

# ADHESIVES AND SEALANTS TRANSPORTATION



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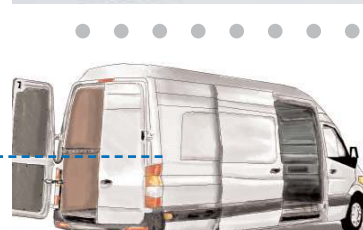
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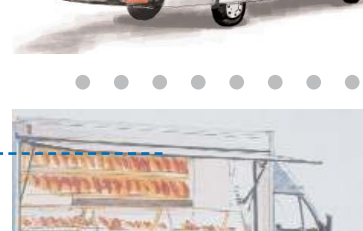
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# KÖRAPUR 115 - KÖRAPUR 125

## ELASTIC PUR ADHESIVES AND SEALANTS

For primed and painted metals, aluminium and steel, wood and duroplastics. For bonding and sealing in the manufacture of containers, vehicles, vehicle bodywork, air conditioning, heating equipment, etc.

|                     |  |
|---------------------|--|
| Base                | Polyurethane, one-component, curing with moisture  |
| Colour              | White, grey, black   |
| Density             | 1,2 g/cm <sup>3</sup>  |
| Viscosity           | Paste, low slump, spreadable, applicable by using a sealant applicator gun   |
| Curing              | 3 mm (after 24 hours)  |
| Elongation at break | 450 %  |
| Tensile strength    | 2 N/mm <sup>2</sup>  |
| Skin formation time | 45 minutes   |
| Properties          | Elastic, good resistance to humidity, weathering and temperatures from -40°C to +90°C (up to +120°C for short intervals), overpaintable after curing |



Inside sealing with Körapur 115

### KÖRAPUR 115

*Elastic one-component PUR sealant, also suitable for bonding applications*



Sealing application with Körapur 125

### KÖRAPUR 125

*Elastic one-component PUR sealant, also suitable for bonding applications. Approval for contact with foodstuffs.*

|                           |        |        |
|---------------------------|--------|--------|
| Hardness Shore A          | 50     | 48     |
| Change in volume          | 7 %    | 6 %    |
| Tear propagation strength | 6 N/mm | 9 N/mm |

|                 |                            |                            |
|-----------------|----------------------------|----------------------------|
| Packaging units | 290 ml aluminium cartridge | 310 ml aluminium cartridge |
|                 | 570 ml sausage             | 600 ml sausage             |
|                 |                            | 23 kg hobbock              |
|                 |                            | 230 kg drum                |

## PRODUCT INFORMATION

### KÖRAPUR 115 - KÖRAPUR 125

Processing temperature +5°C to +35°C

Preparation The surfaces must be dry, clean and free from grease. Adhesion to plastics and paints must be tested for compatibility by carrying out preliminary tests. For the cleaning of the substrate we recommend Körasolv PU or CR. In case of powder coated substrates Körasolv WL should be used. To increase bond strength of non porous substrates such as glass, glass-fibre reinforced plastics, aluminium, stainless steel, etc. we recommend the use of Körabond HG 81 or HG 83. For porous substrates such as wood, Körabond HG 74 E is recommended. For certain plastics such as ABS or PVC adhesion can be improved by the use of Körabond HG 77. Users are advised to confirm the compatibility and suitability of the products with their own test.

Bonding Apply the material onto the substrate, using a spatula or a sealant applicator gun. The thickness of the adhesive layer will depend on the type of materials to be bonded. The materials to be bonded should be pressed firmly together within 20 minutes after application of the sealant adhesive. We recommend mechanical fixing until a complete cure is obtained. Curing time depends on temperature, humidity and joint dimensions.

Storage Do not store at temperatures below +5°C or above +25°C. Stored in unopened containers, usable for up to 9 months.

Cleaning Clean tools immediately after use with Körasolv PU. Cured material can only be removed mechanically.

#### For safety information refer to the Material Safety Data Sheet

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# KÖRAPUR 128 - KÖRAPUR 128 / 2-part

## ELASTIC PUR ADHESIVES AND SEALANTS

For primed and painted metals, aluminium and steel, wood and duroplastics.

For bonding in the manufacture of containers, vehicles, vehicle bodywork, air conditioning and heating equipment, metalwork, etc.

|                     |   |
|---------------------|---|
| Base                | Polyurethane, curing with moisture  |
| Density             | 1,2 g/cm <sup>3</sup>   |
| Curing              | 3 mm (after 24 hours)   |
| Elongation at break | 450 %   |
| Tensile strength    | 2 N/mm <sup>2</sup>   |
| Hardness Shore A    | 45  |
| Properties          | Elastic, good resistance to humidity, weathering and temperatures from -40°C to +90°C (up to +120°C for short intervals), overpaintable after curing.<br>For a faster curing system we recommend the use of Körapur 128 / 2-part plus hardener Köracur 110. |



*Floor construction with Körapur 128*

### KÖRAPUR 128

*Elastic one-component PUR-sealant, self levelling, for various sealing and bonding applications*



*Sealing of a roof element with Körapur 128 / 2-part*

### KÖRAPUR 128 / 2-part

*Elastic PUR-sealant, also suitable for bonding applications*

|                           |                                 |                  |
|---------------------------|---------------------------------|------------------|
| Colour                    | White, approx. RAL 9010         |                  |
| Viscosity                 | Self levelling, easy to process | Paste, low slump |
| Skin formation time       | 35 minutes                      | -                |
| Pot life                  | -                               | 15 minutes       |
| Change in volume          | 9 %                             | < 1 %            |
| Tear propagation strength | 6 N/mm                          | 4 N/mm           |

|                |                |  |
|----------------|----------------|--|
| Packaging unit | 600 ml sausage | 310 ml aluminium cartridge<br>600 ml sausage<br>23 kg hobbock<br>230 kg drum |
|----------------|----------------|--|

## PRODUCT INFORMATION

### KÖRAPUR 128 - KÖRAPUR 128 / 2-part

Processing temperature +5°C to +35°C

**Preparation** The surfaces to be bonded must be dry, clean and free from grease. Adhesion to plastics and paints must be tested for compatibility by carrying out preliminary tests. For the cleaning of the substrate we recommend Körasolv PU or CR. In case of powder coated substrates Körasolv WL should be used. To increase bond strength of non porous substrates such as glass, glassfibre reinforced plastics, aluminium, stainless steel, etc. we recommend the use of Körabond HG 81 or HG 83. For porous substrates such as wood, Körabond HG 74 E is recommended. For certain plastics such as ABS or PVC adhesion can be improved by the use of Körabond HG 77. Users are advised to confirm the compatibility and suitability of the products with their own test.

**Bonding** Apply the material onto the substrate, using a spatula or a sealant applicator gun. The thickness of the adhesive layer will depend on the type of materials to be bonded. The materials to be bonded should be pressed firmly together within 20 minutes after application of the sealant adhesive. We recommend mechanical fixing until a complete cure is obtained. Curing time depends on temperature, humidity and joint dimensions.

**Storage** Do not store at temperatures below +5°C or above +25°C. Stored in unopened containers, usable for up to 9 months.

**Cleaning** Clean tools immediately after use with Körasolv PU. Cured material can only be removed mechanically.

#### For safety information refer to the Material Safety Data Sheet

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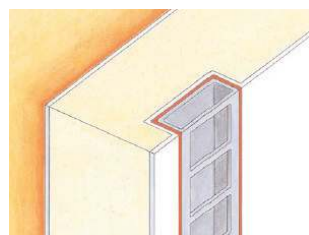


# KÖRAPUR 140 - KÖRAPUR 140 / 2-part

## ELASTIC PUR ADHESIVES AND SEALANTS

Elastic, moisture curing one- and two-component adhesives for primed and painted metals, aluminium and steel, wood and duroplastics. For bonding in the manufacture of containers, vehicles, vehicle bodywork, air conditioning and heating equipment.

|                     |   |
|---------------------|---|
| Base                | Polyurethane, curing with moisture  |
| Colour              | White, grey, black  |
| Density             | 1,2 g/cm <sup>3</sup>   |
| Viscosity           | Paste, low slump  |
| Skin formation time | 45 minutes  |
| Elongation at break | 400 %   |
| Tensile strength    | 4 N/mm <sup>2</sup>   |
| Shear strength      | 3 N/mm <sup>2</sup> (at a layer thickness of 2 mm)  |
| Tear strength       | 7 N/mm  |
| Change in volume    | 7 %   |
| Hardness Shore A    | 55  |
| Properties          | Elastic, good resistance to humidity, weathering and temperatures from -40°C to +90°C (up to +120°C for short intervals). Overpaintable after curing.<br>For a faster curing system we recommend the use of Körapur 140 / 2-part plus hardener Köracur 110. |



*Bonding of double-deck loading rails with Körapur 140*

### KÖRAPUR 140

*Elastic one-component PUR adhesive*



*Bonding of edge profiles with Körapur 140 / 2-part*

### KÖRAPUR 140 2-part

*Elastic PUR adhesive with optimum strength*

|                 |  |                              |
|-----------------|--|------------------------------|
| Pot life        | -  | 20 min                       |
| Curing          | 3 mm (after 24 hours)  | 2-3 hours                    |
| Packaging units | 310 ml aluminium cartridge<br>600 ml sausage<br>23 kg hobbock<br>230 kg drum | 23 kg hobbock<br>230 kg drum |

## PRODUCT INFORMATION

### KÖRAPUR 140 - KÖRAPUR 140 / 2-part

Processing temperature +5°C to +35°C

Preparation The surfaces to be bonded must be dry, clean and free from grease. Adhesion to plastics and paints must be tested for compatibility by carrying out preliminary tests. For the cleaning of the substrate we recommend Körasolv PU or CR. In case of powder coated substrates Körasolv WL should be used. To increase bond strength of non porous substrates such as glass, glassfibre reinforced plastics, aluminium, stainless steel, etc. we recommend the use of Körabond HG 81 or HG 83. For porous substrates such as wood, Körabond HG 74 E is recommended. For certain plastics such as ABS or PVC adhesion can be improved by the use of Körabond HG 77. Users are advised to confirm the compatibility and suitability of the products with their own test.

Bonding Apply the material onto the substrate, using a sealant applicator gun. The thickness of the adhesive layer will depend on the type of materials to be bonded. The materials to be bonded should be pressed firmly together within 10 minutes after application of the sealant adhesive. We recommend mechanical fixing until a complete cure is obtained. Curing time depends on temperature, humidity and joint dimensions.

Storage Do not store below +5°C or above +25°C.  
Stored in unopened containers, usable for up to 9 months.

Cleaning Clean tools immediately after use.  
Cured material can only be removed mechanically.

#### For safety information refer to the Material Safety Data Sheet

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# KÖRAPOP 225 - KÖRAPOP 225 / 2-part

## ELASTIC STP ADHESIVES AND SEALANTS

For the manufacturing of vehicles, vehicle bodywork, containers, air conditioning, heating equipment, metalwork, etc.  
 Good adhesion to glass, many kinds of metals (zinc, aluminium, steel), painted and primed surfaces, wood, duroplastics and some thermoplastics. Approval for contact with foodstuffs. Excellent UV resistance.  
 Can be used without primer on a variety of substrates after cleaning.

|                           |  |
|---------------------------|--|
| Base                      | ST polymer, curing with moisture   |
| Colour                    | White (further colours on request)   |
| Density                   | 1,44 g/cm <sup>3</sup>   |
| Viscosity                 | Paste, low slump   |
| Skin formation time       | 25 minutes   |
| Elongation at break       | 500 %  |
| Tensile strength          | 3,0 N/mm <sup>2</sup>  |
| Tear propagation strength | 20 N/mm (DIN 53 515)   |
| Hardness Shore A          | 42   |
| Properties                | Elastic, good resistance to humidity, weathering and temperatures from -40°C to +80°C (up to +120°C for short intervals). Can be overpainted immediately after application. Isocyanate and silicone free. Adhesion to plastics and paints must be tested for compatibility by carrying out preliminary tests.<br>For a faster curing we recommend the use of Körapop 225 / 2-part plus hardener Köracur 310. |



*Bonding and sealing of the luggage compartment flaps with Körapop 225*

### KÖRAPOP 225

*ST polymer, spreadable,*



*Bonding of edge profiles with Körapop 225 / 2-part*

### KÖRAPOP 225 / 2-part

*ST polymer, solvent free,*

|                 |   |  |
|-----------------|---|--|
| Pot life        | -   | 20 minutes                                       |
| Curing          | 3 mm (after 24 hours)   | 2-3 hours  |
| Packaging units | 310 ml PE-cartridge<br>600 ml sausage<br>25 kg hobbock<br>270 kg drum | 220 ml cartridge<br>25 kg hobbock<br>270 kg drum |

## PRODUCT INFORMATION

### KÖRAPOP 225 - KÖRAPOP 225 / 2-part

|                        |  |
|------------------------|--|
| Processing temperature | +5°C to +30°C  |
| Preparation            | The surfaces to be bonded must be dry, clean and free from dust and grease. Adhesion to plastics and paints must be tested for compatibility by carrying out preliminary tests. Körapop 225 and Körapop 225 / 2-part can be used without primer on most materials. Users are advised to confirm compatibility and suitability with their own tests.                          |
| Bonding                | Apply Körapop 225 using a sealant applicator gun. The thickness of the layer depends on the type and the expected movement of the material to be bonded. Join the materials within 10 minutes and press firmly together. We recommend mechanical fixing until a complete cure is obtained. Curing time depends on temperature, humidity and thickness of the adhesive layer. |
| Storage                | Do not store below +5°C or above +25°C.<br>Stored in unopened containers, usable for up to 12 months.  |
| Cleaning               | Clean tools immediately after use with Körasolv PU.<br>Cured material can only be removed mechanically.  |

#### For safety information refer to the Material Safety Data Sheet

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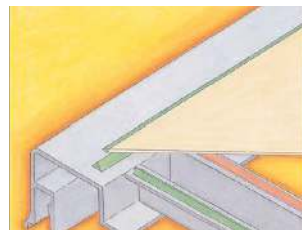
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# KÖRAPOP 235 - KÖRAPOP 240

## ELASTIC STP ADHESIVES AND SEALANTS

For the manufacture of vehicles, vehicle bodywork and containers.  
 Good adhesion to glass, many kinds of metal, primed and painted surfaces, wood, duroplastics and some thermoplastics.  
 Excellent UV-resistance.  
 Can be used without primer on a variety of substrates after cleaning.

|                     |  |
|---------------------|--|
| Base                | MS-polymer, one-component, curing with moisture  |
| Colour              | White (further colours on request)   |
| Viscosity           | Paste, low slump   |
| Skin formation time | 10 minutes   |
| Tensile strength    | 3,3 N/mm <sup>2</sup>  |
| Properties          | Elastic, good resistance to humidity, weathering and temperatures from -40°C to +90°C (up to +120°C for short intervals).<br>Overpaintable after curing. Isocyanate and silicone free. Adhesion to plastics and paints must be tested for compatibility by carrying out preliminary tests. |



*Assembly of roof profiles with Körapop 235*

### KÖRAPOP 235

*ST polymer, spreadable, excellent mechanical properties*



*Bonding and sealing of mountings made of thermoplastic materials with Körapop 240*

### KÖRAPOP 240

*Good cataplasma properties*

|                           |                        |                        |
|---------------------------|------------------------|------------------------|
| Density                   | 1,44 g/cm <sup>3</sup> | 1,41 g/cm <sup>3</sup> |
| Elongation at break       | 550 %                  | 430 %                  |
| Shear strength            | 2,2 N/mm <sup>2</sup>  | 2,7 N/mm <sup>2</sup>  |
| Tear propagation strength | 24 N/mm                | 21 N/mm                |
| Hardness Shore A          | 50                     | 55                     |

|                 |                     |                     |
|-----------------|---------------------|---------------------|
| Packaging units | 310 ml PE-cartridge | 310 ml PE-cartridge |
|                 | 600 ml sausage      | 600 ml sausage      |
|                 | 25 kg hobbock       | 25 kg hobbock       |
|                 | 270 kg drum         | 270 kg drum         |

## PRODUCT INFORMATION

### KÖRAPOP 235 - KÖRAPOP 240

Processing temperature +5°C to +30°C

**Preparation** The surfaces to be bonded must be dry, clean and free from dust and grease. Adhesion to plastics and paints must be tested for compatibility by carrying out preliminary tests. Körapop 235 and Körapop 240 can be used without primer on most materials. Users are advised to confirm compatibility and suitability with their own tests.

**Bonding** Apply material to the substrate using a sealant applicator gun. The thickness of the layer will depend on the types of material to be bonded. Join the materials to be bonded within 5 minutes after application and press firmly together. We recommend mechanical fixing until a complete cure is obtained. The curing time depends on temperature, humidity and joint dimensions.

**Storage** Do not store below +5°C or above +25°C.  
Stored in unopened containers, usable for up to 9 months.

**Cleaning** Clean tools immediately after use with Körasolv PU.  
Cured material can only be removed mechanically.

#### For safety information refer to the Material Safety Data Sheet

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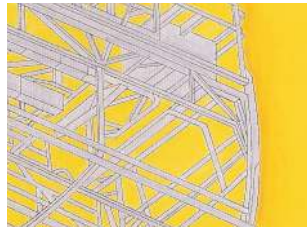
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# KÖRAPOP 316 - KÖRAPOP 330

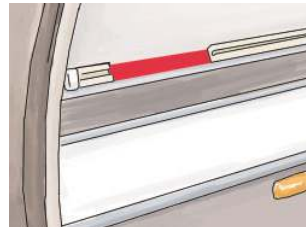
## ELASTIC STP ADHESIVES AND SEALANTS

For the manufacture of vehicles, vehicle bodywork and containers.  
 Good adhesion to glass, many metals, painted and primed surfaces, wood, duroplastics and some thermoplastics.  
 Excellent UV resistance.  
 Can be used without primer on a variety of substrates.

|                     |   |
|---------------------|---|
| Base                | Silane terminated polymers, curing with moisture  |
| Colour              | White (further colours on request)  |
| Viscosity           | Paste, low slump  |
| Skin formation time | 10 minutes  |
| Tear strength       | 3,3 N/mm <sup>2</sup>   |
| Properties          | Elastic, good resistance to humidity, weathering and temperatures from -40°C to +90°C (up to +120°C for short intervals).<br>Overpaintable after curing. Isocyanate and silicone free.<br>Adhesion to plastics and paints must be tested for compatibility by carrying out preliminary tests. |



Sealing of weld seams with Körapop 316



Bonding of decorative strips with Körapop 330

### KÖRAPOP 316

*ST-Polymer, spreadable and sprayable, excellent mechanical properties*

### KÖRAPOP 330

*High initial tack*

|                           |                        |                        |
|---------------------------|------------------------|------------------------|
| Density                   | 1,44 g/cm <sup>3</sup> | 1,60 g/cm <sup>3</sup> |
| Elongation at break       | 550 %                  | 200 %                  |
| Shear strength            | 2,2 N/mm <sup>2</sup>  | 1,3 N/mm <sup>2</sup>  |
| Tear propagation strength | 24 N/mm                | 10 N/mm                |
| Hardness Shore A          | 50                     | 58                     |

|                 |                                       |                                       |
|-----------------|---------------------------------------|---------------------------------------|
| Packaging units | 310 ml PE-cartridge<br>600 ml sausage | 310 ml PE-cartridge<br>600 ml sausage |
|-----------------|---------------------------------------|---------------------------------------|

## PRODUCT INFORMATION

### KÖRAPOP 316 - KÖRAPOP 330

Processing temperature +5°C to +30°C

Preparation The surfaces to be bonded must be dry, clean and free from dust and grease. Adhesion to plastics and paints must be tested for compatibility by carrying out preliminary tests. Körapop 316 and Körapop 330 can be used without primer on most materials. Users are advised to confirm compatibility and suitability with their own tests.

Bonding Apply material onto the substrate using a sealant applicator gun. The thickness of the layer will depend on the types of material to be bonded. Join the materials to be bonded within 5 minutes after application. The curing time depends on temperature, humidity and joint dimensions.

Storage Do not store below +5°C or above +25°C.  
Stored in unopened containers, usable for up to 9 months.

Cleaning Clean tools immediately after use with Körasolv PU.  
Cured material can only be removed mechanically.

#### For safety information refer to the Material Safety Data Sheet

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# KÖRAPUR 666 - KÖRAPUR 672

## 2-PART PUR REACTIVE ADHESIVES

Reactive adhesive for the assembly bonding in the vehicle manufacturing. Good adhesion to wood, aluminium and steel, duroplastics and some thermoplastics.

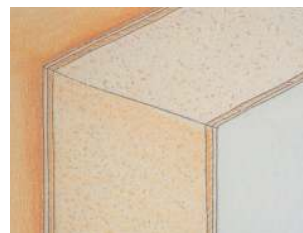
|            |   |
|------------|---|
| Base       | Polyurethane, two component, solvent free   |
| Colour     | Beige   |
| Properties | Good resistance to humidity, weathering, good adhesion to aluminium, wood, PVC (rigid), GRP |



*Bonding of floor elements with Körapur 666*

### KÖRAPUR 666

*Specially suitable for the bonding of floor elements in the manufacture of refrigerated vehicles*



*Bonding of a 5-layer-sandwich element with Körapur 672*

### KÖRAPUR 672

*Medium pot life, medium open time, good adhesion properties on wood*

|                  |  |  |
|------------------|--|--|
| Pot life         | Variable (3-90 min)  | Variable (20-80 min)   |
| Density          | 1,70 g/cm <sup>3</sup> (resin)<br>1,23 g/cm <sup>3</sup> (hardener)<br>1,63 g/cm <sup>3</sup> (mixing)                         | 1,67 g/cm <sup>3</sup> (resin)<br>1,23 g/cm <sup>3</sup> (hardener)<br>1,60 g/cm <sup>3</sup> (mixing) |
| Viscosity        | 50.000 mPas (mixing)   | ca. 8.000 mPas (mixing)  |
| Mix ratio        | Resin : hardener<br>6 : 1 (by weight)  | Resin : hardener<br>5 : 1 (by weight)  |
| Initial strength | 12-16 h (at 20 °C and pot life 90 min)   | 8 h (at 20 °C and pot life 60 min)   |
| Shear strength   | <u>Aluminium / wood</u><br>17 N/mm <sup>2</sup> at -20 °C<br>14 N/mm <sup>2</sup> at +20 °C<br>3,5 N/mm <sup>2</sup> at +80 °C | -  |

|                 |  |   |
|-----------------|--|---|
| Packaging units | 0,350 kg mixing cartridge<br>1 kg mixing unit<br>6 kg pail<br>30 kg hobbock<br>300 kg drum | 5 kg pail<br>30 kg hobbock<br>300 kg drum<br>1.300 kg container |
|-----------------|--|---|



## PRODUCT INFORMATION

### KÖRAPUR 666 - KÖRAPUR 672

Processing temperature +5°C to +25°C

Preparation The surfaces to be bonded must be dry, clean and free from dust and grease. We recommend that metal surfaces are prepared by abrasion. A primer may be applied to improve ageing and hydrolysis resistance. Mix A and B component thoroughly (approx. 400 rpm) until an even colour is obtained. Please follow the instructions for the use of mixing cartridges.

Bonding Apply the material evenly onto the surfaces to be bonded using a spatula and press firmly together. Maximum bond strength is achieved after 36 hours when using Körapur 666 and after 24 hours when using Körapur 672.

Storage Do not store below +10°C or above +25°C. Stored in unopened containers, usable for up to 12 months.

Cleaning Clean tools immediately after use with Körasolv PU. Cured material can only be removed mechanically. When using Körapur 666 or Körapur 672 direct skin contact with the uncured adhesive must be avoided. Wear protective gloves.

#### For safety information refer to the Material Safety Data Sheet

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# KÖRAPUR 840 - KÖRAPUR 842

## 2-PART PUR REACTIVE ADHESIVE

Reactive adhesive for the assembly bonding in the vehicle manufacturing.  
 Good adhesion to aluminium and steel, duroplastics and some thermoplastics.  
 Good damping properties.

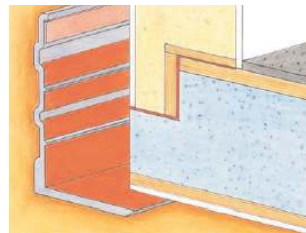
|            |  |
|------------|--|
| Base       | Polyurethane, two component, solvent free  |
| Colour     | Beige                                      |
| Properties | Good resistance to humidity and weathering |
| Mix ratio  | Resin : hardener = 5 : 1 (by weight)       |



*Bonding of a skirting board with Körapur 840*

### KÖRAPUR 840

*For the bonding of skirting boards, double floor case rails, etc.*



*Assembly bonding with Körapur 842*

### KÖRAPUR 842

*Excellent impact resistance, non sag properties at thin layers*

|                           |   |  |
|---------------------------|---|--|
| Pot life                  | Variable (2 / 8 / 15 / 20 / 45 min)   | Variable (15 / 20 / 80 min)  |
| Initial strength          | 40 minutes - 8 hours at +20 °C<br>(depending on the pot life)   | 3-12 hours at +20 °C<br>(depending on the pot life)  |
| Density                   | 1,55 g/cm <sup>3</sup> (resin)<br>1,23 g/cm <sup>3</sup> (hardener)<br>1,45 g/cm <sup>3</sup> (mixing)                              | 1,50 g/cm <sup>3</sup> (resin)<br>1,23 g/cm <sup>3</sup> (hardener)<br>1,46 g/cm <sup>3</sup> (mixing)                           |
| Viscosity                 | 40.000 mPas (mixing)  | 55.000 mPas (mixing)   |
| Tear propagation strength | <u>Aluminium / aluminium</u><br>24 N/mm <sup>2</sup> at -20 °C<br>16 N/mm <sup>2</sup> at +20 °C<br>4,4 N/mm <sup>2</sup> at +80 °C | <u>Aluminium / aluminium</u><br>13 N/mm <sup>2</sup> at -20 °C<br>9 N/mm <sup>2</sup> at +20 °C<br>3 N/mm <sup>2</sup> at +80 °C |

|                 |   |   |
|-----------------|---|---|
| Packaging units | 0,540 kg tandem cartridge<br>0,360 kg mixing cartridge<br>5 kg pail<br>30 kg hobbock<br>300 kg drum | 0,360 kg missing cartridge<br>300 kg drum |
|-----------------|---|---|

## PRODUCT INFORMATION

### KÖRAPUR 840 - KÖRAPUR 842

Processing temperature +5°C to +25°C

Preparation The surfaces to be bonded must be dry, clean and free from dust and grease. Metals must normally be pre-treated and possibly sanded. A primer may be applied to improve ageing and hydrolysis resistance. Mix A and B component thoroughly (approx. 400 rpm), until an even colour is obtained. Please follow the processing instructions for mixing cartridges.

Bonding Apply the adhesive evenly to the substrates to be bonded using a spatula and press firmly together. When using Körapur 840 or 842 bonding can be easily stressed after 12-16 hours. Final bond strength is achieved after 24 hours.

Storage Do not store below +10°C or above +25°C.  
Stored in unopened containers, usable for up to 12 months.

Cleaning Clean tools immediately after use with Körasolv PU. Cured material can only be removed mechanically. When using Körapur 840 or Körapur 842 direct skin contact with the uncured adhesive must be avoided. Wear protective gloves.

#### For safety information refer to the Material Safety Data Sheet

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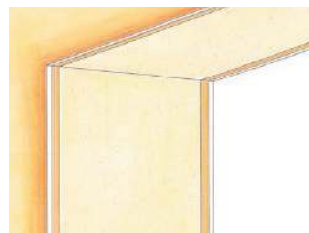
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# KÖRAPUR 572 - KÖRAPUR 648

## 2-PART PUR REACTIVE ADHESIVE

For the bonding of sandwich elements in the manufacture of refrigerated and commercial vehicles, caravans, etc.  
 Good adhesion to wood, aluminium and steel, GRP, duroplastics and some thermoplastics.

|            |   |
|------------|---|
| Base       | Polyurethane, two component, solvent free                                 |
| Colour     | Beige   |
| Properties | Good resistance to humidity and weathering, excellent adhesion properties |



*Bonding of a sidewall element with Körapur 572*

### KÖRAPUR 572

*Medium pot life,  
medium viscosity*



*Bonding of a 4-layer sandwich element*

### KÖRAPUR 648

*Long pot life,  
long open time,  
low viscosity*

|                  |  |  |
|------------------|--|--|
| Density          | 1,65 g/cm <sup>3</sup> (resin)<br>1,23 g/cm <sup>3</sup> (hardener)<br>1,60 g/cm <sup>3</sup> (mixing) | 1,49 g/cm <sup>3</sup> (resin)<br>1,23 g/cm <sup>3</sup> (hardener)<br>1,42 g/cm <sup>3</sup> (mixing) |
| Viscosity        | ca. 8.000 mPas (mixing)  | ca. 1.400 mPas (mixing)  |
| Mx ratio         | Resin : hardener<br>5 : 1 (by weight)  | Resin : hardener<br>3,5 : 1 (by weight)  |
| Pot life         | 60 minutes   | 120 minutes  |
| Open time        | 90 minutes   | 180 minutes  |
| Initial strength | 6-8 hours  | 12-16 hours  |

|                 |             |  |
|-----------------|-------------|--|
| Packaging units | 300 kg drum | 30 kg hobbock<br>270 kg drum<br>1.300 kg container |
|-----------------|-------------|--|

## PRODUCT INFORMATION

### KÖRAPUR 572 - KÖRAPUR 648

|                        |   |
|------------------------|---|
| Processing temperature | +5°C to +25°C   |
| Preparation            | The surfaces to be bonded must be dry, clean and free from dust and grease. Metals must normally be pre-treated and possibly sanded. A primer may be applied to improve ageing and hydrolysis resistance. Mix A and B component thoroughly (approx. 400 rpm), until an even colour is obtained.                 |
| Bonding                | Apply the adhesive to the substrates to be bonded evenly using a brush or a roll and press firmly together. The thickness of the adhesive layer depends on the type of materials to be bonded. Final bond strength is achieved after 24 hours when using Körapur 572 and after 36 hours when using Körapur 648. |
| Storage                | Do not store below +10°C or above +25°C.<br>Stored in unopened containers, usable for up to 12 months.  |
| Cleaning               | Clean tools immediately after use with Körasolv PU.<br>Cured material can only be removed mechanically.<br>When using Körapur 572 or Körapur 648 direct skin contact with the uncured adhesive must be avoided. Wear protective gloves.   |

#### For safety information refer to the Material Safety Data Sheet

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# KÖRACOLL WB 12 - KÖRACOLL 3350

## SOLVENT FREE DISPERSION ADHESIVES

For bonding applications in the construction of passenger vehicles, including floor and wall covering trim, sound and thermal insulation and decorative laminates. Also bonds to wood, sheet metal, GRP and PUR elements, as well as painted surfaces.

Universal adhesive for different kinds of application.

|            |   |
|------------|---|
| Colour     | White   |
| Density    | 1,0 g/cm <sup>3</sup> (at +23°C)  |
| Properties | Filling, tough, extensively resistant to humidity, good resistance to temperatures up to approx. +110°C |



*Bonding of floor coverings with Köracoll WB 12*

**KÖRACOLL WB 12**  
*Universal adhesive for a wide range of applications*



*Bonding of wall and floor coverings with Köracoll 3350*

**KÖRACOLL 3350**  
*Suitable for low temperature activation*

|                        |  |  |
|------------------------|--|--|
| Base                   | EVA / acrylic ester copolymer with self cross linking properties   | Polyurethane   |
| Viscosity              | 9.000 - 13.000 mPas, rollable, sprayable, spreadable and brushable | 5.000 mPas   |
| Solid content          | 68 %   | 49 %   |
| Hardener               | -  | Köracur D group                                      |
| Mix ratio              | -  | 100 : 5  |
| Pot life               | -  | 8 Stunden  |
| Activating temperature | -  | ca. +45°C (depending on the intermediate storage)    |
| Consumption            | 250-400 g/m <sup>2</sup> (depending on the substrate)              | 60-120 g/m <sup>2</sup> (depending on the substrate) |

|                 |                    |           |
|-----------------|--------------------|-----------|
| Packaging units | 10 kg plastic pail | 5 kg pail |
|-----------------|--------------------|-----------|

# PRODUCT INFORMATION

## KÖRACOLL WB 12 - KÖRACOLL 3350

Processing temperature +15°C to +35°C

Preparation The surfaces to be bonded must be dry, clean and free from dust and grease. Please follow the processing instructions!

### KÖRACOLL WB 12

Bonding

For one-side application, apply an even layer of the adhesive to the substrate to be bonded using a toothed trowel. Immediately, not later than 10 minutes after application of the adhesive, join the substrates together and use a brush or a roller to ensure complete contact. Remove any excess adhesive with water immediately. Open assembly time is approx. 20 minutes. For contact bonding apply the adhesive to the materials to be bonded using a spatula or brush and allow to dry for approx. 20-40 minutes. Join the two substrates and press firmly together. Do not expose the bond to mechanical stress during the first 3-8 hours of the curing time.

### KÖRACOLL 3350

The adhesive is applied by spraying equipment gun with a pressure of 3-5 bar and a nozzle of 1.5 mm diameter. After curing (approx. 60 minutes at room temperature, can be accelerated by heat) the adhesion follows in, depending on the substrate in vacuum drawing process or heated squeezer (membrane pressing). The sealing time depends on the heat conductance of the materials. Sealing time and heat conductance have to be determined in pre-tests. The maximum temperature resistance is reached after 3-4 days.

Cleaning

Clean tools immediately after use with Körasolv PU. Cured material can only be removed mechanically. When using Köracoll WB 12 or Köracoll 3350 direct skin contact with the uncured adhesive must be avoided. Wear protective gloves.

### For safety information refer to the Material Safety Data Sheet

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# KÖRAPREN FU 35 - KÖRAPREN FU 36

## POLYCHLOROPRENE CONTACT ADHESIVE

Universal contact adhesive for the vehicle manufacturing. For the bonding of wall and floor coverings, as well as decorative PVC sheets to wood (chipboards, plywood), PVC and rubber profiles. Not suitable for bonding of polystyrene rigid foam.

|             |  |
|-------------|--|
| Base        | Polychloroprene, solvent containing                    |
| Density     | 0,86 g/cm <sup>3</sup>                                 |
| Consumption | 250-300 g/cm <sup>3</sup> (depending on the substrate) |



*Bonding of wall coverings in the manufacture of buses and coaches, caravans, etc. with Körapren FU 35*

### KÖRAPREN FU 35

*Sprayable, for larger surface areas*



*Bonding of floor coverings with Körapren FU 36*

### KÖRAPREN FU 36

*Universal contact adhesive, spreadable, also suitable for bonding on mineral substrates and metal*

|               |   |                                     |
|---------------|---|-------------------------------------|
| Colour        | Light yellowish, transparent                                | Amber                               |
| Viscosity     | 400 mPas  | 3.200 mPas                          |
| Solid content | 21 %  | 25 %                                |
| Properties    | High contact adhesion, good resistance to humidity and heat | Conditionally resistant to humidity |

|                 |                              |  |
|-----------------|------------------------------|--|
| Packaging units | 10 kg hobbock<br>170 kg drum | 750 g tin<br>5 kg pail<br>12,5 kg hobbock<br>25 kg hobbock |
|-----------------|------------------------------|--|

# PRODUCT INFORMATION

## KÖRAPREN FU 35 - KÖRAPREN FU 36

|                        |  |
|------------------------|--|
| Processing temperature | +12°C to +25°C   |
| Preparation            | The surfaces to be bonded must be dry, clean and free from dust and grease.          |
| Storage                | Stored in the unopened container between +10°C and +25°C usable for up to 12 months. |
| Cleaning               | Clean tools with Körasolv PU.  |

### KÖRAPREN FU 35

### KÖRAPREN FU 36

|         |   |  |
|---------|---|--|
| Bonding | <p>Apply the adhesive with spray jet application evenly on the two parts to be bonded. Pressure and diameter of the nozzle will depend on the application. After a waiting time (ventilation time) of approx. 10-15 minutes place the parts accurately and press firmly together. The waiting time depends on room temperature, thickness of the adhesive layer and absorbancy of the surface. The surfaces should be pressed together when the adhesive film is still slightly sticky but does not stick to the finger when lightly pressed.</p> | <p>Apply the adhesive with a brush or a roll evenly to both surfaces to be bonded. After a waiting time (ventilation time) of approx. 15 minutes place the parts accurately and press briefly, but firmly together. The parts have to be bonded together at least 60 minutes after application. The waiting time depends on room temperature, thickness of the adhesive layer and absorbancy of the surface.</p> |
|---------|---|--|

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# KÖRATAC C 12 - KÖRATAC DF 841

## POLYMER-ADHESIVES

For the bonding of rubber (EPDM, SBR, CR) to a variety of other materials like wood, metal, duromers and the bonding of plastics, foils, etc.

|             |                   |
|-------------|-------------------|
| Base        | Synthetic resin   |
| Colour      | Transparent       |
| Consistency | Easily spreadable |



*Bonding of parts made of rubber onto metals and plastics (except PE, PP etc.) with Köratac C 12*

### KÖRATAC C 12

*Fast curing, solvent free, for smaller surface areas*



*Bonding of door sealings made of soft PVC with Köratac DF 841*

### KÖRATAC DF 841

*For the bonding of soft and rigid PVC and sealings in the manufacture of commercial vehicles*

|             |  |  |
|-------------|--|--|
| Density     | 1,0 g/cm <sup>3</sup>                              | 0,9 g/cm <sup>3</sup>  |
| Consumption | 100-250 g/m <sup>2</sup>                           | 60-100 g/m <sup>2</sup>  |
| Open time   | Less than 30 sec.                                  | Less than 1 minute   |
| Properties  | High contact adhesion, good resistance to humidity | High contact adhesion, high initial strength, good resistance to humidity and heat |

|                 |              |             |
|-----------------|--------------|-------------|
| Packaging units | 20 g bottle  | 1 kg tin    |
|                 | 50 g bottle  | 10 kg can   |
|                 | 100 g bottle | 170 kg drum |

# PRODUCT INFORMATION

## KÖRATAC C 12 - KÖRATAC DF 841

|                        |  |
|------------------------|--|
| Processing temperature | Not below +12°C  |
| Storage                | Do not store below +12°C.<br>Stored in the unopened container, usable for up to 12 months. |
| Cleaning               | Körasolv PU  |

|             | KÖRATAC C 12   | KÖRATAC DF 841   |
|-------------|--|--|
| Preparation | <p>The surfaces to be bonded must be dry, clean and free from dust and grease.</p> <p>As the curing process is started with air humidity, the humidity in the workrooms should amount to 40-70 % r.h.</p>  | <p>Due to the variety of different PVC types, especially soft PVC, preliminary tests have to be carried out for examination of swelling and dissolving characteristics.</p> <p>Clean contaminated foils with Körasolv GL.</p>  |
| Bonding     | <p>Exact dosing by using the applicator nozzle. Join the parts to be bonded together as long as the adhesive film is still wet and press for 10-12 seconds. Within this time the adhesive will only harden partially. The two pieces will nonetheless adhere so tightly that adjustment is no longer possible.</p> <p>Complete curing will be achieved after 24 hours.</p> | <p>Apply Köratoc DF 841 abundantly to one side using a soft brush or spraying equipment. Press both parts immediately together without ventilation, so that a small bead is formed at the overlapping end. If the surfaces to be bonded have already dried too much, the bonding procedure can be repeated. If high initial tack is required, apply Köratoc DF 841 on both sides and press together after a drying time of 2-5 minutes. Köratoc DF 841 may cause a yellow cast on white or very bright foils. This does not cause any negative effect neither to the foil nor to the bond.</p> |

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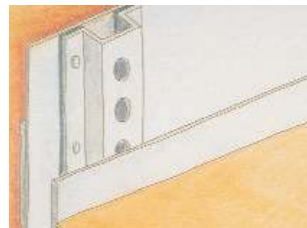
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# KÖDIPLAST CS - KÖDIPLAST CT 100

## BUTYL SEALANTS

For the sealing of external joints, gaps and junctions on surfaces such as wood, metal, glass, many plastics and other materials. Sealant for commercial vehicles, caravans and containers.  
 Not suitable for high movement joints.

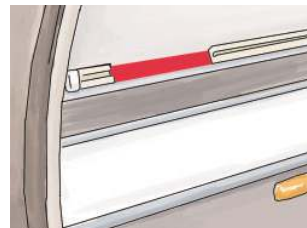
|             |   |
|-------------|---|
| Base        | Butyl rubber, one component   |
| Colour      | Grey  |
| Viscosity   | Paste, spreadable   |
| Shrinkage   | 20 %  |
| Weight loss | 15 %  |
| Properties  | Resistant to temperatures from -30°C to +80°C.<br>Good resistance to weathering. Do not use in contact with oils, solvents and fuels. |



Sealing of riveted profiles with Ködiplast CS

### KÖDIPLAST CS

*Soft, plasty, low slump*



Sealing of screw fittings with Ködiplast CT 100

### KÖDIPLAST CT 100

*Soft, non setting, easily removable*

|         |                        |                        |
|---------|------------------------|------------------------|
| Density | 1,34 g/cm <sup>3</sup> | 1,42 g/cm <sup>3</sup> |
|---------|------------------------|------------------------|

|                 |   |                |
|-----------------|---|----------------|
| Packaging units | 310 ml aluminium cartridge<br>600 ml sausage<br>25 kg hobbock | 570 ml sausage |
|-----------------|---|----------------|

## PRODUCT INFORMATION

### KÖDIPLAST CS - KÖDIPLAST CT 100

|                        |  |
|------------------------|--|
| Processing temperature | +15°C to +25°C   |
| Preparation            | The surfaces to be bonded must be dry, clean and free from dust and grease. To degrease non porous surfaces like glass or metal, use Körasolv GL. Please contact our technical department if the product is used with plastics such as polycarbonate or PMMA (stress cracking!)  |
| Jointing               | Apply the material using a gun, in which the cartridges or sausages are inserted. Trapping of air bubbles have to be avoided. The final seal is achieved after all the volatile materials have evaporated. Evaporation time depends on the temperature and the joint dimension. When using Ködiplast for bonding of EPDM foils a trivial wrinkling of the foil may occur in particular cases. This effect is reversed completely after a short time. |
| Storage                | Do not store below +5°C or above +25°C.<br>Stored in unopened containers, usable for up to 12 months.  |
| Cleaning               | Clean tools and remove fresh spots with Körasolv PU.   |

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# KÖDITEC 114 - KÖDISIL N

## ELASTIC ONE COMPONENT SILICONE SEALANT

For sealing in the manufacture of containers, vehicles, trucks, vans, caravans and sales vehicles.

|            |   |
|------------|---|
| Base       | Silicone rubber, one component, curing with moisture  |
| Properties | Good resistance to weathering and ageing, extensively resistant to many kinds of solvents, oils, fuels, water, some acids, detergents, etc. |



Sealing of engine components with Kōditec 114

### KÖDITEC 114

High temperature resistance from -40 °C to +250 °C



Bonding and sealing of glass counters with Kōdisil N

### KÖDISIL N

Neutral and odourless, fungicide

|                        |                        |   |
|------------------------|------------------------|---|
| Colour                 | Anthracite             | White, transparent  |
| Density                | 1,03 g/cm <sup>3</sup> | 1,27 g/cm <sup>3</sup> (white),<br>1,02 g/cm <sup>3</sup> (transparent) |
| Hardness Shore A       | 17                     | 23 (white)<br>19 (transparent)  |
| Skin formation time    | 10 minutes             | 5 minutes   |
| Max. movement capacity | -                      | 25 %  |

|                 |                                       |                                       |
|-----------------|---------------------------------------|---------------------------------------|
| Packaging units | 310 ml PE cartridge<br>600 ml sausage | 310 ml PE cartridge<br>600 ml sausage |
|-----------------|---------------------------------------|---------------------------------------|



# PRODUCT INFORMATION

## KÖDITEC 114 - KÖDISIL N

|                  |  |
|------------------|--|
| Preparation      | The joints to be sealed must be dry, clean and free from dust and grease. Otherwise adhesion decrease may occur. To degrease non porous surfaces like glass or metal, use Körasolv GL. Please contact our technical department if the product is used with plastics such as polycarbonate or PMMA (stress cracking!)   |
| Jointing         | Apply the sealant into the gap using a sealant applicator gun. To achieve a better wetting, the material should be applied with a certain pressure against the joint edges. Wider joints should be filled in several operations. Apply the sealant to the joint edges at first to ensure the contact to the complete surface of the edges of the joint.  |
| Joint dimensions | The joints to be sealed must be at least 4 mm wide and 4 mm deep. For joint widths up to approx. 5 mm a square cross-section is most suitable. For wider joints the joint depth should be at least half the joint width. Prior to sealing a stable, non absorbant insert material, possibly convex, e.g. polyethylene foam, is to be pressed into the joint in a way that the adhesion surface on the joint flanks is maximised (see DIN 18 540). It is recommended to cover the edges of the gap with self-adhesive tape in order to ensure a clean and straight joint. Triple surface adhesion is to be avoided. |
| Storage          | Do not store below +10°C or above +25°C.<br>Stored in unopened containers, usable for up to 9 months.  |
| Cleaning         | Use Körasolv GL to clean tools and to remove fresh adhesive spots.   |

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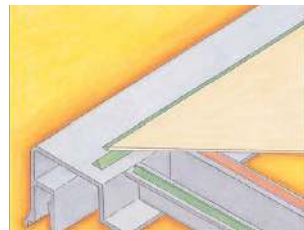
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# KÖRATAPE AT 2 - KÖRATAPE AT 3

## ACRYLIC TAPES

Köratape is designed for use in a wide variety of industrial and construction applications. Typical applications include automotive trim attachment, trail skin-to-frame assembly, signs, graphics, furniture appliance and electrical component assemblies.

|                     |                        |
|---------------------|------------------------|
| Base                | Acrylate, solvent free |
| Thickness           | 0,64 mm to 2,03 mm     |
| Width               | 6,35 mm to 457,2 mm    |
| Service temperature | -35°C to +90°C         |



*For the manufacture of vehicles, vehicle bodywork, containers, air conditioning and heating equipment, metalwork, etc.*



*For primed and painted metals, thermoplastics and duroplastics, assembly aid*

**KÖRATAPE AT 2**  
*Acrylic tape with acrylic foam core*

**KÖRATAPE AT 3**  
*Acrylic tape with solid acrylic core*

|                  |            |             |
|------------------|------------|-------------|
| Colour           | Grey       | Translucent |
| Tensile strength | 0,95 MPa   | 1,4 MPa     |
| Elongation       | 900%       | 500%        |
| Peel strength    | 1,75 N/mm  | 2,63 N/mm   |
| Packaging units  | On request | On request  |

## PRODUCT INFORMATION

### KÖRATAPE AT 2 - KÖRATAPE AT 3

|                         |  |
|-------------------------|--|
| Processing temperature  | +10°C to +35°C   |
| Preparation             | The substrate to be bonded should be dry and free from dust, oil and release agents. Clean the substrate no more than 15 minutes prior to the bonding with Körasolv CR, GL or WL and allow to dry.<br>To remove all contaminants without leaving any residue use a clean, lint-free wiping cloth or disposable wipe. Dispose both wipes afterwards.<br>Ensure optimum temperature of the substrate, not below +15°C. |
| Processing instructions | 1. Apply the adhesive tape onto the cleaned substrate with a recommended application pressure (approx. 2,5 kg/cm <sup>2</sup> ). Adhesive strength depends on the contact between adhesive and the surfaces to be bonded.<br><br>2. Remove the protective liner for the connection to the second substrate and proceed as instructed in step 1.  |
| Storage                 | Stored in unopened original containers at +20°C and 50% r.h. usable for up to 2 years from production time.  |
| Cleaning                | Körasolv CR, GL or WL  |

#### For safety information refer to the Material Safety Data Sheet

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# KÖRAPUR 689 - KÖRAPUR 690

## COATING SYSTEMS

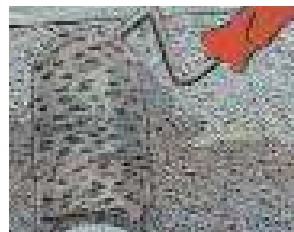
For floor coating in lorries, containers, sales vehicles, mobile shops, caravans, mobile homes, etc. on polyester, aluminium, primed steel sheets and timber.

Particularly suitable for fresh service, meat, fish and deep-freeze vehicles (tested down to -30°C). Permitted to come into contact with foodstuffs, physiologically unobjectionable. Test certificate available.

|            |   |
|------------|---|
| Base       | Polyurethane, two component                                 |
| Colour     | Grey, approx. RAL 7037                                      |
| Properties | Tough, good resistance to abrasion, tested according EN 438 |



Floor coating with Körapur 689



Floor coating with Körapur 690

### KÖRAPUR 689

Self levelling

### KÖRAPUR 690

Test certificate available

|                     |                                 |                                 |
|---------------------|---------------------------------|---------------------------------|
| Density             | 1,40 g/cm <sup>3</sup> (mixing) | 1,14 g/cm <sup>3</sup> (mixing) |
| Viscosity           | 3.600 mPas (mixing)             | 33.000 mPas (mixing)            |
| Mix ratio           | 4 : 1 by weight                 | 3 : 1 by weight                 |
| Consumption         | 2-5 kg/m <sup>2</sup>           | 600-800 g/m <sup>2</sup>        |
| Pot life            | 35 minutes at +20°C             | 120 minutes at +20°C            |
| Tensile strength    | 18 N/mm <sup>2</sup>            | -                               |
| Elongation at break | 15 %                            | -                               |
| Hardness Shore D    | 70                              | -                               |

|                 |   |  |
|-----------------|---|--|
| Packaging units | 15 kg mixing unit<br>in stacked container | 6 kg mixing unit<br>in stacked container |
|-----------------|---|--|

# PRODUCT INFORMATION

## KÖRAPUR 689 - KÖRAPUR 690

|                        |   |
|------------------------|---|
| Processing temperature | +15°C to +25°C  |
| Coating                | Please follow the processing instructions.  |
| Storage                | Do not store below +5°C or above +25°C.<br>Stored in unopened containers, usable for up to 12 months.   |
| Cleaning               | Clean tools immediately after use with Körasolv PU.<br>Cured material can only be removed mechanically. |

### KÖRAPUR 689

### KÖRAPUR 690

|             |  |  |
|-------------|--|--|
| Preparation | <p>The surface to be coated must be adjusted horizontally and must be dry and free from dust and grease. The substrates must be properly prepared to ensure good adhesion. Uncoated wooden sheets must not exceed 8-12% moisture content. Previously coated wooden sheets must be completely abraded. Sheet joints must be connected by key and slot joint and preferably bonded. If necessary glass fibre cloth should be placed over the joint to prevent cracking of the top coat. Large holes and deepening must be filled with Körapur 666 prior to the application. Polyester, stainless steel and aluminium must be degreased and grinded. Polyester surfaces which may contain release agents such as paraffin waxes should be thoroughly abraded to ensure good adhesion. Stainless steel or aluminium surfaces must be degreased. When repairing older floors particular care must be given to the pre-treatment. Good results can be achieved with sand blasting.</p> | <p>The surfaces must be dry, clean and free from dust and grease. The substrates must be properly prepared to ensure good adhesion. This includes mechanical and/or chemical pre-treatment. When repairing older floors particular care must be given to the pre-treatment. Good results can be achieved with sand blasting.</p> |
|-------------|--|--|

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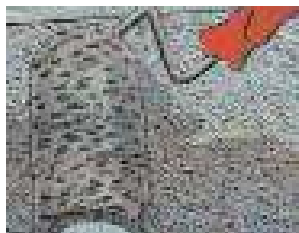
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# KÖRAPOX BS 85 - KÖRAPOX BS 90

## EPOXY RESIN SEALING

For non-slipping sealing of coated floors in lorries, containers, sales vehicles, caravans, camping cars, etc.  
 Particularly suitable for fresh service, meat, fish and deep-freeze vehicles (tested down to -30°C). Permitted to come into contact with foodstuffs, physiologically unobjectionable. Test certificate available!

|            |   |
|------------|---|
| Base       | Epoxy, two component                                |
| Properties | Tough, good resistance to water, salt and yellowing |
| Open time  | 30 minutes  |
| Colour     | Grey  |



Sealing of the granulate with Körapox BS 85

**KÖRAPOX BS 85**  
*Good resistance to yellowing*



Covering the hydraulic platform with Körapox BS 90

**KÖRAPOX BS 90**  
*Good adhesion to metal*

|             |                                 |                                 |
|-------------|---------------------------------|---------------------------------|
| Density     | 1,14 g/cm <sup>3</sup> (mixing) | 1,55 g/cm <sup>3</sup> (mixing) |
| Viscosity   | low viscosity                   | 35.000 mPas (mixing)            |
| Mix ratio   | 4 : 1 by weight                 | 7 : 1 by weight                 |
| Consumption | 250 g/m <sup>2</sup>            | 800-1.000 g/m <sup>2</sup>      |
| Pot life    | 90 minutes at +20°C             | 8 hours at +20°C                |

|                 |  |  |
|-----------------|--|--|
| Packaging units | 5 kg mixing unit<br>in stacked container | 8 kg mixing unit<br>in stacked container |
|-----------------|--|--|

# PRODUCT INFORMATION

## KÖRAPOX BS 85 - KÖRAPOX BS 90

|                        |   |
|------------------------|---|
| Processing temperature | +15°C to +25°C  |
| Coating                | Please follow the processing instructions.  |
| Storage                | Do not store below +5°C or above +25°C.<br>Stored in unopened containers, usable for up to 12 months.   |
| Cleaning               | Clean tools immediately after use with Körasolv PU.<br>Cured material can only be removed mechanically. |

|                        | KÖRAPOX BS 85   | KÖRAPOX BS 90  |
|------------------------|---|--|
| Processing temperature | +15°C to +25°C  | +15°C to +25°C   |
| Preparation            | <p>The surfaces must be dry (not more than 15 % moisture content), clean and free from grease. Concrete slush, oil and colour residues must be removed thoroughly. If necessary a flame or sand jet can be used. The substrate and the pre-treatment have to be adapted to the following practical operation.</p> <p>Mix A and B component intensively in the weight ratio 4:1 using a stirrer (approx. 400 rpm). Transfer the mixed compound into a second cleaned vessel and stir again.</p> <p>1. application: dilute Körapox BS 85 with up to 20 % Körasolv PR</p> <p>2. application: use Körapox BS 85 without solvent or add up to 10 % Körasolv PR</p> | <p>The surfaces must be dry, clean and free from dust and grease. The substrates must be properly prepared to ensure good adhesion. This includes mechanical and/or chemical pretreatment.</p> <p>When repairing older floors particular care must be given to the pre-treatment. Good results can be achieved with sand blasting. GRP- and aluminium surfaces must be well abraded. Not suitable for sealing flexible substrates such as wood. When repairing older floors particular care must be given to the pre-treatment. Good results can be achieved with sand blasting.</p> |

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# KÖRASOLV PR - PU - WL - CR

## CLEANERS AND DILUANTS

|                 | KÖRASOLV PR  | KÖRASOLV PU                                    | KÖRASOLV WL                                | KÖRASOLV CR  |
|-----------------|--|--|--|--|
| Application     | Very strong cleaner for old floors. Also recommended for PVC coated steels | General purpose cleaner for tools and surfaces | Mild cleaner for greasy and waxy surfaces. | Cleaner and diluant for Körapur, Körapox and Köratac adhesives |
| Base            | Mixture of organic solvents, toluene free                                  | Mixture of organic solvents, toluene free      | Mixture of organic solvents                | Mixture of organic solvents, toluene free                      |
| Density         | 0,90 g/cm <sup>3</sup>   | 0,81 g/cm <sup>3</sup>                         | 0,80 g/cm <sup>3</sup>                     | 0,77 g/cm <sup>3</sup>   |
| Packaging units | 12,5 litres  | 1 litre<br>5 litres<br>12 litres               | 1 litre<br>12 litres                       | 1 litre<br>5 litres<br>12 litres                               |

# KÖRABOND HG 74 E - HG 77

## PRIMERS AND ADHESION PROMOTERS

Primer for the pre-treatment of the substrates prior to the bonding with 1-part PUR or 1-part-POP adhesives and sealants. The use of primers improves the adhesion as well as the moisture resistance of the bond. Users are advised to confirm the suitability of the products with their own tests.

|                 |  |   |
|-----------------|--|---|
| Base            | Synthetic resin, containing solvent  |   |
| Viscosity       | Low viscosity  |   |
|                 | <b>KÖRABOND HG 74 E</b><br><i>Primer curing with moisture</i>  | <b>KÖRABOND HG 77</b><br><i>One component primer</i>  |
| Colour          | Light yellow, transparent or red   | Transparent or blue   |
| Density         | 1,0 g/cm <sup>3</sup>  | 0,92 g/cm <sup>3</sup>  |
| Consumption     | 100 g/m <sup>2</sup>   | 40-80 g/m <sup>2</sup>  |
| Drying time     | 20 minutes   | 30 minutes  |
| Application     | For the pre-treatment of porous substrates such as wood or concrete prior to the application with 1-part PUR or 1-part POP adhesives and sealants. | Primer for the pre-treatment of rigid PVC and ABS prior to the bonding.<br>Adhesion promotor for cured Körapop prior to overpainting. |
| Packaging units | 1 litre  | 1 litre   |

# PRODUCT INFORMATION

## KÖRABOND HG 74 E - HG 77

|                        |  |
|------------------------|--|
| Processing temperature | +10°C to +25°C   |
| Preparation            | The surfaces to be bonded must be dry, clean and free from dust and grease.                              |
| Storage                | Store dry in tightly closed containers, at temperatures not below +10°C and not for more than 12 months. |

|             | KÖRABOND HG 74 E  | KÖRABOND HG 77   |
|-------------|---|--|
| Preparation | <p>Apply Körabond HG 74 E using a brush or a roller and allow to dry for at least 20 minutes.</p> <p>The adhesive or sealant must be applied within 8 hours after the primer application to ensure maximum adhesion. Otherwise fresh primer must be applied.</p> <p>It is absolutely necessary to carry out suitability and compatibility tests for unknown or new materials.</p> | <p>Apply Körabond HG 74 E using a brush or a roller and allow to dry for at least 30 minutes.</p> <p>The adhesive or sealant must be applied within 24 hours after the primer application to ensure maximum adhesion. Otherwise fresh primer must be applied.</p> <p>It is absolutely necessary to carry out suitability and compatibility tests for unknown or new materials.</p> |

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# KÖRABOND HG 81 - HG 83

## ADHESION PROMOTORS

Adhesion promoter for the pre-treatment of the substrates prior to the bonding with 1-part PUR or 1-part POP adhesives and sealants. The use of primers improves the adhesion as well as the moisture resistance of the bond. Users are advised to confirm the suitability of the products with their own tests.

|             |   |
|-------------|---|
| Base        | Synthetic resin, solvent containing   |
| Viscosity   | Low viscosity   |
| Consumption | 20-40 g/m <sup>2</sup>  |
| Drying time | > 2 minutes   |
| Application | For the pre-treatment of non porous substrates such as metals (aluminium, steel, VA-steel, brass, copper, zinc, tinplate), plastics (ABS, rigid PVC, PA, GFK, SMC, PUR), painted surfaces, enamel, ceramic as well as coated glass for the bonding with elastic adhesives and sealants. |

### KÖRABOND HG 81

*Adhesion promoter*

### KÖRABOND HG 83

*Adhesion promoter*

|         |                       |                        |
|---------|-----------------------|------------------------|
| Colour  | Browny, transparent   | Transparent            |
| Density | 0,8 g/cm <sup>3</sup> | 0,77 g/cm <sup>3</sup> |

|                 |                                  |                                    |
|-----------------|----------------------------------|------------------------------------|
| Packaging units | 1 litre<br>5 litres<br>12 litres | 0,5 litres<br>1 litre<br>25 litres |
|-----------------|----------------------------------|------------------------------------|

# PRODUCT INFORMATION

## KÖRABOND HG 81 - HG 83

|                        |   |
|------------------------|---|
| Processing temperature | +10°C to +35°C  |
| Preparation            | The surfaces to be bonded must be dry, clean and free from dust and grease.   |
| Storage                | Store dry in tightly closed containers, at temperatures not below +10°C and not for more than 12 months.  |
| Processing             | Apply Körabond to the surfaces to be bonded and allow to dry. Apply only in one direction using a non fibre cloth which should be changed frequently.<br>Drying time is approx. 10 minutes. The subsequent bonding should happen at last 24 hours after application of the primer. Otherwise fresh primer must be applied. Allow proper drying time and do not use Körabond on non absorbant and porous substrates to ensure maximum adhesion and to avoid curing disturbance.<br>It is absolutely necessary to carry out suitability and compatibility tests for unknown or new materials. |

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# KÖMMERLING - MORE THAN JUST A PRODUCT

## Our philosophy ...

... more research and development!

We have the solutions for tomorrow's requirements today.

... more products!

We have the widest product-range in the market.

... more logistics!

We help to save your time.

... more consulting and training!

We increase your benefit, your certainty and your income return.

... more service!

We are there when you need us.

... more communication!

We are active in building-up your market.

... more quality!

We offer you high performance products.

