

ADHESIVES AND SEALANTS TRANSPORTATION



Chapter I PUR adhesives and sealants

1. Körapur 115 - Körapur 125
2. Körapur 128 - Körapur 128 / 2-part
3. Körapur 140 - Körapur 140 / 2-part


 Chapter II Silane terminated adhesives and sealants

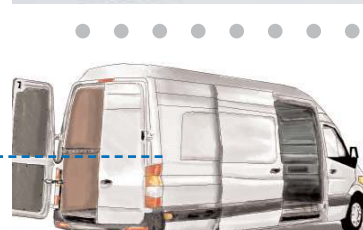
4. Körapop 225 - Körapop 225 / 2-part
5. Körapop 235 - Körapop 240
6. Körapop 316 - Körapop 330


 Chapter III 2-part PUR adhesives

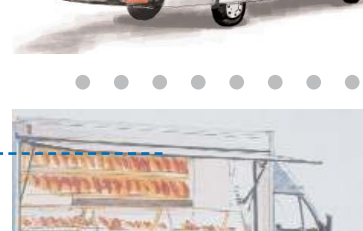
7. Körapur 666 - Körapur 672
8. Körapur 840 - Körapur 842
9. Körapur 572 - Körapur 648


 Chapter IV Dispersion adhesives

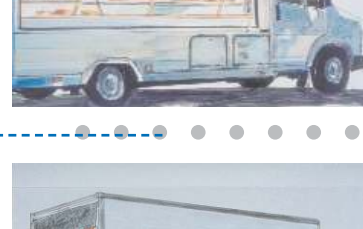
10. Köracoll WB 12
11. Köracoll 3350


 Chapter V Solvent and polymer adhesives

12. Körapren FU 35 - Körapren FU 36
13. Köratac C 12 - Köratac DF 841


 Chapter VI Butyl and silicone sealants

14. Ködiplast CT 100 - Ködiplast CS
15. Ködisil N - Köditec 114


 Chapter VII Acrylic tapes

16. Köratape AT 2
17. Köratape AT 3


 Chapter VIII Floor coatings

18. Körapur 689 - Körapur 690
19. Körapox BS 85 - Körapox BS 90


 Chapter IX Cleaners and Primers

20. Körasolv PR, PU, WL, CR
21. Körabond HG 74 E, HG 77, HG 81, HG 83

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 ³
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 ²
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

Please note: Every endeavour has been made to ensure that the information contained herein is true and reliable but it is given only for the guidance of our customers.

Any values quoted are approximate and do not form part of the manufacturing specification.

The company cannot accept any responsibility for loss or damage or infringement of patent rights that may result from the use of the information, due to the possibility of variations of processing or working conditions and workmanship outside of our control.

Users are advised to confirm the suitability of the products with their own tests.

Please refer also to our Terms and Conditions of Sale, a copy of which is available upon request.

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 ³
Curing	3 mm (after 24 hours)
Elongation at break	450 %
Tensile strength	2 N/mm ²
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. 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 600 ml sausage 23 kg hobbock 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

Please note: Every endeavour has been made to ensure that the information contained herein is true and reliable but it is given only for the guidance of our customers.

Any values quoted are approximate and do not form part of the manufacturing specification.

The company cannot accept any responsibility for loss or damage or infringement of patent rights that may result from the use of the information, due to the possibility of variations of processing or working conditions and workmanship outside of our control.

Users are advised to confirm the suitability of the products with their own tests.

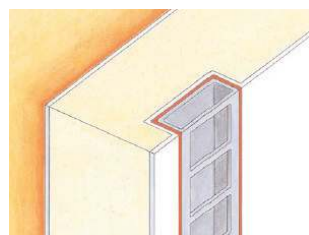
Please refer also to our Terms and Conditions of Sale, a copy of which is available upon request.

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 ³
Viscosity	Paste, low slump
Skin formation time	45 minutes
Elongation at break	400 %
Tensile strength	4 N/mm ²
Shear strength	3 N/mm ² (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. 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 600 ml sausage 23 kg hobbock 230 kg drum	23 kg hobbock 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

Please note: Every endeavour has been made to ensure that the information contained herein is true and reliable but it is given only for the guidance of our customers.

Any values quoted are approximate and do not form part of the manufacturing specification.

The company cannot accept any responsibility for loss or damage or infringement of patent rights that may result from the use of the information, due to the possibility of variations of processing or working conditions and workmanship outside of our control.

Users are advised to confirm the suitability of the products with their own tests.

Please refer also to our Terms and Conditions of Sale, a copy of which is available upon request.

KÖRAPOP 225 - KÖRAPOP 225 / 2-part

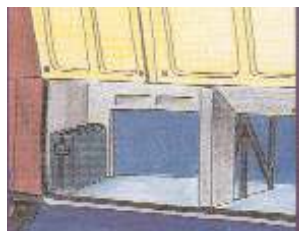
ELASTIC STP ADHESIVES AND SEALANTS

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 ³
Viscosity	Paste, low slump
Skin formation time	25 minutes
Elongation at break	500 %
Tensile strength	3,0 N/mm ²
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. 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 600 ml sausage 25 kg hobbock 270 kg drum	220 ml cartridge 25 kg hobbock 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. 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.

For safety information refer to the Material Safety Data Sheet

Please note: Every endeavour has been made to ensure that the information contained herein is true and reliable but it is given only for the guidance of our customers.

Any values quoted are approximate and do not form part of the manufacturing specification.

The company cannot accept any responsibility for loss or damage or infringement of patent rights that may result from the use of the information, due to the possibility of variations of processing or working conditions and workmanship outside of our control.

Users are advised to confirm the suitability of the products with their own tests.

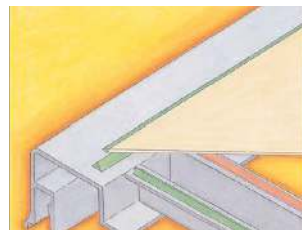
Please refer also to our Terms and Conditions of Sale, a copy of which is available upon request.

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 ²
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. 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



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

KÖRAPOP 235

ST polymer, spreadable, excellent mechanical properties

KÖRAPOP 240

Good cataplasma properties

Density	1,44 g/cm ³	1,41 g/cm ³
Elongation at break	550 %	430 %
Shear strength	2,2 N/mm ²	2,7 N/mm ²
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

Please note: Every endeavour has been made to ensure that the information contained herein is true and reliable but it is given only for the guidance of our customers.

Any values quoted are approximate and do not form part of the manufacturing specification.

The company cannot accept any responsibility for loss or damage or infringement of patent rights that may result from the use of the information, due to the possibility of variations of processing or working conditions and workmanship outside of our control.

Users are advised to confirm the suitability of the products with their own tests.

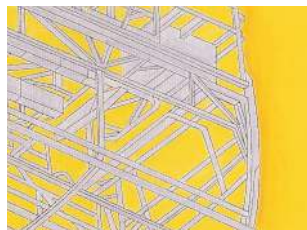
Please refer also to our Terms and Conditions of Sale, a copy of which is available upon request.

KÖRAPOP 316 - KÖRAPOP 330

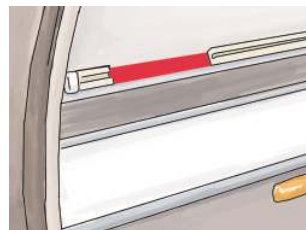
ELASTIC STP ADHESIVES AND SEALANTS

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 ²
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. Isocyanate and silicone free. 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 ³	1,60 g/cm ³
Elongation at break	550 %	200 %
Shear strength	2,2 N/mm ²	1,3 N/mm ²
Tear propagation strength	24 N/mm	10 N/mm
Hardness Shore A	50	58

Packaging units	310 ml PE-cartridge 600 ml sausage	310 ml PE-cartridge 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

Please note: Every endeavour has been made to ensure that the information contained herein is true and reliable but it is given only for the guidance of our customers.

Any values quoted are approximate and do not form part of the manufacturing specification.

The company cannot accept any responsibility for loss or damage or infringement of patent rights that may result from the use of the information, due to the possibility of variations of processing or working conditions and workmanship outside of our control.

Users are advised to confirm the suitability of the products with their own tests.

Please refer also to our Terms and Conditions of Sale, a copy of which is available upon request.

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.

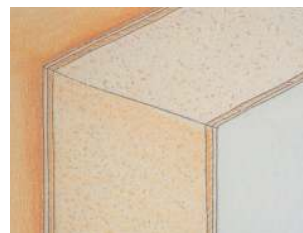
Base	Polyurethane, two component, solvent free
Colour	Beige
Properties	Good resistance to humidity, weathering, good adhesion to aluminium, wood, PVC (rigid), GRP



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 ³ (resin) 1,23 g/cm ³ (hardener) 1,63 g/cm ³ (mixing)	1,67 g/cm ³ (resin) 1,23 g/cm ³ (hardener) 1,60 g/cm ³ (mixing)
Viscosity	50.000 mPas (mixing)	ca. 8.000 mPas (mixing)
Mix ratio	Resin : hardener 6 : 1 (by weight)	Resin : hardener 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> 17 N/mm ² at -20 °C 14 N/mm ² at +20 °C 3,5 N/mm ² at +80 °C	-

Packaging units	0,350 kg mixing cartridge 1 kg mixing unit 6 kg pail 30 kg hobbock 300 kg drum	5 kg pail 30 kg hobbock 300 kg drum 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

Please note: Every endeavour has been made to ensure that the information contained herein is true and reliable but it is given only for the guidance of our customers.

Any values quoted are approximate and do not form part of the manufacturing specification.

The company cannot accept any responsibility for loss or damage or infringement of patent rights that may result from the use of the information, due to the possibility of variations of processing or working conditions and workmanship outside of our control.

Users are advised to confirm the suitability of the products with their own tests.

Please refer also to our Terms and Conditions of Sale, a copy of which is available upon request.

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.

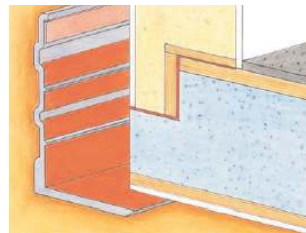
Base	Polyurethane, two component, solvent free
Colour	Beige
Properties	Good resistance to humidity and weathering
Mix ratio	Resin : hardener = 5 : 1 (by weight)



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

Packaging units	0,540 kg tandem cartridge 0,360 kg mixing cartridge 5 kg pail 30 kg hobbock 300 kg drum	0,360 kg missing cartridge 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

Please note: Every endeavour has been made to ensure that the information contained herein is true and reliable but it is given only for the guidance of our customers.

Any values quoted are approximate and do not form part of the manufacturing specification.

The company cannot accept any responsibility for loss or damage or infringement of patent rights that may result from the use of the information, due to the possibility of variations of processing or working conditions and workmanship outside of our control.

Users are advised to confirm the suitability of the products with their own tests.

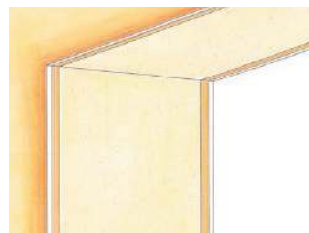
Please refer also to our Terms and Conditions of Sale, a copy of which is available upon request.

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 ³ (resin) 1,23 g/cm ³ (hardener) 1,60 g/cm ³ (mixing)	1,49 g/cm ³ (resin) 1,23 g/cm ³ (hardener) 1,42 g/cm ³ (mixing)
Viscosity	ca. 8.000 mPas (mixing)	ca. 1.400 mPas (mixing)
Mx ratio	Resin : hardener 5 : 1 (by weight)	Resin : hardener 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 270 kg drum 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. 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 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

Please note: Every endeavour has been made to ensure that the information contained herein is true and reliable but it is given only for the guidance of our customers.

Any values quoted are approximate and do not form part of the manufacturing specification.

The company cannot accept any responsibility for loss or damage or infringement of patent rights that may result from the use of the information, due to the possibility of variations of processing or working conditions and workmanship outside of our control.

Users are advised to confirm the suitability of the products with their own tests.

Please refer also to our Terms and Conditions of Sale, a copy of which is available upon request.

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 ³ (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 ² (depending on the substrate)	60-120 g/m ² (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

Please note: Every endeavour has been made to ensure that the information contained herein is true and reliable but it is given only for the guidance of our customers.

Any values quoted are approximate and do not form part of the manufacturing specification.

The company cannot accept any responsibility for loss or damage or infringement of patent rights that may result from the use of the information, due to the possibility of variations of processing or working conditions and workmanship outside of our control.

Users are advised to confirm the suitability of the products with their own tests.

Please refer also to our Terms and Conditions of Sale, a copy of which is available upon request.

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 ³
Consumption	250-300 g/cm ³ (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 170 kg drum	750 g tin 5 kg pail 12,5 kg hobbock 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	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.	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.

For safety information refer to the Material Safety Data Sheet

Please note: Every endeavour has been made to ensure that the information contained herein is true and reliable but it is given only for the guidance of our customers.

Any values quoted are approximate and do not form part of the manufacturing specification.

The company cannot accept any responsibility for loss or damage or infringement of patent rights that may result from the use of the information, due to the possibility of variations of processing or working conditions and workmanship outside of our control.

Users are advised to confirm the suitability of the products with their own tests.

Please refer also to our Terms and Conditions of Sale, a copy of which is available upon request.

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 ³	0,9 g/cm ³
Consumption	100-250 g/m ²	60-100 g/m ²
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. Stored in the unopened container, usable for up to 12 months.
Cleaning	Körasolv PU

	KÖRATAC C 12	KÖRATAC DF 841
Preparation	The surfaces to be bonded must be dry, clean and free from dust and grease. As the curing process is started with air humidity, the humidity in the workrooms should amount to 40-70 % r.h.	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. Clean contaminated foils with Körasolv GL.
Bonding	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. Complete curing will be achieved after 24 hours.	Apply Köratat 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 Köratat DF 841 on both sides and press together after a drying time of 2-5 minutes. Köratat 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.

For safety information refer to the Material Safety Data Sheet

Please note: Every endeavour has been made to ensure that the information contained herein is true and reliable but it is given only for the guidance of our customers.

Any values quoted are approximate and do not form part of the manufacturing specification.

The company cannot accept any responsibility for loss or damage or infringement of patent rights that may result from the use of the information, due to the possibility of variations of processing or working conditions and workmanship outside of our control.

Users are advised to confirm the suitability of the products with their own tests.

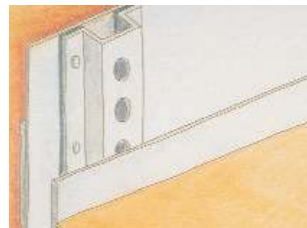
Please refer also to our Terms and Conditions of Sale, a copy of which is available upon request.

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.

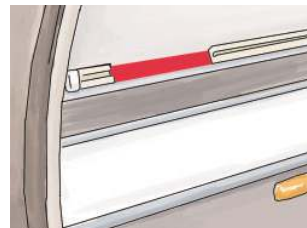
Base	Butyl rubber, one component
Colour	Grey
Viscosity	Paste, spreadable
Shrinkage	20 %
Weight loss	15 %
Properties	Resistant to temperatures from -30°C to +80°C. Good resistance to weathering. Do not use in contact with oils, solvents and fuels.



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 ³	1,42 g/cm ³
---------	------------------------	------------------------

Packaging units	310 ml aluminium cartridge 600 ml sausage 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. Stored in unopened containers, usable for up to 12 months.
Cleaning	Clean tools and remove fresh spots with Körasolv PU.

For safety information refer to the Material Safety Data Sheet

Please note: Every endeavour has been made to ensure that the information contained herein is true and reliable but it is given only for the guidance of our customers.

Any values quoted are approximate and do not form part of the manufacturing specification.

The company cannot accept any responsibility for loss or damage or infringement of patent rights that may result from the use of the information, due to the possibility of variations of processing or working conditions and workmanship outside of our control.

Users are advised to confirm the suitability of the products with their own tests.

Please refer also to our Terms and Conditions of Sale, a copy of which is available upon request.

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 ³	1,27 g/cm ³ (white), 1,02 g/cm ³ (transparent)
Hardness Shore A	17	23 (white) 19 (transparent)
Skin formation time	10 minutes	5 minutes
Max. movement capacity	-	25 %

Packaging units	310 ml PE cartridge 600 ml sausage	310 ml PE cartridge 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. Stored in unopened containers, usable for up to 9 months.
Cleaning	Use Körasolv GL to clean tools and to remove fresh adhesive spots.

For safety information refer to the Material Safety Data Sheet

Please note: Every endeavour has been made to ensure that the information contained herein is true and reliable but it is given only for the guidance of our customers.

Any values quoted are approximate and do not form part of the manufacturing specification.

The company cannot accept any responsibility for loss or damage or infringement of patent rights that may result from the use of the information, due to the possibility of variations of processing or working conditions and workmanship outside of our control.

Users are advised to confirm the suitability of the products with their own tests.

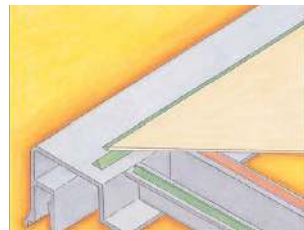
Please refer also to our Terms and Conditions of Sale, a copy of which is available upon request.

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. To remove all contaminants without leaving any residue use a clean, lint-free wiping cloth or disposable wipe. Dispose both wipes afterwards. 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 ²). Adhesive strength depends on the contact between adhesive and the surfaces to be bonded. 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

Please note: Every endeavour has been made to ensure that the information contained herein is true and reliable but it is given only for the guidance of our customers.

Any values quoted are approximate and do not form part of the manufacturing specification.

The company cannot accept any responsibility for loss or damage or infringement of patent rights that may result from the use of the information, due to the possibility of variations of processing or working conditions and workmanship outside of our control.

Users are advised to confirm the suitability of the products with their own tests.

Please refer also to our Terms and Conditions of Sale, a copy of which is available upon request.

KÖRAPUR 689 - KÖRAPUR 690

COATING SYSTEMS

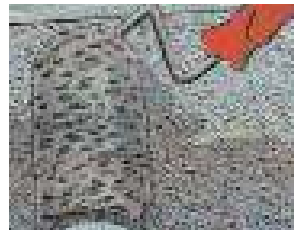
For floor coating in lorries, containers, sales vehicles, mobile shops, caravans, mobile homes, etc. on polyester, aluminium, primed steel sheets and timber.

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 ³ (mixing)	1,14 g/cm ³ (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 ²	600-800 g/m ²
Pot life	35 minutes at +20°C	120 minutes at +20°C
Tensile strength	18 N/mm ²	-
Elongation at break	15 %	-
Hardness Shore D	70	-

Packaging units	15 kg mixing unit in stacked container	6 kg mixing unit 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. 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.

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>
-------------	--	--

For safety information refer to the Material Safety Data Sheet

Please note: Every endeavour has been made to ensure that the information contained herein is true and reliable but it is given only for the guidance of our customers.

Any values quoted are approximate and do not form part of the manufacturing specification.

The company cannot accept any responsibility for loss or damage or infringement of patent rights that may result from the use of the information, due to the possibility of variations of processing or working conditions and workmanship outside of our control.

Users are advised to confirm the suitability of the products with their own tests.

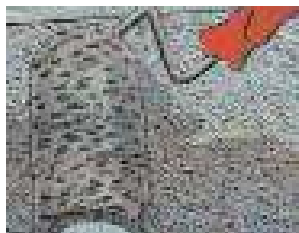
Please refer also to our Terms and Conditions of Sale, a copy of which is available upon request.

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

Packaging units	5 kg mixing unit in stacked container	8 kg mixing unit 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. 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.

	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>

For safety information refer to the Material Safety Data Sheet

Please note: Every endeavour has been made to ensure that the information contained herein is true and reliable but it is given only for the guidance of our customers.

Any values quoted are approximate and do not form part of the manufacturing specification.

The company cannot accept any responsibility for loss or damage or infringement of patent rights that may result from the use of the information, due to the possibility of variations of processing or working conditions and workmanship outside of our control.

Users are advised to confirm the suitability of the products with their own tests.

Please refer also to our Terms and Conditions of Sale, a copy of which is available upon request.

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 ³	0,81 g/cm ³	0,80 g/cm ³	0,77 g/cm ³
Packaging units	12,5 litres	1 litre 5 litres 12 litres	1 litre 12 litres	1 litre 5 litres 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	
	KÖRABOND HG 74 E <i>Primer curing with moisture</i>	KÖRABOND HG 77 <i>One component primer</i>
Colour	Light yellow, transparent or red	Transparent or blue
Density	1,0 g/cm ³	0,92 g/cm ³
Consumption	100 g/m ²	40-80 g/m ²
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. 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>

For safety information refer to the Material Safety Data Sheet

Please note: Every endeavour has been made to ensure that the information contained herein is true and reliable but it is given only for the guidance of our customers.

Any values quoted are approximate and do not form part of the manufacturing specification.

The company cannot accept any responsibility for loss or damage or infringement of patent rights that may result from the use of the information, due to the possibility of variations of processing or working conditions and workmanship outside of our control.

Users are advised to confirm the suitability of the products with their own tests.

Please refer also to our Terms and Conditions of Sale, a copy of which is available upon request.

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 ²
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 ³	0,77 g/cm ³

Packaging units	1 litre 5 litres 12 litres	0,5 litres 1 litre 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. 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. It is absolutely necessary to carry out suitability and compatibility tests for unknown or new materials.

For safety information refer to the Material Safety Data Sheet

Please note: Every endeavour has been made to ensure that the information contained herein is true and reliable but it is given only for the guidance of our customers.

Any values quoted are approximate and do not form part of the manufacturing specification.

The company cannot accept any responsibility for loss or damage or infringement of patent rights that may result from the use of the information, due to the possibility of variations of processing or working conditions and workmanship outside of our control.

Users are advised to confirm the suitability of the products with their own tests.

Please refer also to our Terms and Conditions of Sale, a copy of which is available upon request.

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.

