

# 640 Dicht Kleber

## Hybrid adhesive



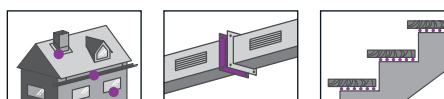
### Technical data sheet

Version: 07-2025



#### Tests:

- EMICODE EC1<sup>PLUS</sup> "very low emissions"
- VOC test IAC-EU
- Fulfills the French VOC requirement Class A+
- DIN EN ISO 846, Method "A"
- Tested for break-in-resistant RC2 bonding
- Suitable for use in the foodstuffs industry acc. to ISEGA certificate 62018 U24
- LABS conformity: VDMA 24364-S-L
- Listed on baubook



Highly UV & weathering resistant



Highly elastic and vibration inhibiting



Approved for foodstuffs



Approved RC2 bonding

## 1. Technical data

|                                                  |                                                                                                    |
|--------------------------------------------------|----------------------------------------------------------------------------------------------------|
| Basis                                            | Hybrid adhesive - MS polymer                                                                       |
| Skin formation time                              | ~ 8 Min. (23°C/50% relative humidity)                                                              |
| Full curing time                                 | ~ 2.5 mm/24 hours (at +23°C/50% relative humidity)                                                 |
| Density                                          | ~ 1.47 (EN ISO 1183-1)                                                                             |
| Shore A hardness                                 | ~ 44 (DIN EN ISO 868)                                                                              |
| Volume shrinkage                                 | ~ 2.6% (EN ISO 10563)                                                                              |
| Tear propagation resistance                      | ~ 13.2 N/mm (ISO 34-1)                                                                             |
| Tensile strength/100%                            | ~ 1.2 N/mm <sup>2</sup> (DIN 53504-S2)                                                             |
| Tensile strength/breakage                        | ~ 2.1 N/mm <sup>2</sup> (DIN 53504-S2)                                                             |
| Elongation at break                              | ~ 400% (DIN 53504-S2)                                                                              |
| Resistance to high and low temperatures          | -40°C to +110°C (long-term exposure)                                                               |
| Application temperature (substrate, environment) | Lower +5°C, upper +35°C                                                                            |
| Non-sag property                                 | < 3 mm                                                                                             |
| Colours                                          | White, anthracite, black and grey                                                                  |
| Packaging                                        | 310 ml cartridges, mini foil bag with 80 ml, and foil bag with 600 ml, other containers on request |
| Shelf life of cartridges and foil bags           | 12 months in original packaging in cool and dry storage conditions                                 |

## 2. Properties / applications

640 Dicht Kleber is free from silicone, plasticisers, solvents and isocyanates and does not contain CMRs. It is UV and weathering resistant, impresses with its very good resistance to high and low temperatures. The adhesive is virtually odourless after curing and meets the strict requirements of EMICODE EC1<sup>PLUS</sup> "very low-emissions". Thanks to the supplied screw cap, the adhesive can be used multiple times. Suitable for interior and exterior applications. The product is supplied in an innovative cartridge made of recycled material and can be recycled even more effectively thanks to a special NIR marker. Suitable for break-in-resistant RC2 bonding. The extraordinary adhesion range enables lasting joints and bonds in various materials for interior and exterior applications. 640 Dicht Kleber can be used to seal joints in vehicle, container, bodywork, technical equipment manufacturing and mechanical engineering, and for cable ducts. The adhesive is also very useful in the ventilation and air supply sectors, and for adhesion bonding of mirrors.

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## 3. Substrate pre-treatment

The adhesion surfaces must be capable of bearing and free of dust, oil and grease. Pre-cleaning with 828 Grundreiniger is generally recommended on non-absorbent substrates, but compatibility with sensitive surfaces should be checked in advance to avoid surface damage. If required, carefully pretreat the adhesion surfaces using a suitable primer. Sanding with a fine sanding fleece can further improve adhesion on smooth surfaces. Due to the many different coating systems, an adhesion test is recommended before application to painted surfaces.

| Substrate*                                   | Pre-treatment                  |
|----------------------------------------------|--------------------------------|
| Glass                                        | 828 Grundreiniger              |
| Tiles                                        | 828 Grundreiniger              |
| Pine wood                                    | Dust free                      |
| Wet ground concrete                          | Dust free                      |
| Concrete, formwork smoothness                | Dust free                      |
| Steel DC 04                                  | 828 Grundreiniger              |
| Hot-dip galvanised steel                     | 828 Grundreiniger              |
| Stainless steel                              | 828 Grundreiniger              |
| Zinc                                         | 828 Grundreiniger              |
| Aluminium                                    | 828 Grundreiniger              |
| Aluminium AlMg1                              | 828 Grundreiniger              |
| Aluminium AlCuMg1                            | 828 Grundreiniger              |
| Aluminium 6016                               | 828 Grundreiniger              |
| Anodised aluminium                           | 828 Grundreiniger              |
| PVC Kömadur ES                               | 828 Grundreiniger              |
| PVC soft                                     | 828 Grundreiniger              |
| PC Makrolon Makroform 099                    | 828 Grundreiniger              |
| Polyacrylic PMMA XT 20070 Röhm* <sup>1</sup> | 828 Grundreiniger              |
| Polystyrene PS Iroplast                      | 828 Grundreiniger              |
| ABS Metzoplast ABS 7 H                       | 828 Grundreiniger / Primer 100 |
| PET                                          | 828 Grundreiniger              |
| PU waste quality                             | 828 Grundreiniger              |
| PMMA Röhm sanitary quality                   | 828 Grundreiniger              |
| Mirrors* <sup>2</sup>                        | 828 Grundreiniger              |
| GRP                                          | 828 Grundreiniger              |
| EPDM Semperit E 9614                         | 828 Grundreiniger              |

**\*For substrates which are not listed in this table, the processor must always carry out preliminary tests to check the suitability of the sealant for use. The tests carried out above only refer to the adhesive properties and have no significance in terms of compatibility with the stated substrates.**

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, etc.). Therefore, this table is for guidance only and does not constitute a binding statement.

**\*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.

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## 4. Application notes/restrictions

- 640 Dicht Kleber is not approved for applications with natural stone.
- Not approved for use in combination with insulating glass edge sealing systems
- Note that the alkalinity of the concrete must not be too high for application on concrete. As of a pH value >9, we recommend the alkaline-resistant Primer 160.
- Without pre-treatment, no adhesion is possible on plastics with a low-energy surface, such as PE, PP or PTFE
- Not suitable for processing in permanently wet or underwater areas.
- Not suitable for bonding structural glazing.
- For adhesion bonding of mirrors, always ensure that the mirror coating has sufficient thickness (0.05 mm) and the coating is undamaged. Otherwise there is a risk of damage to the mirror film. The bonding of mirrors and/or mirror elements must be carried out in accordance with the applicable standards and guidelines, such as "Technical Guidelines of the Glazing Trade No. 11 "Installation of Mirrors".
- Hybrid sealants and adhesives are not suitable for permanent joints or adhesion bonding of copper and brass

## 5. Processing

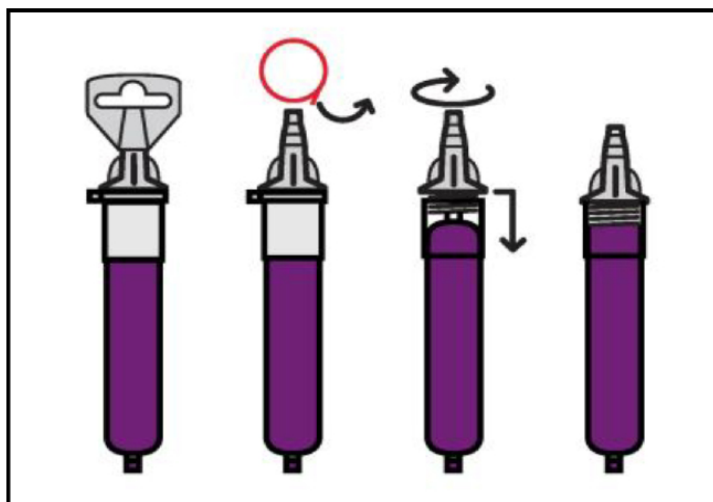
**General instructions:** The expiry date of the material must be observed, otherwise the properties of the product can no longer be guaranteed. If the products are stored and/or transported over a longer period of time at higher temperatures/humidity, the shelf life may be reduced or the material properties 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.

**Pre-treatment of the adhesion surfaces:** The substrate must be pre-treated in accordance with the instructions in section 3 of this technical data sheet.

**Applying the adhesive:** Apply 640 Dicht Kleber evenly and free of bubbles into the adhesive joint or onto the bonding surface while observing the processing conditions. If the substrate is pretreated with primer, its flash-off time must be observed. It is essential to ensure perfect contact with the adhesive surfaces or edges. For mirror bonding, always observe the applicable technical guidelines for the glazing trade.

**After-treatment:** When using a tooling agent, apply it fresh, unused and sparingly. Once the joint has been formed, any tooling agent residue must be removed before it dries; visual flaws can otherwise occur.

**Processing instructions 80 ml foil tube:** Our 80 ml foil tube impresses with a new opening system. This prevents contamination when opening the container. Simply twist off the white tear-off tape completely and screw the nozzle tip on firmly. The foil bag is opened by the innovative closure system and the material can be processed. The nozzle tip can be cut to fit the desired opening, as required, using a sharp knife.



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## 6. Maintenance and care

Ramsauer sealants and adhesives are carefully manufactured using state-of-the-art production processes. This results in high-quality products which, when processed appropriately, enable durable and resistant bonding and jointing. However, in order to guarantee the functionality of the joints and bondings, they need to be checked at regular intervals in accordance with the loads they are exposed to (chemical, mechanical, thermal, UV radiation), to clean them and to renew them if necessary (also see information sheet "Care and maintenance of joint seals").

## 7. Meets the requirements of IVD instruction sheet

|          |                                                                                                                                                        |
|----------|--------------------------------------------------------------------------------------------------------------------------------------------------------|
| No. 19-1 | Sealing of joints and connections in the roof area. Possible applications of sprayable sealants, assembly adhesives, butyl sealing tapes and profiles. |
| No. 30   | Assembly adhesive for bonding and sealing                                                                                                              |

## 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](http://www.ramsauer.eu)**.

## 9. 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, in particular with regard to substrates, processing and environmental conditions, the results may differ from this information. Therefore, no guarantee can be provided for the quality of the results achieved, which are influenced by the aforementioned circumstances. No legal claim, in whatever form, can be asserted against Ramsauer GmbH & Co KG based on these reference or from a verbal consultation, unless we are guilty of intent or gross negligence in this respect. Ramsauer GmbH & Co KG 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, which you can download at any time from our homepage at **[www.ramsauer.eu](http://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.

