

655 Kraft Fix

Hybrid adhesive



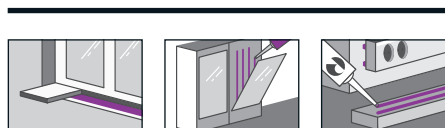
Technical data sheet

Version: 07-2025



Tests:

- EMICODE EC1^{PLUS} "very low emissions"
- Fulfills the French VOC requirement Class A+
- Suitable for use in the foodstuffs industry acc. to ISEGA certificate 63334 U24
- Resistant to artificial slurry acc. to DIBt guideline "Interior coating of slurry tanks" October 1999
- LABS conformity: VDMA 24364-S-L
- Listed on baubook



Excellent immediate adhesion



Compatible with natural stone



Good adhesion on many substrates



Very high tensile stress at break

1. Technical data

Basis	Hybrid adhesive - MS polymer
Skin formation time	~ 7 Min. (23°C/50% relative humidity)
Full curing time	~ 2 mm/24 hours (at +23°C/50% relative humidity)
Density	~ 1.56 (EN ISO 1183-1)
Shore A hardness	~ 80 (DIN EN ISO 868)
Volume shrinkage	~ 3% (EN ISO 10563)
Non-sag property	< 3 mm
Tear propagation resistance	~ 20.5 N/mm (ISO 34-1)
Tensile stress at break	~ 3.2 N/mm ² (DIN 53504-1 S2)
Elongation at break	~ 190% (DIN 53504-1 S2)
Initial shear load adhesion	up to ~ 250kg/m ²
Initial tensile load adhesion	>2000 kg/m ²
Resistance to high and low temperatures	-30°C to +90°C (long-term exposure)
Application temperature (substrate, environment)	Lower +5°C, upper +35°C
Colours	Grey, white
Packaging	290 ml cartridge; 600 ml foil bag; 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

655 Kraft Fix is characterised by its strong immediate adhesion and high Shore hardness. Fast curing and excellent adhesion to many plastics, metals, glass, ceramics and natural stone open up a wide range of applications. This neutral cure adhesive is odourless, and free from solvents, silicone and isocyanate. The product can be overpainted with a wide range of commercially available water-soluble paints in accordance with DIN 52452. However, due to the variety of paints and coatings available on the market, preliminary tests are essential. The extraordinary adhesion range enables lasting joints and bonds in a wide variety of materials in interior and exterior applications. It is used wherever extraordinary adhesive strength is required. The adhesive is suitable for wood and plastic window construction, for interior and exterior bonding and for bonding 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 / Primer 140
Hot-dip galvanised steel	828 Grundreiniger
Stainless steel	828 Grundreiniger
Zinc	828 Grundreiniger
Aluminium	828 Grundreiniger
Aluminium AlMg1	828 Grundreiniger / Primer 140
Aluminium AlCuMg1	828 Grundreiniger / Primer 140
Aluminium 6016	828 Grundreiniger / Primer 140
Anodised aluminium	828 Grundreiniger
PVC Kömadur ES	828 Grundreiniger / Primer 100
PVC soft	828 Grundreiniger
Polystyrene PS Iroplast	828 Grundreiniger
ABS Metzoplast ABS 7 H	828 Grundreiniger / Primer 100
PET	828 Grundreiniger
PMMA Röhm sanitary quality	828 Grundreiniger / Primer 100
Mirrors ^{*2}	828 Grundreiniger
Natural stone	828 Grundreiniger
GRP	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

- Avoidance of blinding for mirrors can only be guaranteed if the mirror coating has sufficient thickness (min. 0.05 mm) and the coating is undamaged. The bonding of mirrors 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".
- When bonding coated glass, adhesion and compatibility tests must be carried out in advance
- Not suitable for bonding aquariums.
- Not suitable for permanently wet stresses.
- Without pre-treatment, no adhesion is possible on plastics with a low-energy surface, such as PE, PP or PTFE
- Not approved for use in combination with insulating glass edge sealing systems
- 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 pretreated in accordance with the instructions in section 3 of this technical data sheet.

Applying the adhesive: A manual or pneumatic applicator with a high gearing ratio is used for processing 655 Kraft Fix. The adhesive must be applied to the adhesive joint or bonding surface evenly and free of bubbles while observing the processing conditions. If the substrate is pre-treated with a primer, its flash-off time must be observed. It is essential to ensure perfect contact with the adhesive surfaces or edges.

Post-treatment: Remove excess material quickly, as the cured adhesive can only be removed mechanically (e.g., smoothing tool, cutter, etc.). 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.

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. 30	Assembly adhesive for bonding and sealing
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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. 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. On publication of a new version/revision of the technical data sheet, all previous versions of the respective product lose their validity.

