

1030 HT

High-temperature polysiloxane



Technical data sheet

Version: V0 - 10-2025

1. Properties

- high-temperature acetate-based silicone
- RTV1 compound
- low shrinkage cross-linking
- UV, ageing and weather resistant
- excellent adhesion to various materials
- safe for use in the food area
- temperature resistance at long term exposure from -50 °C to +250 °C and up to +300 °C at short term exposure
- EMICODE® EC 1^{PLUS} ‚very low emission‘

2. Areas of application

- For chemically highly stressed sealing and bonding in industrial plant construction.
- For sealing and bonding that is exposed to very high temperatures.
- For bonding and sealing in the domestic appliance industry.
- For sealing and bonding heating elements in appliances, industrial furnaces and boilers.

3. Technical data

CTM*	Standard	Feature	Unit	Value Anthracite	Value Brown
		Base		Acetate acid cure	
		Curing mechanism		RTV 1	
		Skin formation time at +23 °C 50% RH	mins	~ 6	~ 8
		Full curing time at +23 °C 50% RH	mm/24 hrs	~ 1.60	~ 2.00
	EN ISO 1183-1	Density	g/cm ³	~ 1.08	~ 1.20
	DIN EN ISO 868	Shore A hardness		~ 43	~ 29
	EN ISO 10563	Volume shrinkage	%	~ 3.00	~ 1.70
	DIN 53504-S2	Elongation at break	%	~ 370	~ 350
	DIN 53504-S2	Tensile strength	N/mm ²	~ 2.40	~ 1.53
	DIN 53504-S2	Modulus of elasticity 100 %	N/mm ²	~ 0.64	~ 0.61
	DIN ISO 34-1	Tear resistance	N/mm	~ 9.20	~ 8.70
		Temperature resistance (long term exposure)	°C	-50 to +250	-50 to +300
		Temperature resistance (short term exposure)	°C	up to +300	-
		Processing temperature	°C	+5 to +35	+5 to +35
f-1-0/g-1-0		Shear stress 51/s	Pa	~ 6700	~ 8230
f-1-0/g-1-0		Viscosity 51/s	Pa·s	~ 131	~ 161
	DIN EN ISO 8394-1	Extrusion rate 310 ml cartridge	g/min	~ 48	~ 40
		Electrical conductivity (volume resistance)	Ω·cm	> 1 x 10 ¹⁰	> 1 x 10 ¹⁰
		Thermal conductivity	W/(m·K)	~ 0.34	~ 0.24
		Colours	Anthracite, brown		
		Packaging	Barrel, hobbock, 400 & 600 ml film bag, 310 ml cartridge		
		Shelf life	Barrel/hobbock: 6 months Film bag/cartridge: 12 months (when stored in a cool and dry place in the original container)		

* Corporate Test Method | CTM copies available on request

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4. Substrate preparation

The adhesive surfaces must be dry, stable and free of dust, oil and grease. On non-absorbent substrates, pre-cleaning with 828 Basic Cleaner is recommended. For sensitive surfaces, compatibility should be checked in advance to avoid surface damage. If necessary, carefully pre-treat the adhesive surfaces with a suitable primer. Sanding with fine abrasive fleece can further improve adhesion on smooth surfaces.

Substrate*	Pre-treatment
ABS Metzoplast ABS 7 H	828 Basic Cleaner Primer 100
Aluminium	828 Basic Cleaner Primer 140
Aluminium 6016	828 Basic Cleaner Primer 140
Aluminium AlCuMg1	828 Basic Cleaner Primer 140
Aluminium AlMg1	828 Basic Cleaner Primer 140
Anodised aluminium	828 Basic Cleaner Primer 140
Glass	828 Basic Cleaner
PC Makrolon Makroform 099	828 Basic Cleaner Primer 100
PET	828 Basic Cleaner
PU cutting quality	828 Basic Cleaner
Stainless steel	828 Basic Cleaner Primer 140
Steel hot-dip galvanised	828 Basic Cleaner Primer 140
Tile	828 Basic Cleaner

* On substrates not listed in this table, the processor must always carry out preliminary tests to check the suitability of the product. This table is based on adhesion tests carried out on test specimens from Rocholl under laboratory conditions. In practice, adhesive properties depend on a variety of external influences (weather, contamination, etc.). Therefore, this table is for guidance only and does not constitute a binding statement. The tests carried out above refer only to adhesive properties and are not indicative of compatibility with the substrates mentioned.

*1: Different types of PLEXIGLAS® show certain differences in their chemical resistance. In some applications, the formation of stresses must be expected. These stresses, in combination with certain agents, can lead to 'stress cracking'. The duration of exposure, temperature and concentration of the acting substance have a fundamental influence on the possible 'stress cracks'. When using our products in combination with PLEXIGLAS®, the suitability must therefore be checked in advance.

*2: Compatibility with a wide variety of mirror coatings from different manufacturers is regularly tested in our laboratory. Due to the manufacturing processes of different manufacturers, which are not known to us in detail, and depending on the existing substrate and bonding variants, preliminary tests are recommended.

5. Processing

General information: 1030 HT can be processed at substrate and ambient temperatures between +5 °C and +35 °C. The ideal processing temperature is about +20 °C. The viscosity of the uncured material is temperature-dependent, meaning that viscosity increases at low temperatures and decreases at high temperatures. In addition, a variety of external influences, such as humidity, UV exposure, chemical influences, high temperatures, etc., must be taken into account. These and other factors can have a significant effect on the material properties of the product and its shelf life. The expiry date stated on the product must be strictly adhered to, as the product properties can no longer be guaranteed if this date is exceeded. Good ventilation must be ensured during processing and curing.

Processing: Before application, the processor must ensure that all materials that come into contact with the product do not cause any incompatibilities. The polysiloxane must be processed within the specified skin formation time, as reliable adhesion can no longer be achieved once skin formation has taken place. It should be noted that the skin formation time is considerably shorter in particularly hot or humid climates.

Removal: Uncured 1030 HT can be removed with 502 Surface Cleaner or 504 Universal Cleaning Wipes, while cured material can only be removed mechanically. If it comes into contact with the skin, it must be cleaned immediately.

6. Application restrictions

- Not suitable for underwater or natural stone applications.
- Avoid contact with laminated safety glass and mirror films as well as insulating edge seal systems.
- When applied to uncoated metals, especially brass, copper, lead, zinc, etc., corrosion may occur due to the acetic acid released during cross-linking.
- No adhesion on tar- and bitumen-containing as well as alkaline substrates.
- Without pre-treatment, no adhesion to plastics with low-energy surfaces, such as PE, PP or PTFE.
- Not suitable for large-area bonding or joints with a depth of more than 15 mm.

7. Safety notices

All safety notices and instructions are listed in the current safety data sheet available on www.ramsauer.eu.

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8. Liability for defects

All information, in particular suggestions for the processing and use of our products, is based on our knowledge and previous experience. Depending on the specific circumstances, in particular with regard to the substrate, processing and environmental conditions, the results may differ from our specifications. Therefore, no guarantee can be given for the quality of the results achieved, which are influenced by the aforementioned circumstances. No legal claims of any kind can be asserted against Ramsauer GmbH & Co KG on the basis of this information or verbal advice, provided that we are not guilty of intent or gross negligence. Ramsauer GmbH & Co KG guarantees that its products will retain their technical properties as specified in the technical data sheets until their expiry date. Product users must observe the latest technical data sheet, which can be downloaded from our website at www.ramsauer.eu. Our current General Terms and Conditions apply. These are also available on our website. With the publication of a new version or revision of a technical data sheet, all previous versions of the respective product lose their validity.

