

625 Pur Leim

Polyurethane glue



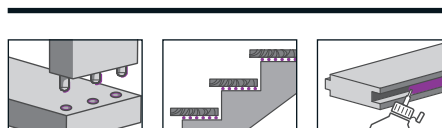
Technical data sheet

Version: 10-2026



Tests:

- Stress group D4 according to EN 204, water resistant



Tested for
waterproof D4
bonding



Grindable

1. Technical data

Basis	1-component polyurethane glue
Density	~ 1,13 g/cm ³
Viscosity at +20°C	~ 10500 ±3500 mPa.s
Dry content	100%
Pot life	~ 16 min. (+20°C)
Pressure	~ 60 min. (at +20°C)
Curing time	After 24 hours (at +20°C)
Final strength	After approx. 7 days (at +20°C)
Water resistance	Very good
Resistance to high and low temperatures	-40 °C to +100 °C
Consumption	120 – 250 g/m ² (depending on the material)
Shelf life	12 months in original packaging in cool and dry storage conditions
Packaging	750 g bottle

2. Properties / applications

625 Pur Leim is a polyurethane-based 1-component adhesive. Curing process via air humidity. 625 Pur Leim is essentially suitable for waterproof bonding of wood as per DIN EN 204, stress class D4 and of insulating panels (polyurethane foam, polystyrene rigid foam, etc.) through to wood, steel, aluminium sheet, concrete and other materials commonly used in construction.

3. Substrate pre-treatment

The adhesion surfaces must be dry, capable of bearing, and free of dust, oil and grease. Pre-cleaning with 828 Grundreiniger is generally recommended for non-absorbent substrates; however, for sensitive surfaces, compatibility should be verified beforehand to avoid surface damage. If necessary, carefully pretreat the bonding surfaces with a suitable primer. Lightly sanding smooth surfaces with a fine abrasive pad can further improve adhesion. Due to the wide variety of coating systems available, an adhesion test is recommended prior to application on painted surfaces.

625 Pur Leim

4. Application notes/restrictions

• **Caution:** 625 Pur Leim must not be used in toys or baby products that children can put in their mouths.

5. Processing

General instructions: The expiry date of the material must be observed, otherwise the properties of the product can no longer be guaranteed. If the products are stored and/or transported over a longer period of time at higher temperatures/humidity, the shelf life may be reduced or the material properties may change. Strong environmental influences (e.g. high temperature, UV exposure, chemical influences such as vapours) can affect the properties of the material to varying degrees. Before applying, the user must ascertain that the building materials (solid, liquid or in gaseous form) are compatible with the sealant in the contact area. Pay attention to the ambient and substrate temperature during application because as excessively high or low temperatures can lead to changes in properties. Due to the large number of possible influences during processing, it is always advisable for the processor to carry out a test processing before use. Good ventilation must be ensured during processing and curing.

Preparation of the adhesion surfaces: The substrate must be pretreated in accordance with the instructions in section 3 of this technical data sheet.

Application: 625 Pur Leim is applied on one side with a brush or smoothing tool. If neither surface is porous, atomised water (up to 10 g/m²) is sprayed on the adhesive surface. Join the two materials within the pot life. Apply a pressure of 5daN/cm² for bonding wood on wood. After joining other materials, apply maximum and uniform pressure to the surface without causing a permanent change in the shape of the materials.

The curing time depends on the temperature. For this reason, check the following in advance:
 If the temperature is below +20°C, maintain or increase the time during which pressure is applied
 If the temperature is above +20°C, observe the pot life of the adhesive.
 Poor bonding results can otherwise occur.

Cleaning: Clean the processing tools with MEK or acetone after processing, if non-polymerised compound is still present. Mechanical removal is necessary after polymerisation.

Pressure application time depends on the temperature:

Temperature		Pressure application time	
Adhesive + wood	Pressure application temperature	With water	Without water
+20°C	+20°C	40 minutes	55 minutes
+20°C	+30°C	30 minutes	40 minutes
+20°C	+40°C	20 minutes	30 minutes
+20°C	+50°C	14 minutes	22 minutes
+20°C	+60°C	9 minutes	15 minutes
Test material: 3 mm balsa wood, consumption: ~150 g/m ²			

6. 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**.

7. Liability for defects

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