

635 Kraft Elast Kleber

Hybrid adhesive



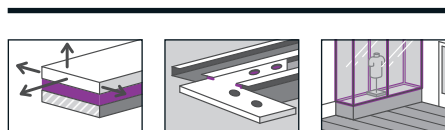
Technical data sheet

Version: 07-2026



Tests:

- EMI CODE EC1^{PLUS} „very low emissions“
- Fulfills the French VOC requirement Class A+
- DIN EN ISO 846, Methods A + C
- Suitable for use in ventilation systems according to ÖNORM H 6021:2023-01-15



Crystal-clear
appearance
after
curing



Good adhesion
to damp sub-
strates



Elastic and
vibration-
dampening



Bonding of
toughened
safety glass
(ESG) units

1. Technical data

Basis	Hybrid adhesive – MS polymer
Skin formation time	~ 6 Min. (23°C/50% relative humidity)
Full curing time	~ 2 mm/24 hours (at +23°C/50% relative humidity)
Density	~ 1,04 (EN ISO 1183-1)
Shore A hardness	~ 34 (DIN EN ISO 868)
Shrinkage	~ 4% (EN ISO 10563)
Tear propagation resistance	~ 12,7 N/mm (ISO 34-1)
Tensile stress at break	~ 2,65 N/mm ² (DIN 53504-1 (S2))
Module	~ 0,76 N/mm ² (DIN 53504-1 (S2))
Elongation at break	~ 520% (DIN 53504-1 (S2))
Resistance to high and low temperatures	-40°C to +110°C (long-term exposure)
Application temperature (substrate, environment)	Lower 5°C, upper +35°C
Colour	crystal clear
Packaging	290 ml cartridge; other container sizes on request
Shelf life of cartridges	12 months in original packaging in cool and dry storage conditions

2. Properties/applications

635 Kraft Elast Kleber is a virtually odorless, weather-resistant, crystal-clear hybrid-based adhesive. Once cured, the material remains elastic and is characterized by excellent long-term durability. Suitable for a wide range of interior applications, 635 Kraft Elast Kleber is free from silicone, isocyanates, and solvents. It offers a broad spectrum of uses and is easy to apply; its stable, paste-like consistency allows for the leveling of uneven surfaces and the easy filling of gaps. It is suitable for bonding both static and vibrating structures. 635 Kraft Elast Kleber is highly versatile, making it ideal for bonding door frames, panels, decorative moldings, windowsills, skirting boards, panels, timber structures, insulation materials, and much more.

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3. Substrate pre-treatment

The adhesion surfaces must be 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 using a suitable primer. Sanding with a fine sanding fleece can further improve adhesion on smooth surfaces.

Substrate*	Pre-treatment
Glas	828 Grundreiniger
Hot-dip galvanised steel	828 Grundreiniger
Aluminium	828 Grundreiniger
Aluminium AlMg1	828 Grundreiniger
Aluminium AlCuMg1	828 Grundreiniger
Aluminium 6016	828 Grundreiniger
Anodised aluminium	828 Grundreiniger
PET	828 Grundreiniger
PMMA Röhm sanitary quality	828 Grundreiniger
GRP	828 Grundreiniger
EPDM Semperit E 9614	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.

4. Application notes/restrictions

- Not suitable for sealing and bonding natural stone.
- This product is not suitable for bonding Plexiglas®
- Yellowing and embrittlement can occur upon exposure to UV radiation or at higher temperatures.
- Not approved for bonding mirror elements and RC2-bondings
- Once cured, 635 Kraft Elast adhesive can be painted over in accordance with DIN 52452. However, due to the wide variety of paint systems available, preliminary tests should be conducted.
- Hybrid sealants and adhesives are not suitable for permanent joints or adhesion bonding of copper and brass
- 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. Substrates containing tar and bitumen are unsuitable as adhesion substrates or must be tested independently in advance. 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.

Pre-treatment 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: Apply 635 Kraft Elast Kleber evenly and free of bubbles into the adhesive joint or onto the bonding surface while observing the processing conditions. If the substrate is pretreated with primer, its flash-off time must be observed. It is essential to ensure perfect contact with the adhesive surfaces or edges. When bonding vapour diffusion-tight substrates, make sure that there is sufficient moisture available for cross-linking (if necessary, moisten with a spray bottle).

Post-treatment: Once the joint has been formed, any residue of tooling agent must be removed before it dries, otherwise visual flaws are to be expected. The sealant can be painted over; however, due to the wide variety of paints and coatings available on the market, we recommend testing the adhesion and paint compatibility in advance.

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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

No. 30	Assembly adhesive for bonding and sealing
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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 release of a new version or revision of the technical data sheet, all previous versions for the respective product become invalid.

