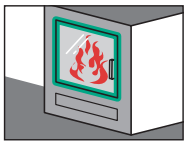
330

Hitzefest

1-component acetic cure silicone sealant

RAMSAUER®

LASTING BONDS.



Technical data sheet

Version: 04-2023

Tests:

· Fulfils the French VOC requirement Class A+

1. Mechanical Properties

Basis	Acetic silicone sealant
Skin formation time	~ 10 Min. (23°C/50% relative humidity)
Full curing time	~3 mm/24 hours (at +23°C/50% relative humidity)
Density	~ 1.20 (EN ISO 1183-1)
Shore A hardness	~ 35 (DIN EN ISO 868)
Volume shrinkage	~ 4.5% (EN ISO 10563)
Tear propagation resistance	~ 7.02 N/mm (ISO 34-1)
Tensile stress at break	~ 0.58 N/mm² (DIN EN ISO 8339)
Module	~ 0.53 N/mm² (EN ISO 8339)
Elongation at break	~ 120% (DIN EN ISO 8339)
Resistance to high and low temperatures	-50°C to +300°C (long-term exposure)
Application temperature (substrate, environment)	Lower +5°C, upper +35°C
Colours	Brown
Packaging	310 ml cartridge, other containers on request
Shelf life of cartridges and foil bags	12 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

330 Hitzefest is an acetic cure silicone rubber, characterised by its good adhesive strength and resistance to high and low temperatures. The material is resistant to heat exposure up to +300°C. After complete curing, the product is odourless, physiologically harmless and inert.

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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	Primer 140
Stainless steel	-
Zinc	-
Aluminium	+
Aluminium AlMg1	Primer 140
Aluminium AlCuMg1	+
Aluminium 6016	Primer 140
Anodised aluminium	Primer 140
Brass MS 63 Hardness F 37	-
PVC Kömadur ES	Primer 100
PVC soft	-
PC Makrolon Makroform 099	-
Polyacrylic PMMA XT 20070 Röhm*[1]	-
Polystyrene PS Iroplast	Primer 100
ABS Metzoplast ABS 7 H	-
PET	+
PU waste quality	+
Copper	-
Polycarbonate	-
PMMA Röhm sanitary quality	-
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

330 Hitzefest is suitable for sealing single glazing and insulating glazing in wooden and aluminium windows and for sealing expansion and butt joints in structural aluminium facades. The perfect choice for joints exposed to heat load and industrial applications.

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5. Meets the requirements of IVD instruction sheet

No. 11	Explanations of technical terms used in "fire protection" from the point of view of sealants or joints sprayed with sealant.

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. Substrates containing tar and bitumen are unsuitable as adhesion substrates. **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 "Brandschutzband 1040"). 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: Before applying the sealant to substrates (surfaces) that have been pre-treated with water-soluble paint systems, it is important to carry out bonding tests. If the bond is poor, the substrate must be primed with a primer coat. A further bonding test is recommended. Before application, it must be ensured that all building materials (solid, liquid or gaseous) coming into contact with the silicone are compatible and do not have a negative impact (discolouration, curing problems, etc.). Due to the curing system, the material may only be used on acid-resistant surfaces. The product is not suitable for grouting natural stone. Not suitable for aquarium construction and drinking water applications. Avoid contact with materials containing bitumen and plasticisers.

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.

Product users must consult the latest technical data sheet, which can be requested from us. Our current General Terms and Conditions apply, which you can download 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.

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