



# 600 SILIKON KLEBER RAMSAUER®

## DICHTSTOFFE

**(Silicone adhesive)**

**1-component industrial adhesive on an amine basis**

### TECHNICAL DATA

Basis: amine system  
 Skin over time: ~ 13 min. (23°C/50% relative humidity)  
 Curing rate: ~3 mm/24 hours (at+23°C / 50 relative humidity).  
 Density: ~1.35 g/cm<sup>3</sup> (DIN 52451)  
 Shore hardness: ~29 (A DIN 53505)  
 Shrinkage: ~6%  
 Tear strength: approx. 8 N/mm (ASTM D624 Form B)  
 Elongation at tear: ~800 % (DIN 52455)  
 Modulus: ~0.30 N/mm<sup>2</sup> (100 % elongation)  
 Shear strength: ~ 1,25 N/mm<sup>2</sup> (DIN 52455-3)  
 Tensile strength: ~1,4 N/mm<sup>2</sup> (DIN52455)  
 Temperature resistance: - 40°C to + 150°C (short time up to +180°C)  
 Processing temperature (substrate, environment): + 5°C to + 35°C  
 Not suitable for being covered with a paint coat  
 Storage life: 12 months in a cool and dry place  
 Colours: grey  
 Packaging: 310ml-cartridges; alternative packaging upon request

### CHARACTERISTICS

Ramsauer 600 SILIKON KLEBER is a quickly curing silicone rubber for gluing wood-based materials, tiles, glass, ceramics, metals, concrete, etc. 600 SILIKON KLEBER is sound absorbing, UV-, frost- and heat resistant. The special curing system of this product prevents discoloration on brass, copper and other metals. Therefore it is perfectly suitable for the construction of metal and aluminium structures and facade construction. This adhesive adheres extremely well to alkaline substrates. 600 SILIKON KLEBER remains elastic even after curing, and therefore it is capable of absorbing vibrations etc.



very well.

### APPLICATION

600 SILIKON KLEBER is highly suitable for gluing a wide variety of substrates, e.g. for stairs, for fastening door

claddings, as well as for gluing and sealing components subjected to high mechanical stress.

### MEETS THE REQUIREMENTS OF IVD-INSTRUCTION SHEET

As of the date of publication the IVD Instruction Sheet mentioned below is available in German only.  
 No. 30: Montageklebstoff für Klebungen und Abdichtungen (Mounting adhesives for gluing and sealing)

### PROCESSING

Apply the product only to structurally flawless and dry substrates which must be free from dust, grease, and oil. In order to ensure complete curing of the adhesive always apply

it in strips. It is recommended to secure the parts to be glued for 12 hours in order to support the bonding process.

### LIMITATIONS OF APPLICATION

A minimum cross-section of sealant of 5 mm is imperative. The product is not compatible with nitrocellulose and PU paint systems. Before using the product on coated substrates it is imperative to conduct proper tests. In case of areas covered with white paint coats the adhesive must have sufficient access of air for curing (yellow discolouration of the painted surface is possible). When gluing natural stone contamination

of edges may occur - use our special product "440 NATURSTEIN" (Natural Stone) for this purpose. This compound is not suitable for gluing mirrors or for the construction of aquariums and terrariums. Before using the sealant the user must make sure that it is compatible with all building materials and substances with which it will get in contact. With respect to any building materials which will be



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used subsequently close to the adhesive/sealant it is imperative to make sure in advance that their ingredients

and/or cleavage products will not affect or modify the sealant.

### SAFETY ADVICE

Consult the current EC Safety Data Sheet which is available at any time on our website at [www.ramsauer.at](http://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. 1-component silicone sealants are not suitable for full surface bonding. The curing time increases with the thickness of the layer. Before

using the 1-component silicone sealant in layers with a thickness of more than 15 mm get in touch with our application engineering department. 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.

### PRIMING TABLE

Glass	+
Tiles	+
Pinewood	RP 70
Concrete, wet-ground	RP 70
Concrete, smooth according to formwork	RP 70
Steel DC 04	+
Hot dip galvanised steel	+
High grade steel	RP 140 / RP 145
Zinc	+
Aluminium	+
Aluminium AlMg1	+
Aluminium AlCuMg1	+
Aluminium 6016	+
Aluminium anodised	+
Brass MS 63 Hardness F 37	-
Rigid PVC Kömadur ES	RP 100 / RP 105
PVC plasticised	+
PC Makrolon Makroform 099	-
Polyacrylic PMMA XT 20070 Röhm	RP 100 / RP 105
Polystyrene PS Iroplast	+
ABS Metzoplast ABS 7 H	+
PET	+
PU blend quality	+
Copper	RP 40
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.

### LIABILITY FOR DEFECTS

The information provided including but not limited to the proposals for processing and using our products is based on 600 Silikon Kleber / Version: 02/16 Page:2 Supersedes version: 01/16  
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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](http://www.ramsauer.at).



## **QUALITY YOU CAN RELY ON**

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