



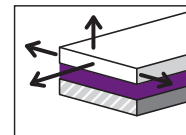
RAMSAUER®

635

**LASTING
BONDS.**

Kraft Elast Kleber

1-component hybrid adhesive



Technical data sheet

Version: 10-2023

Tests:

- Emicode EC1^{PLUS} "very low-emission"
- Fulfills the French VOC requirement Class A+



1. Mechanical Properties

Basis	Hybrid adhesive - MS polymer
Skin formation time	~ 4 Min. (23°C/50% relative humidity)
Full curing time	~2 mm/24 hours (at +23°C/50% relative humidity)
Density	~ 1.04 (EN ISO 1183-1)
Shore A hardness	~ 26 (DIN EN ISO 868)
Volume shrinkage	~ 4% (EN ISO 10563)
Tear propagation resistance	~ 11.5 N/mm (ISO 34-1)
Tensile stress at break	~ 0.74 N/mm ² (DIN EN ISO 8339)
Module	~ 0.47 N/mm ² (EN ISO 8339)
Elongation at break	~ 280% (DIN EN ISO 8339)
Resistance to high and low temperatures	-40°C to +90°C (long-term exposure)
Application temperature (substrate, environment)	Lower +5°C, upper +35°C
Colours	Crystal-clear
Packaging	290 ml cartridge, other containers on request
Shelf life of cartridges	12 months in original packaging in cool and dry storage conditions

2. Properties

635 Kraft Elast Kleber is a virtually odourless, weather-resistant, transparent, hybrid RTV-1 adhesive. After curing, the adhesive remains elastic and exhibits excellent permanent properties. 635 Kraft Elast Kleber is suitable for many interior applications and is free from silicone, isocyanate and solvents.



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3. Priming table

Key

+	Good adhesion without priming
-	No adhesion
Primer	Recommended primer

Glass	+
Tiles	-
Pine wood	Primer 70
Wet ground concrete	+
Concrete, formwork smoothness	+
Steel DC 04	Primer 140
Hot-dip galvanised steel	+
Stainless steel	+
Zinc	+
Aluminium	+
Aluminium AlMg1	+
Aluminium AlCuMg1	+
Aluminium 6016	Primer 140
Anodised aluminium	+
Brass MS 63 Hardness F 37	+
PVC Kömadur ES	Primer 100
PVC soft	Primer 100
PC Makrolon Makroform 099	+
Polyacrylic PMMA XT 20070 Röhm*1	-
Polystyrene PS Iroplast	Primer 100 / Primer 105
ABS Metzoplast ABS 7 H	Primer 100 / Primer 105
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

635 Kraft Elast Kleber supports a very wide range of applications. It is easy to work with and its stable and paste-like properties mean that unevenness can be evened out and voids easily filled. Suitable for bonding static and vibrating constructions. 635 Kraft Elast Kleber supports versatile use, e.g., for bonding door frames, panels, trims, window sills, skirting boards, boards, wooden structures, insulation materials and much more.



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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 bonding surfaces:** 635 Kraft Elast Kleber is ready for use and can be used without further preparation. The adhesion surfaces must be dry, capable of bearing, and free of dust, oil and grease. If required, carefully pretreat the adhesion surfaces using a suitable primer. We recommend priming with our Primer 70 adhesive coating for optimum adhesion, especially on absorbent/porous, mainly alkaline substrates. **Processing:** Apply beads of adhesive to the parts to be bonded or to the substrate; then push the workpieces together, align, press on and fix in place until cured. Use a manual, pneumatic or battery sealant gun for processing. Compatibility with various coatings, e.g., paints, varnishes, plastics, etc., must be checked prior to application or must be ensured with the sealant. Please clarify in advance, for materials that are processed in the area of the adhesive, that their ingredients or vapours do not impair or change the adhesive (e.g., discolouration etc.). Additionally adding moisture and higher temperatures can shorten the curing time.

7. Application restrictions

Caution: After curing, 635 Kraft Elast Kleber is coatable in line with DIN 52452. Due to the large number of different paint systems, in-house tests must be carried out. Not approved for natural stone. Please use our products 640 Dichtkleber and/or 660 Spiegelkleber to bond mirrors. Not approved for RC2 bonding work! Yellowing and embrittlement is possible if exposed to UV radiation and higher temperatures. For glass seals/bonded joints exposed to UV, we recommend our approved silicone sealants. Please contact our application engineering department for details. Not approved for use with Plexiglas®.

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.

Occupational health and safety: Avoid swallowing, prolonged or repeated contact with the skin. Keep out of the reach of children. Request a safety data sheet!

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 higher temperatures/humidity, the shelf life may be reduced or the material properties may change. Prior to processing, the user must ensure that the components (gaseous, liquid or solid) coming into contact with the sealant/adhesive are compatible and that no damage or impairments can be caused. In the case of translucent substrates or wider bonded joints, changes to the mechanical properties and/or discolouration due to, e.g., UV radiation cannot be ruled out. Non-ferrous metals can cause discolouration of the adhesive. For full-surface bonding of vapour-tight substrates, one bonding side must be moistened (caution: avoid accumulations of water!).



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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, with regard to the substrate, processing and environmental conditions, the results may differ from our information. No warranty or liability claim for any reason whatsoever arises from these instructions or from any instructions issued verbally. 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; you can download these 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.