



TECHNICAL DATA SHEET

ergo.[®] 6300 and ergo.[®] 6305 Hybrid-Polymer

Fast curing, elastic single-component sealant and adhesive for bonding as well as sealing of seams and joints in carbody-, waggon-, container and boatbuilding. Also suitable for mechanical engineering and applications in air-conditioners and ventilation technologies.

Advantages

- good adhesion to glass, a wide range of metal (zinc, aluminium, steel), varnished and primed surfaces
- good adhesion to wooden as well as to mineral substrates and to thermoplastics (except PE, PP, PTFE)
- resistant against humidity, weathering and temperatures from -40°C up to +90°C (up to +200°C for short intervals)

Properties of liquid product

Chemical Base	Hybrid-Polymer
Appearance	pasty, non-dripping, spreadable with a spatula
Colour	ergo. [®] 6300 ergo. [®] 6305
Density at 23°C	white black
Viscosity @ 25°C (EN 12092, Cone-plate-system, MK25) shear rate 10 s ⁻¹ 100 s ⁻¹	~ 1,41 g/cm ³ 280.000 – 320.000 mPa•s 120.000 – 160.000 mPa•s
Skinning time at 23°C/50%rh (pre-tests under real ambient conditions are recommended)	~ 5 minutes
Curing progress after 24 h at 23°C/50%rh	~ 3 mm
Change of weight (after 14 days)	~ 1 %

Typical properties of cured product

Tensile strength (DIN 53504) storage 7 days at 23°C/50%rh	~ 3,2 N/mm ²
Elongation at break (DIN 53504) storage 7 days at 23°C/50%rh	~ 400 %
Modulus at 100% elongation and 23°C (DIN 53504 S2) storage 7 days at 23°C/50%rh	~ 1,9 N/mm ²



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Tear resistance (ASTM D 624, Form B) storage 7 days at 23°C/50%rh	~ 21 N/mm
Shore-A-hardness (DIN 53505) storage 28 days at 23°C/50%rh	~ 55
Thermal range	-40°C up to +90° C 45 minutes up to +180°C 30 minutes up to +200°C
Working temperature	+5°C up to +30°C
Packaging	cartridges à 310 ml
Storage conditions	cool and dry (no longer periods > +25°C)
Storage stability	9 month in original box

Usage

Good adhesion to clean, dry and grease-free surfaces (cleaned either with **ergo.® 9190** or **ergo.® 9195**), even without Primer. For best results we recommend the use of Primer **ergo.® 6950** (non absorbing surfaces) or of Primer **ergo.® 6960** (absorbing surfaces)

Please check the compatibility with varnish and plastic in advance

Apply **ergo.® 6300** or **ergo.® 6305** with a common putty gun. The thickness of the needed layer depends on expected forces and relative movements. The curing process is influenced by layer thickness, temperature and humidity

Special consideration

Not suitable for glass bonding with permanent UV radiation to the bonded area

Safety

Please read the MSDS and the labels carefully before use

WARRANTY INFORMATION - PLEASE READ CAREFULLY

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