



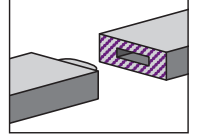
RAMSAUER®

620

LASTING BONDS.

Konstruktions Kleber Rapid

1-component polyurethane-based industrial adhesive



Technical data sheet

Version: 07-2022

Tests:

- Tested in accordance with DIN EN 204 - D4
- Tested in accordance with WATT 91



1. Mechanical Properties

Basis	Polyurethane-based adhesive
Film properties of the cured film	Viscoelastic
Viscosity	Medium viscosity/pasty (at +20°C)
Skin formation time, dry	~ 5 Min. (+20°C/50% relative humidity)
Skin formation time, wet	~ 2 Min. (+20°C/sprayed with water mist)
Functional strength	~ 15 min. (at +20°C)
Density	~ 1.52 (EN ISO 1183-1)
Curing speed	~ 2.5mm (+20°C/50% relative humidity)
Adhesive strength	~ 7.6 N/mm ² (DIN EN 14257 - WATT 91)
Application quantity (for each substrate)	~ 150 - 300 g/m ²
Minimum processing temperature	+5°C
Resistance to high and low temperatures	-30°C to +110°C (long-term exposure)
Colour	Beige
Packaging	310 ml cartridge, other containers on request
Shelf life of cartridges	12 months in original packaging in cool and dry storage conditions
Filling weight	~ 470 g

2. Properties

620 KONSTRUKTIONEN KLEBER RAPID cures under the influence of moisture to form a viscoelastic and solvent-free adhesive joint. The moisture contained in the air or in the parts to be bonded may be sufficient for this. However, moisture is normally added by spraying on water. Analysis of the influence of temperature and humidity on the strength of the fully cured bonds should be carried out specifically for the application where needed. Higher humidity and higher temperatures accelerate the curing process. They therefore influence the shelf life, "open time" and curing time of the adhesive. The times given in this data sheet are therefore only guidelines and may vary depending on the actual conditions. Following curing 620 KONSTRUKTIONEN KLEBER RAPID is sandable and paintable.

3. Priming table



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4. Application

620 KONSTRUKTIONEN KLEBER RAPID supports a wide variety of assembly bonding applications. The adhesive exhibits excellent adherence on pretreated metals such as galvanised steel, primed steel, anodised aluminium, thermosets and thermoplastic materials, wood materials and cement-bound materials. Suitable for bonding natural stone given professional use. Suitable for bonding corner connectors in aluminium window and door construction work. 620 KONSTRUKTIONEN KLEBER RAPID can also be used for joint bonding of boards of panels in woodworking, window and front door building applications.

5. Meets the requirements of IVD instruction sheet

No. 30	Assembly adhesive for bonding and sealing
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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. **Pretreatment of the adhesion surfaces:** The adhesion surfaces must be load-bearing, dry, free of dust, grease, oil and separating agents. Depending on the material surface, a check should be performed to establish whether the bonding results can be improved by sanding or priming. **Bonding:** After pretreating the substrate (observe flash-off time), a bead of adhesive is applied to one side of one of the parts to be joined. For non-absorbent materials (material moisture <8%), the adhesive must be moistened with water; this is the only way to achieve complete curing. The workpieces to be bonded must be assembled and aligned within the skin forming time. The parts are then fixed or pressed until functional strength is achieved. Any leaking adhesive must be removed immediately while fresh. Cured adhesive can only be removed mechanically.

7. Application restrictions

Caution: If the bond is poor, the substrate must be primed with a primer coat. A further bonding test is recommended. Not suitable for contact surfaces containing tar and bitumen. Not suitable for bonding mirrors, aquarium and terrarium construction. Before using the sealant, the user must rule out incompatibilities with other building materials in the contact area. Please clarify in advance, for building materials that will subsequently be applied in the area of the adhesive/sealant, that their ingredients or cleavage products of these materials cannot impair, or change the properties of, the sealant. There is a risk of discolouration in case of UV exposure. Not suitable for PE, PP, PA, PTFE, substrates containing oil, wax and bitumen or similar. Due to the large number of possible materials and possible differences in adhesion behaviour, a bonding test is required before use in production.

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.



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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. If the products are stored and/or transported over a longer period of time (several weeks) at elevated temperature/humidity, the shelf life may be reduced or the material properties may change. Cured adhesive can only be removed mechanically

10. Liability for defects

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