

# 622 2K-PU Kleber

## PUR reactive resin adhesive



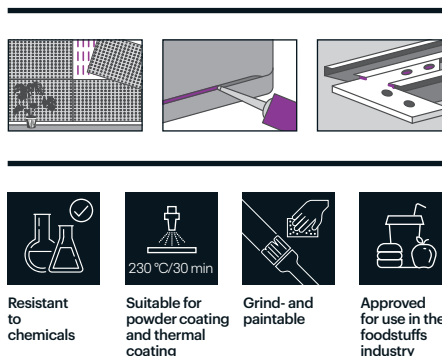
### Technical data sheet

Version: 10-2026



#### Tests:

- Water vapor permeability tested according to DIN EN ISO 12572:2001
- Approved for use in the foodstuffs industry acc. to ISEGA certificate 63006 U24
- Fulfills the French VOC requirement Class A+



### 1. Technische Daten

|                                                                         |                                                                                                           |
|-------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------|
| Basis                                                                   | 2-component reactive adhesive                                                                             |
| Density                                                                 | ~ 1,40 g/cm <sup>3</sup>                                                                                  |
| Shore D hardness                                                        | ~ 80 (DIN 53505)                                                                                          |
| Viscosity                                                               | Low viscosity, pasty                                                                                      |
| Mixing ratio                                                            | 1:1                                                                                                       |
| Pot life                                                                | ~ 30 min. (+20°C)                                                                                         |
| Pot life of the cartridge with static mixer                             | ~ 15 min.                                                                                                 |
| Functional strength                                                     | After ~ 3 hrs. (+20°C)                                                                                    |
| Curing time after 24 hrs.                                               | 75% (at +20°C/50% RLF)                                                                                    |
| Final strength                                                          | After approx. 7 days (at +20°C)                                                                           |
| Application temperature adhesive and substrate                          | +7 °C to +30 °C                                                                                           |
| Tensile shear strength, aluminium/aluminium, 0.2 mm joint (DIN EN 1465) | At +20°C: 20,0 N/mm <sup>2</sup> ; at +80°C: 8,0 N/mm <sup>2</sup>                                        |
| Water vapor permeability according to DIN EN ISO 12572:2001             | Diffusion-equivalent air layer thickness S <sub>d</sub> ~ 820m<br>Water vapor diffusion number μ ~ 176800 |
| Subsequent powder coating after reaching final strength                 | 30min / up to +230 °C                                                                                     |
| Application quantity for each corner                                    | ~ 20 g                                                                                                    |
| Colours                                                                 | White                                                                                                     |
| Packaging                                                               | 2 x 310 ml side-by-side cartridge, drum on request                                                        |
| Shelf life of cartridges and foil bags                                  | 9 months in original packaging in cool and dry storage conditions                                         |
| Compatible processing equipment                                         | Pneumatic sealant gun RM62, manual sealant gun RH62                                                       |

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## 2. Properties / applications

622 2K-PU Kleber is a reactive adhesive for bonding corner joints of aluminium windows and doors. In addition, the adhesive can achieve a designed frictional connection of different combinations of materials, e.g. in vehicle bodies. Our 622 2K-PU Kleber is best suited for general bonding of aluminium, HPL, GRP and many other substrate materials. Best suited for hard grouting of wall panels. Also suitable for repairing joints in plasterboard.

## 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. A primer is always recommended for hard PS surfaces

## 4. Application notes/restrictions

- Without pre-treatment, no adhesion is possible on plastics with a low-energy surface, such as PE, PP or PTFE
- If permanent exposure to moisture is expected, the bonded joints/adhesive surfaces must be additionally sealed with suitable sealing compounds.
- Bonding of materials with different rates of linear expansion must be evaluated with regard to the long-term behaviour of the materials, especially if under stress in changing temperature ranges.
- For bonding on aluminium, copper, brass, only on chemically pretreated or painted surfaces; these materials cannot be permanently bonded with ensured resistance to weathering and ageing without appropriate pretreatment of the bonding surface. Due to the different aluminium surfaces and qualities, we recommend obtaining sufficient information from the supplier in order to carry out the best possible pretreatment for future bonding work – appropriate suitability testing is recommended.
- When bonding stainless steel, make sure that the surfaces are carefully cleaned and/or degreased.
- Galvanised plates must always be protected against permanent exposure to moisture. For bonding applications, make sure that occurring moisture does not reach the bonding surface.
- Powder coatings with PTFE components cannot be reliably bonded without pretreatment (e.g., plasma process).

## 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.

**Preparing the adhesive cartridge:** Material temperatures have a considerable influence on the reactivity and dispensing behaviour; in warm conditions, the compounds flow and can be dispensed far faster. In low temperatures, the cartridges must be warmed up uniformly (up to max. +35°C). The cartridge is opened and inserted into the gun. Perform the first pressing without attaching the static mixer. Only when both components visibly emerge the static mixing tube is screwed onto the cartridge. Avoid overloading the tandem cartridges by applying excessive force > 3.6 kN. Depending on the manufacturer of the pneumatic equipment, mixing problems can occur during processing at higher operating pressures. The first approx. 20 g of mixed adhesive are not used for bonding for safety reasons.

**Applying the adhesive:** When pretreating the substrate with primer, its drying time must be observed. Using the static mixer, apply the mixed adhesive directly to the profile or bonding surface within the pot life and join the parts. After joining, then fix or press the parts until functional strength is achieved. Any leaking adhesive must be removed immediately while fresh.

**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. Fresh, uncured adhesive can be removed from the surfaces and processing equipment, e.g., using our 504 Universal Reinigungstücher. Cured adhesive can only be removed mechanically.

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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

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](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.

