

PRODUCT INFORMATION

Körapur 666



KÖMMERLING CHEMISCHE FABRIK GMBH

Two component reactive adhesive for bonding of metals. Good adhesion to aluminium, wood, PVC-rigid and GRP

- for bonding profiles and corner angels in aluminium window construction
- Suitable for assembling of side walls, floors and roofs in the commercial vehicle construction
- For the manufacture of sandwich elements such as PS-, PUR-, PVC-rigid foam
- For various bondings within the vehicles, containers, boat- and shipbuilding industry
- Good resistance to humidity and weathering
- Tough
- Meets the requirements of the International Maritime Organization



TECHNICAL DATA

Base	Polyurethane, two-component, solvent-free		
Colour	Beige		
Density			
- resin	1.7	g/cm ³	DIN 53 479
- hardener	1.2	g/cm ³	
- mix	1.6	g/cm ³	
Viscosity			
- resin	Paste		Brookfield RVT Brookfield RVT
- hardener	200	mPa•s	
- mix	50.000	mPa•s	
Hardener / accelerator	Köracur TH 650		
Mixing ratio	6 : 1	units by weight	(at +23°C)
resin : hardener	4.5 : 1	units by volume	
Pot life	90/60/45/30/25/20/18/8/5/3 min curing can be improved by adding dropwise accelerator Köracur PU		
Shore D Hardness	55		DIN 53505
Shear strength	17 Mpa 4 MPa EN 1465 / 23°C		DIN EN 1465 / 23°C DIN EN 1465 / 80°C

KÖRAPUR 666

PROCESSING

Processing temperature

Do not use the product below +15°C to +25°C

Preparation

The surfaces must be clean, dry and free from grease, oil and dust. We recommend that metal surfaces should be pretreated and sanded. Adhesion must be tested for compatibility by carrying out preliminary trials.

Thoroughly mix the components A + B intensively together using a mixer (agitation 400 revs/min.) until an even colour is obtained.

Bonding

Apply an even layer of adhesive to the surfaces to be bonded using a spatula and join them together. Care should be taken that application is deposited on both substrates. Avoid entrapping air when making the bond.

Before any load can effect the bond observe the loading capacity:

Loading capacity	
Körapur 666/90	after 12 - 16 hours
Körapur 666/60	after 10 - 12 hours
Körapur 666/45	after 6 - 8 hours
Körapur 666/30	after 4 - 6 hours
Körapur 666/25	after 4 - 6 hours
Körapur 666/20	after 3 - 4 hours
Körapur 666/18	after 2 - 3 hours
Körapur 666/08	after 1 hour
Körapur 666/05	after 0,5 - 1 hours
Körapur 666/03	after 20 - 40 minutes

Maximal bond strength is achieved after 10-36 hours depending on pot life. High temperature shorten the pot life, low temperature extends the pot life.

CLEANING

Körasolv PU.

Clean tools immediately after use. Once cured adhesive can only be removed mechanically.

SPECIAL NOTES

Tools

Spatula, appropriate 2-component mixing equipment

Storage

Do not store at temperatures below +10°C. When stored in tightly closed containers useable up to 12 months.

Precautions

When processing the product avoid direct skin contact with the uncured material. Use of safety gloves is recommended. Follow the Regulations issued by the relevant Professional Associations.

IMO requirements

Meets the requirements of the International Maritime Organization up to a coating weight of 350 g/m².

PACKAGING UNITS

	0.350 kg mixing cartridge *)	1 kg mixing unit	3 kg container	6 kg container	30 kg container	90 kg container	300 kg drum
Körapur 666/90	x	x	x	x	x		x
Körapur 666/60				x	x		x
Körapur 666/45							x
Körapur 666/30	x						x
Körapur 666/25							x
Körapur 666/20				x			x
Körapur 666/18							x
Körapur 666/08						x	x
Körapur 666/05					x		x
Körapur 666/03							x

*) 12 cartridges per carton

Mixing accessories separately in sets of 12

For safety related data please refer to the safety data sheet!

Please note: All given data are based on careful examination in our laboratories and our past practical experience. These are non-binding indications. Given the high number of materials appearing on the market and the different methods of use which are beyond our influence and control, we naturally cannot accept any responsibility for the results of your work, also with regard to third party patent rights. We recommend that sufficiently thorough tests be carried out to ascertain whether the product described will meet the requirements of your particular case. Please also note our Terms of Sale, Delivery and Payment. This product information replaces all previous issues.



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