



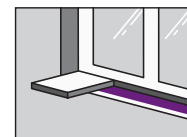
RAMSAUER®

655

LASTING BONDS.

Kraft Fix

1-component hybrid adhesive



Natural Stone

Technical data sheet

Version: 07-2024

Tests:

· EMICODE EC1^{PLUS} "very low emissions"



1. Technical Data

Basis	Hybrid adhesive - MS polymer
Skin formation time	~ 7 Min. (23°C/50% relative humidity)
Full curing time	~ 2 mm/24 hours (at +23°C/50% relative humidity)
Density	~ 1.56 (EN ISO 1183-1)
Shore A hardness	~ 80 (DIN EN ISO 868)
Volume shrinkage	~ 3% (EN ISO 10563)
Non-sag property	< 3 mm
Tear propagation resistance	~ 20.5 N/mm (ISO 34-1)
Tensile stress at break	~ 3.2 N/mm ² (DIN 53504-1 S2)
Elongation at break	~ 190% (DIN 53504-1 S2)
Resistance to high and low temperatures	-30°C to +90°C (long-term exposure)
Application temperature (substrate, environment)	Lower +5°C, upper +35°C
Colours	Grey, white
Packaging	290 ml cartridge; 600 ml foil bag; Other containers on request
Shelf life of cartridges and foil bags	12 months in original packaging in cool and dry storage conditions

2. Properties / Area of application

655 Kraft Fix is a ready-to-use, high-porosity, 1-component sealant based on MS hybrid with very high initial tack. 655 Kraft Fix is neutrally curing, odourless, and free from solvents, silicone and isocyanate. The product can be overpainted with a wide range of commercially available water-soluble paints in accordance with DIN 52452. However, due to the variety of paints and coatings available on the market, preliminary tests are essential. This heavy duty adhesive supports a wide range of applications. The extraordinary adhesion range enables lasting joints and bonds in a wide variety of materials in interior and exterior applications. Suitable for bonding mirrors. The product shows excellent adhesion to many plastics, metals, glass and natural stones.



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3. Surface preparation

The adhesive surfaces must be dry, stable and free of dust, oil and grease. On non-absorbent surfaces, pre-cleaning with 828 basic cleaner is generally recommended, but for sensitive surfaces the compatibility should be checked in advance to avoid surface damage. If necessary, carefully prepare the bonding surfaces using a suitable primer. Sanding with a fine abrasive fleece can further improve adhesion on smooth surfaces.

Surface	Preperation
Glass	828 Grundreiniger
Tiles	828 Grundreiniger
Pine wood	dust free
Wet ground concrete	dust free
Concrete, formwork smoothness	dust free
Steel DC 04	828 Grundreiniger
galvanised steel	828 Grundreiniger
Stainless steel	828 Grundreiniger
Zinc	828 Grundreiniger
Aluminium	828 Grundreiniger
Aluminium AlMg1	828 Grundreiniger
Aluminium AlCuMg1	828 Grundreiniger
Aluminium 6016	828 Grundreiniger
Anodised aluminium	828 Grundreiniger
Brass MS 63 Hardness F 37	828 Grundreiniger
PVC Kömadur ES	828 Grundreiniger / Primer 100
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
PMMA Röhm sanitary quality	828 Grundreiniger
Mirrors*2	828 Grundreiniger
Natural stone	dust free

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, loads, etc.). Therefore, this table is for guidance only and does not constitute a binding statement. For further information please contact our application engineering department. The tests carried out above only refer to the adhesive properties and have no significance in terms of compatibility with the stated substrates.

*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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655

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4. Processing

General information: 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 elevated temperatures/humidity, the shelf life may be shortened or the material properties may change. Strong environmental influences (e.g. high temperature, UV exposure, chemical influences such as vapors, etc.) can affect the properties of the material to varying degrees. Before processing, the user has to ensure that the building materials (solid, liquid or in gaseous state) in the contact area are compatible with the sealant. Pay attention to the ambient and substrate temperature during processing, as temperatures that are too high or low can lead to a change in the properties. Due to the large number of possible influences during processing, the processor is always recommended to carry out a trial processing before use. Good ventilation must be ensured during processing and curing.

Pre-treatment of the adhesive surfaces: The substrate pre-treatment must be carried out in accordance with the information under point 3 of this data sheet.

Einbringen des Klebstoffes: Applying the adhesive: The 655 Kraft Fix 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.

After-treatment: When using a smoothing agent, it should be fresh, unused and used sparingly. After the joint has been formed, any smoothing agent residue must be removed before it dries, otherwise visual impairments may occur.

5. Meets the requirements of IVD instruction sheet

No. 30	Assembly adhesive for bonding and sealing
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6. Maintenance and care

Ramsauer sealants and adhesives are manufactured carefully and using the most modern manufacturing processes. This results in high-quality products that, when processed appropriately, enable long-lasting and resistant bonds and joints. However, in order to ensure the functionality of the joints and bonds, it is necessary to check, clean and, if necessary, replace them at regular intervals depending on the loads (chemical, mechanical, thermal, UV radiation) (see also the information sheet "Care and maintenance of joint sealing").

7. Application restrictions

- When processing natural stone, it is essential to carry out preliminary tests.
- When gluing mirrors, it is important to ensure that the mirror coating is sufficiently thick (0.05 mm) and that the coating is not damaged. Otherwise there is a risk of damage to the mirror film. The bonding of mirrors and/or mirror elements must be carried out in accordance with the applicable standards and guidelines, such as "Technical Guidelines of the Glazier Trade No. 11 "Assembly of Mirrors"
- Not suitable for bonding aquariums
- Not suitable for permanent wet conditions
- Not approved for use in combination with insulating glass edge composite systems
- No adhesion to plastics with low-energy surfaces such as PE, PP or PTFE



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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 the guarantee of a work result or a liability, for whatever legal reasons, can be justified neither from these references, nor from a verbal consultation, unless we are guilty of intent or gross negligence in this respect. Ramsauer 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.