

630 Montage Kleber

Acrylic-based adhesive



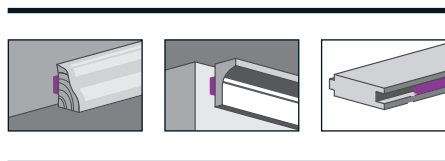
Technical data sheet

Version: 10-2026



Tests:

- Emission EC1 „very low emissions“
- Listed on baubook



Good
adhesion to
absorbent
surfaces



Grind- and
paintable

1. Technical data

Base	Acrylic-based adhesive
Skin formation time	~ 5 Min. (23°C/50% relative humidity)
Full curing time	~ 2,0 mm/24 hours (at +23°C/50% relative humidity)
Density	~ 1,29 (EN ISO 1183-1)
Shore A hardness	~ 60 (DIN EN ISO 868)
Volume shrinkage	~ 45% (EN ISO 10563)
Non-sag property	< 3 mm
Tear propagation resistance	~ 30 N/mm (ISO 34-1)
Module	~ 1,9 N/mm ² (DIN 53504-1 S2)
Tensile strength/breakage	~ 2,2 N/mm ² (DIN 53504-S2)
Elongation at break	~ 280% (DIN 53504-1 S2)
Resistance to high and low temperatures	-40°C to max +65°C (long-term exposure)
Application temperature (substrate, environment)	Lower + 5°C, upper + 35°C
Drying time on substrate absorbent on both sides Drying time on substrate absorbent on one side	~ 15 min. ~ 30 min.
Colours	White
Packaging	310 ml cartridge, other containers on request
Shelf life of cartridges and foil bags	12 months in original packaging in cool, frost-free and dry storage conditions

2. Properties / applications

The solvent-free, universally applicable 630 Montage Kleber forms a strong bond after curing. It can be used on absorbent surfaces indoors and outdoors and impresses with its fast curing time. 630 Montage Kleber is largely resistant to the effects of water and heat. After complete curing, the material is completely odourless, physiologically harmless and inert. Ramsauer 630 Montage Kleber enables fastening of wooden strips and profiles, rigid PVC profiles, polyurethane beams, polystyrene (Styrofoam), chipboard and ceiling tiles on wood, stone, tile, plaster, etc., without nails or screws.

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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 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. 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.

Surface	Preparation
Absorbent surfaces	Dust free / if necessary prime with an emulsion of 630 Montagekleber 1:1 with water
Non-absorbent surfaces	828 Grundreiniger / pre-adhesion test recommended

4. Application notes/restrictions

- Not suitable for bonding mirrors and glass, bonding various plastics (PE, PP, PA, PTFE...), silicone, acrylic glass, oil and bituminous surfaces
- Can lead to corrosion on non-corrosion protected metals and non-ferrous metals
- Not suitable for bonding natural stone
- 630 Montage Kleber must be protected from rain or solvents until a firm skin forms (approx. 12 hours).
- The compatibility with various coatings, such as paints, varnishes, plastics, etc. must be checked before application
- For materials processed in the area of the adhesive, it must be clarified in advance that their ingredients or emissions do not cause any impairment or changes (e.g. discoloration etc.) of the adhesive.
- Without pre-treatment, no adhesion is possible on plastics with a low-energy surface, such as PE, PP or PTFE

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 adhesive is designed for optimal adhesion to absorbent surfaces. For non-absorbent surfaces, an adhesion test is necessary before processing!

Application of the sealant: 630 Montage Kleber sufficiently to the parts to be glued or to the substrate. Then push the workpieces together, align them, press them together and fix them according to the drying time specified above. It is essential to ensure perfect contact with the adhesive surfaces or flanks

After-treatment: Remove excess glue immediately

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.

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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.

