

600 Silikon Kleber

Neutral cure adhesive



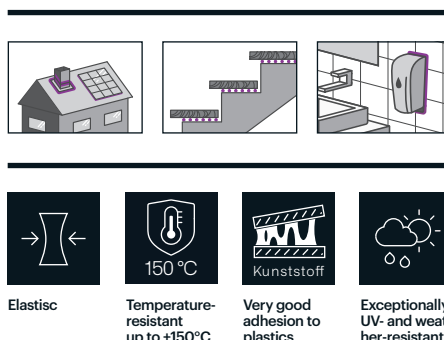
Technical data sheet

Version: 09-2026



Tests:

- Emission EC1^{PLUS} „very low emissions“
- Tested fire behavior according to EN 13501-1:2018



1. Technical data

Basis	Silicone adhesive – alkoxy-based
Skin formation time	~ 10 Min. (23°C/50% relative humidity)
Full curing time	~ 1,5 mm/24 hours (at +23°C/50% relative humidity)
Density	~ 1,25 (EN ISO 1183-1)
Shore A hardness	~ 40 (DIN EN ISO 868)
Volume shrinkage	~ 7.2% (EN ISO 10563)
Tear propagation resistance	~ 9.5 N/mm (ISO 34-1)
Tensile strength/100%	~ 0.78 N/mm ² (DIN 53504-S2)
Tensile strength/breakage	~ 2,37 N/mm ² (DIN 53504-S2)
Elongation at break	~ 420% (DIN 53504-S2)
Classification of reaction to fire	B-s1, d0 (EN 13501-1:2018)
Resistance to high and low temperatures	-40°C to +150°C (long-term exposure)
Application temperature (substrate, environment)	Lower +5°C, upper +35°C
Non-sag property	< 3 mm
Colours	Black, white, grey
Packaging	310ml cartridge, other containers on request
Shelf life of cartridges and foil bags	10 months in original packaging in cool and dry storage conditions

2. Properties / applications

600 Silikon Kleber is a neutral alkoxy-based silicone rubber for the strip bonding of wall panels, wood-based materials, tiles, glass, ceramics, metals, concrete and much more. The product is sound-insulating, and UV-resistant, weather-resistant and resistant to high and low temperatures. The adhesive does not contain any corrosive components and therefore does not cause discolouration of brass, copper or metal, which makes it ideally suited for metal, aluminium and structural facades. Due to its excellent resistance to high and low temperatures, the product is a great choice for use in plumbing work. 600 Silikon Kleber remains elastic even after curing and can therefore easily absorb vibration, shocks or thermal elongation.

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3. Substrate pre-treatment

The adhesion surfaces must be dry, capable of bearing, and free of dust, oil and grease. Pre-cleaning with 828 Grundreiniger is generally recommended for non-absorbent substrates; however, for sensitive surfaces, compatibility should be verified beforehand to avoid surface damage. If necessary, carefully pretreat the bonding surfaces with a suitable primer. Lightly sanding smooth surfaces with a fine abrasive pad can further improve adhesion. Due to the wide variety of coating systems available, an adhesion test is recommended prior to application on painted surfaces.

Substrate*	Pre-treatment
Glass	828 Grundreiniger
Tiles	828 Grundreiniger
Pine wood	Dust free
Wet ground concrete	Dust free / Primer 70
Concrete, formwork smoothness	Dust free / Primer 70
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
Brass MS 63 Hardness F 37	828 Grundreiniger
PVC Kömadur ES	828 Grundreiniger
PVC soft	828 Grundreiniger
PC Makrolon Makroform 099	828 Grundreiniger
Polyacrylic PMMA XT 20070 Röhm* ¹	828 Grundreiniger
Polystyrene PS Iroplast	828 Grundreiniger / Primer 100
ABS Metzoplast ABS 7 H	828 Grundreiniger / Primer 100
PET	828 Grundreiniger
PU waste quality	828 Grundreiniger
Copper	828 Grundreiniger
EPDM Semperit E 9614	828 Grundreiniger
PMMA Röhm sanitary quality	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

- Not suitable for natural stone adhesion
- Not suitable for bonding mirrors, aquarium and terrarium construction
- Not approved for use in combination with insulating glass edge composite systems
- Without pre-treatment, no adhesion is possible on plastics with a low-energy surface, such as PE, PP or PTFE
- Before use on painted surfaces, it is recommended to carry out preliminary tests
- For white painted surfaces, ensure that the adhesive is sufficiently ventilated (yellow discoloration of the painted surface is possible!).

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.

Preparation 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: The 600 Silikon Kleber must be applied evenly and without bubbles into the adhesive joint or onto the adhesive surface while adhering to the processing conditions. When pre-treating the substrate with primer, the flash-off time must be taken into account. It is essential to ensure perfect contact with the adhesive-surfaces or -flanks.

Post-treatment: When using a tooling agent, apply it fresh, unused and sparingly. Once the joint has been formed, any residue of tooling agent must be removed before it dries, otherwise visual flaws are to be expected.

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

not applicable

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.

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.

