



RAMSAUER®
DICHTSTOFFE

680 Anker Kleber

(Anchor Adhesive)

Injection mortar on a vinyl ester resin basis

TESTS, COMPLIANCE WITH STANDARDS

Tested to ETA-17/0679 and ETA-17/0680

Tested to DIN 18008-4

Tested to ÖNROM B 3716-3

CHARACTERISTICS

- Basis material: pure vinyl ester resin
- Colour: grey (component A: white; component B: black)
- Specific weight: 1.7 kg/l at 20°C
- Storage life: 12 months in a cool and dry place

APPLICATION

680 ANKER KLEBER is a heavy-duty injection mortar with vinyl ester resin for solid and hollow materials. It is styrene-free and cures quickly.

Suitable for concrete, stone, perforated bricks and cavity materials for a wide range of applications: fastening of doors, balustrades, stair railings, louvers, antennas, brackets, cable ducts, industrial installations, etc. The product is also suitable for construction applications with reinforcing steel and for the renovation of buildings.

Tested for gluing of glass balustrades.

PROCESSING

- The parts to be fastened must be free from impurities, grease, oil or other foreign substances.
- Inject mortar starting from the bottom of the hole avoiding the formation of air pockets. Pull the static mixer out slowly while pressing the product into the hole. Make sure that the material has a uniform colour.
- The hole must be filled with injection mortar up to about 2/3 of the drilled depth.
- Introduce the part to be fastened within the processing time while rotating it. Then, the hole must be completely full with mortar. Remove any excess material immediately. Hold with a suitable tool if required. The material must be used in compliance with ETA-17/0679 or ETA-170/680.
- Do not touch steel components before the curing time has elapsed.

PROCESSING AND CURING TIMES

Concrete temperature	°C	-10	-5	0	+5	+10	+15	+20	+25	+30	+35	+40
Max. processing time	min.	105	65	45	25	16	11.5	7.5	5	3	2	1
Min. curing time with dry concrete	hrs.	22	13	7	1.5	1	-	-	-	-	-	-
	min.	-	-	-	-	-	45	40	35	30	25	20
Min. curing time in case of holes filled with water	hrs.	44	26	14	3	2	1.5	-	-	-	-	-
	min.	-	-	-	-	-	-	80	70	60	50	40

USING THE CARTRIDGE

- Screw off cap
- Screw static mixer onto the cartridge.



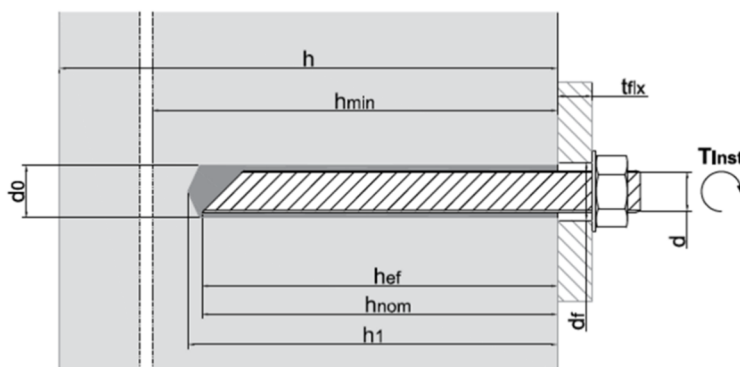
- Insert cartridge into the caulking gun. IMPORTANT: Not suitable for cartridge presses WITHOUT pusher rod!
- Press out 680 ANKER KLEBER until a uniform grey mixture is present in the mixer (do not use the first piece).

PREPARATIONS AND CLEANING OF THE DRILLED HOLE ACCORDING TO ETA-REQUIREMENTS

- Select a suitable drill of adequate size for the part to be fastened and drill at an angle of 90°.
- Use a suitable pump (or compressed air) and steel brush to clean the drilled hole thoroughly removing any dust, concrete fragments, oil, grease and any other impurities before injecting the mortar. Check the diameter of the steel brush before brushing.
- Cleaning in case of compact materials such as concrete or solid stone: blow out hole 4 times, brush 4 times and blow out again 4 times.
- Cleaning in case of non-compact materials such as hollow bricks: blow out hole 4 times, brush 2 times and low out again 4 times.

Theoretical consumption / number of calculated anchors

Fastening in concrete or solid brick			Fastening in perforated brick		
Threaded rod size	Drill hole d0 [mm] x h1 [mm]	Drill hole 2/3 filled *number of calculated anchors	Threaded rod size	Perforated sleeve Dnom [mm] x L [mm]	Perforated sleeves filled *number of calculated anchors
M8	10 x 90	56	M8	12 x 80	28
M10	12 x 95	37	M8	15 x 85	16
M12	14 x 115	25	M10	15 x 85	16
M14	16 x 120	20	M12	15 x 85	16
M16	18 x 130	16	M12	20 x 85	10
M20	24 x 175	6	M16	20 x 85	9
M24	28 x 215	3			



Legend: d [mm] rod diameter
hmin [mm] minimum wall thickness
d0 [mm] drill hole diameter
h1 [mm] drill hole depth
hnom [mm] embedment depth
hef [mm] effective anchor depth
df [mm] attached part drill hole diameter
tfix [mm] attached part thickness
Tinst [Nm] installation torque.

Note: the above-mentioned number (*number of calculated anchors) was calculated from the theoretical volume to fill drill holes or perforated sleeves minus the volume of the threaded rods. A contingency is considered in the theoretical calculation. Application-specific deviation of the actual amount used from the calculated amount may occur.

IMPORTANT NOTE

When using the product take into account the expiry date, ultimate load, and outside temperature. Setting and re-adjustment are possible only within the processing time! Make sure that the adhesive mixture is uniformly grey. Generally good for natural stones. Depending on the type, thickness and capillary activity of the stone, resinification may occur around the adhesive. However, this has no negative influence on the bond strength

ACCESSORIES

- Static mixing pipe
- Mesh sleeve 12 x 50 mm - packaged in bags of 5 units
- Mesh sleeve 15 x 85 mm - packaged in bags of 5 units
- Mesh sleeve 15 x 100 mm - packaged in bags of 5 units
- Mesh sleeve 15 x 135 mm – packed in bags of 5 units
- Mesh sleeve 20 x 85 mm – packed in bags of 5 units
- Blowing pump

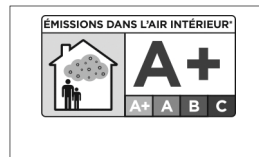
SAFETY ADVICE

Consult the current EC Safety Data Sheet which is available at any time on our website at www.ramsauer.at. Follow the instructions on the label.

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