

622 2-K-PU KLEBER

2-Component-PUR-Reaction Resin Adhesive



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TESTS, COMPLIANCE WITH STANDARDS

Meets the French VOC-requirements for Class A+

TECHNICAL DATA

Basis: 2-component PUR reaction resin adhesive

Colour comp. A: white

Colour comp. B: beige

Colour of final product: beige

Density: 1.52 g/cm³ (EN 542)

Shore-D-hardness: ~ 85 (DIN 53505)

Viscosity: low viscosity, pasty

Mixing ratio: 1:1

Pot life: ~ 60 min. (+20°C)

Processing time of cartridge with static mixer: ~ 30 min. (+20°)

Functional strength: after ~ 6 Std. (+20°C)

Curing time: up to 75 % cured after 24 hours (at +20°C/50% relative humidity)

Final strength: after approx. 7 days (at +20°C)

Minimum processing temperature: +7°C

Tensile shear strength (DIN EN 1465), aluminium/aluminium, 0.2mm joint:

- at +20°C: 18.0 N/mm²
- at +80°C: 9.0 N/mm²

Quantity applied: ~ 20g per corner bracket

Packaging: hobbocks; drums; 2x310ml side-by-side-cartridge (900g net weight)

Equipment for work: Compressed air press RM62; manual press RH62

Storage conditions/life: 12 months in original closed container; to be stored only in tightly shut original containers in a dry place at +15°C to +25°C without direct exposure to sunlight.



CHARACTERISTICS

- Tough glue joint
- Solvent-free
- Slump-resistant, the product does not drip
- High weather resistance
- Coatable with a wide variety of paint systems
- Suitable for subsequent powder-coating (max. 30 min. / +230°C)
- Achieves durability class D4 according to DIN EN 204 when gluing wood.
- Convenient application by means of manual press or compressed air press

APPLICATION

622 2-K-PU-KLEBER is a reaction adhesive for gluing corner joints in window and door manufacturing. Furthermore, a solid structural bond can be achieved between a wide range of combinations of materials, e.g. in the construction of vehicle

bodies. The adhesive 622 2-K-PU-KLEBER is highly suitable for gluing aluminium, glass-reinforced plastics, and many other materials. The product is also suitable for the renovation of joints of gypsum fibre boards.

PROCESSING

The surfaces of the substrates to be glued must be dry and free from dust, grease, oil, and separating agents. Depending on the surface material it must be determined whether bonding can be improved by grinding or priming. Polyolefins (such as e.g. PE or PP) cannot be glued without pre-treatment (e.g. plasma or corona treatment). In case of rigid PS surfaces, priming is generally recommended. The temperature of materials has a considerable effect on reactivity and dosing

behaviour. At high temperatures the compounds move faster and dosing can be achieved in considerably less time. When temperatures are low (<+7°C) heat cartridges evenly up to a maximum of +35°C. Screw the static mixing pipe onto the open cartridge and place the cartridge in a suitable cartridge press. Avoid overload on the side-by-side-cartridge by avoiding inlet forces above 3.6 kN. When operating our compressed air press "RM62" at an inlet pressure of 6.8 bar, a

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Supersedes Version:

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maximum of 2.2 kN is reached and proper mixing is ensured. Do not use the first ~ 20g of mixed adhesive (approx. the size of a walnut) for bonding to be on the safe side. Apply the mixed adhesive through the static mixer within the processing time directly onto the section or surface to be glued and join the parts. After joining, fix or press the parts until the functional strength is reached. Remove any oozing adhesive immediately while it is fresh. After the end of work the static mixer remains on the cartridge unit; replace the static mixer when re-starting work; remove any cured adhesive from the cartridge nozzle. Again remove the first 20g of adhesive.

Gluing of aluminium, copper, brass requires chemical treatment or painting of surfaces. These materials cannot be glued durably with adequate ageing resistance unless the adherent surfaces have been prepared adequately. In view of the wide variety of aluminium surfaces and characteristics we generally recommend obtaining sufficient information from the supplier in order to arrange for the optimum preparation for perfect bonding. Adequate suitability testing is recommended. When gluing high-grade steel, efficient cleaning and

degreasing are imperative. Galvanised sheet metal must be protected from long-term effects of humidity. It must be ruled out that any moisture can reach the adherent surface. Where permanent effects of humidity are to be expected the glued joints/surfaces must be additionally sealed/protected by means of suitable sealants. Powder-coated surfaces containing PTFE cannot be glued reliably without pre-treatment (e.g. plasma treatment). Prior to gluing materials with different linear thermal expansion coefficients it is imperative to consider the expected long-term behaviour of the bond, particularly when exposed to fluctuating temperature ranges. When gluing solid wood the adhesive should be applied to both adherent surfaces. The pressing force should be $> 1\text{N/mm}^2$. When gluing solid wood for outdoor applications it is imperative to conduct adequate experiments depending on the type of wood, level of weathering, surface protection and joint dimensions in order to achieve optimum durable bonding. When exposed to UV-radiation the cured sealant will show discolouration. However, the strength of the cured glue joint remains unchanged.

SAFETY ADVICE

Consult the current EC Safety Data Sheet which is available at any time on our website at www.ramsauer.at. The product should be used by adequately trained staff of specialised companies.

GENERAL ADVICE

Pot life, processing times, and the pressing and fixing times required in each case can be determined accurately only through your own experiments since they are affected to a

high degree by materials, temperature, quantity prepared, quantity applied, as well as other criteria. The user should add safety margins to the guideline values stated above.

CLEANING

Fresh adhesive which has not cured yet can be removed using e.g. our universal cleaning tissues "Universal Reinigungstücher 504". The cured adhesive can be removed by mechanical means only.

LIABILITY FOR DEFECTS

The information provided including but not limited to the proposals for processing and using our products is based on our knowledge and experience, usually at the time of going into print. The results of work may deviate from this information depending on the specific circumstances, in particular with respect to substrates, processing and environmental conditions. Therefore, neither this information nor any oral counselling shall constitute warranty or give rise to any liability on whatever legal ground for any specific result

of work, unless we acted intentionally or by gross negligence. 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.



QUALITY YOU CAN RELY ON

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