



SYSTEM SOLUTIONS FOR MOBILE HOMES

Product Overview

Manufacturing of a modern motorhome or caravan consists of a large number of individual steps. In addition to the production of the sandwich panels, assembly bonding and interior finishing or glazing are of great importance and require a variety of high performance adhesives and sealants. The following list is giving an overview and thus allows a first selection of the respective application.

1. SANDWICH ELEMENTS (ROOF, WALL, FLOORING)

Product name	Technology	Product description	Viscosity 20 °C	Open time 20 °C	Pressing time 40 °C
Icema™ R 145/59 D	1-c liquid PU	Medium open time adhesives for a variety of substrates, easy to apply that provides a reliable bonding strength	3.800 mPas	12 min	20 min
Icema™ R 145/75	1-c liquid PU	Fast product high productivity lines with short open time and short pressing time required	5.100 mPas	3 min	4 min
Icema™ R 145/45	1-c liquid PU	Short open time, versatile product, good adhesion grade in most of materials, including pre-treated metals	4.000 mPas	5 min	8 min
Icema™ R 145/12	1-c liquid PU	Medium open time, versatile product, good adhesion grade in most of materials, including pre-treated metals	3.500 mPas	7 min	10 min
Icema™ 1456	1-c liquid PU	Low foaming curing adhesive for close surface substrates	4.000 mPas	5 min	8 min

Product name	Technology	Product description	Viscosity 120 °C	Open time 20 °C
Rakoll® PUS 3500	Reactive HM	Good green strength for bond security even on material with a certain spring back effect	25.000 mPas	4 min
Rakoll® PUS 3700	Reactive HM	Provides good adhesion to plastic substrates, metals and fiber pressure laminates	17.000 mPas	2 min

Product name	Technology	Product description	Viscosity 20 °C	Mixed viscosity	Pot life 20 °C	Mix ratio by weight
Körapur 672	2-c PU	High humidity resistance	30.000 mPas	10.000 mPas	Various between 20 and 80 min	5:1
Körapur 666	2-c PU	Thixotropic, easy to spread with spatula, high humidity resistance, mixing cartridge available	Paste	55.000 mPas	Various between 3 and 90 min	6:1

2. ASSEMBLY BONDING AND INTERIOR FINISHING

Product name	Technology	Product description	Skin formation time	Curing after 24 h	Shore A	Elongation at break	Tensile strength
Körapur 125	1-c PU	Universal sealant / adhesive	45 min	3 mm	48	500%	2,0 N/mm ²
Körapur 030	1-c PU	Label free according to GHS	45 min	3 mm	45	800%	2,9 N/mm ²
Körapur 140	1-c PU	High strength elastic adhesive	45 min	3 mm	55	400%	4,0 N/mm ²
Körapop 225	1-c STP	Universal sealant / adhesive MS	25 min	3 mm	42	500%	3,0 N/mm ²
Körapop 240	1-c STP	High strength elastic adhesive, temporary high temperature resistance	10 min	3 mm	55	400%	3,2 N/mm ²

2. ASSEMBLY BONDING AND INTERIOR FINISHING

Product name	Technology	Product description	Viscosity 20 °C	Mixed viscosity 20 °C	Pot life 20 °C	Mix ratio by weight	Shore D
Körapur 840	2-c PU	Good impact resistance, good adhesion to powder coating, mixing and tandem cartridge available	Structural viscosity	45.000 mPas	Various between 2 and 45 min	5:1	65
Körapur 790	2-c PU	Repair solution, uTAH cartridge, 1:1 ratio	Paste	Paste	30 min	0,8:1	76
Icema™ R 101	2-c PU	Hard adhesive, non sagging with high viscosity and filling properties, recommended for assembly of vertical surfaces	Structural viscosity	250.000 mPas	120 min	100:15	70

Product name	Technology	Product description	Mixed viscosity 20 °C	Open time 20 °C	Pressing time 50 °C
Icema™ 145/88	LMC	Thixotropic non sagging adhesive with low foaming curing characteristics for assembly operation that need short open time and short press time	140.000 mPas	2 min	6 min

Product name	Technology	Product description	Viscosity 20 °C	Skin formation time	Curing after 24 h	Shore A	Movement capability
Ködisil N	Silicone	Neutral curing silicone, fungicide, DIN 18545 T.2 group E, approved according EN 15651 part 1 and 2	Paste, non-sag properties	5 min	3 mm	25	25%

Product name	Technology	Product description	Viscosity 20 °C	Open time 20 °C	Density	Solid content	pH-Value
Rakoll® DK 100200	Water based	Flows very well, provides an economical spread with good adhesion properties	10.500 mPas	3-5 min	1,38 g/cm ³	71%	8
Köracoll WB 20	Water based	Rapid setting, long tack, Emicode EC1, Giscode D1	14.000 mPas	10-20 min	1,00 g/cm ³	78%	7,5
Köracoll 2027	Water based	Good resistance to humidity and plasticizer, sprayable, high final strength	2.500 mPas	5 min	1,03 g/cm ³	61%	6
Rakoll® GXL3	Water based	Easy to apply and suitable for many processing conditions, provides a very strong bonding. D3 certified	13.000 mPas	8-12 min	1,00 g/cm ³	50%	3

Product name	Technology	Product description	Density	Extrusion rate	Skin formation time
Ködiplast CT 100	Butyl	Solvent containing butyl sealant, removable	1,44 g/cm ³	30 g/min	3 min

Product name	Technology	Product description	Density	Elongation	Force to compress
Köratape BC 1081	Butyl	Butyl coated foam, highly compressible	0,11 g/cm ³	80%	3,2 N/mm ²

Product name	Technology	Product description	Viscosity 20 °C	Open time 20 °C	Heat resistance	Solid content
Körapren FU 35	Solvent based	Universal neoprene contact adhesive, high temperature resistance	400 mPas	30	110 °C	20
Köraplast SF	Solvent based	Universal PUR contact adhesive	2.700 mPas	20	55 °C	19

3. GLAZING

Product name	Technology	Product description	Skin formation time	Curing after 24 h	Shore A	Elongation at break	Tensile strength
Körapur 177	1-c PU	High strength glazing product, drive away time 4-6 hours	35 min	3 mm	55	600%	7,5 N/mm ²



KÖMMERLING CHEMISCHE FABRIK GMBH | Zweibrücker Str. 200 | DE - 66954 Pirmasens
Contact: Ralf Fuhrmann | Phone +49 6331 561019 | eMail ralf.fuhrmann@koe-chemie.de

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