FIX is not suitable for underwater joints in swimming baths and aquariums. Not suitable for glazing work. Avoid contact with materials containing bitumen and plasticisers, e.g. butyl, EPDM, neoprene, insulating paints or bituminous coating, etc. Before applying, the user must ascertain that the building materials (solid, liquid or in gaseous form) are compatible with the adhesive in the contact area. High substrate or base temperatures during processing can lead to impairments of the mechanical properties. When using the product on low energy plastics, such as PE, PP, PTFE etc., appropriate substrate pretreatment must be carried out (e.g., corona or plasma pretreatment).

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. For full-surface bonding and if the 1-component material is used in coating thicknesses of more than 15 mm, please contact our application engineering department. The curing speed increases with increasing coating thickness. 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.



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652

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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, 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.

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