

3270

2-component polysiloxane



Technical data sheet

Version: V1 - 10-2025

1. Properties

- silicone based on neutral alkoxy
- 2-component compound
- moisture-independent cross-linking
- UV, ageing and weather resistant
- temperature resistance at long term exposure from -50 °C to +150 °C
- EMICODE® EC 1^{PLUS} ‚very low emission‘

2. Areas of application

- Ideal for surface bonding where the supply of air humidity is limited.
- For permanent sealing and bonding of components with different thermal expansion properties.
- For various flexible, strong adhesive bonds in the automotive, transport and caravan industries.
- For bonding glass to metal, glass to painted metal and glass to plastic in refrigerators and household appliances.

3. Technical data

CTM [*]	Standard	Feature	Unit	Value
		Base		Alkoxy neutral cure
		Curing mechanism		2C moisture-independent
		Pot life at +23 °C 50 % RH	mins	~ 35
	EN ISO 1183-1	Density (mixture)	g/cm ³	~ 1.29
	DIN EN ISO 868	Shore A hardness		~ 45
	EN ISO 10563	Volume shrinkage	%	~ 4.20
		Initial tack		high
	DIN 53504-S2	Elongation at break	%	~ 250
	DIN 53504-S2	Tensile strength	N/mm ²	~ 2.10
	DIN 53504-S2	Modulus of elasticity 100%	N/mm ²	~ 1.10
	DIN ISO 34-1	Tear resistance	N/mm	~ 9.90
		Temperature resistance (long term exposure)	°C	-50 to +150
		Processing temperature	°C	+5 to +35
f-1-0/g-1-0		Shear stress 51/s	Pa	~ 2050
f-1-0/g-1-0		Viscosity 51/s	Pa·s	~ 40
		Electrical conductivity (volume resistance)	Ω·cm	> 1 x 10 ¹⁰
		Thermal conductivity	W/(m·K)	~ 0.29
		Colours	Black	
		Packaging	Barrel, hobcock, 490 ml side-by-side-cartridge, 280 ml coaxial cartridge	
		Shelf life	6 months (when stored in a cool and dry place in the original container)	

^{*} Corporate Test Method | CTM copies available on request

4. Substrate preparation

The adhesive surfaces must be 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. Due to the many different coating systems, an adhesion test is recommended before application on painted surfaces.

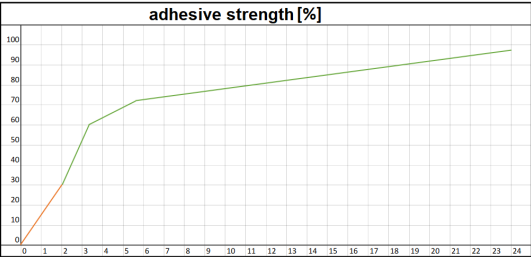
Substrate*	Pre-treatment
ABS Metzoplast ABS 7 H	Primer 100
Aluminium	828 Basic Cleaner
Aluminium 6016	828 Basic Cleaner
Aluminium AlCuMg1	828 Basic Cleaner
Aluminium AlMg1	828 Basic Cleaner
Anodised aluminium	828 Basic Cleaner
Bare steel	828 Basic Cleaner
Brass Ms63 hardness F37	828 Basic Cleaner
Concrete formwork smooth	free of dust
Concrete wet, polished	free of dust
Copper	828 Basic Cleaner
EPDM Semperit E9614	Primer 100
GFK	828 Basic Cleaner
Glass	828 Basic Cleaner
PC Makrolon Makroform 099	828 Basic Cleaner
PET	Primer 100
PMMA Röhm sanitary grade	Primer 100
Polyacrylic PMMA XT 20070 Röhm*1	Primer 40
Polystyrene PS Iroplast	Primer 100
PU cutting quality	Primer 100
PVC Kömadur ES	Primer 100
PVC soft	Primer 100
Electrogalvanised steel	828 Basic Cleaner
Stainless steel	828 Basic Cleaner
Tile	828 Basic Cleaner
Zinc	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. Curing | Build-up of adhesive strength



After a curing time of approximately 2 hours, the bond is already moderately resilient. Final strength is achieved after approximately 24 hours.

6. Processing

General information: 3270 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. First, the substrate must be pre-treated, taking into account the flash-off time when using a primer. For 280 ml coaxial cartridges, we recommend our RH9 hand press or our RM5 pneumatic press as application tool. The RM49 pneumatic press is ideal for 490 ml side-by-side-cartridges. Perform the first squeezing process until both components are visibly discharged from the cartridges. Only then should the supplied static mixer be screwed on. Discard the first approx. 5 cm of the now mixed strand, as the two components may not yet be 100% evenly mixed. During further processing, ensure that the mixture remains consistent and correct. For machine processing, component B must be stirred in advance. When mixing using a 2-component dosing and mixing system, the dosing ratio is 10:1 (volume) or 12:1 (weight). Component A does not react with air humidity and is stable under normal conditions (+23 °C | 50% RH). Component B, on the other hand, is sensitive to air humidity and must therefore be protected from moisture. 3270 must be applied evenly and without bubbles. It is essential to ensure perfect contact with the adhesive surfaces or edges.

Removal: Uncured 3270 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.

7. Application restrictions

- Not suitable for mirror or natural stone applications.
- Do not use for structural bonding of structural glazing elements.
- Without pre-treatment, no adhesion to plastics with low-energy surfaces, such as PE, PP or PTFE.

8. Safety notices

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

9. 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.

