

PRODUCT INFORMATION

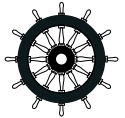
Körapur 672



KÖMMERLING CHEMISCHE FABRIK GMBH

Two component reaction adhesive for bonding rigid PVC, glass fibre-reinforced plastics, steel- and aluminium-sheets to PUR-, PVC- and PS-rigid foam

- Especially suitable for the manufacture of sandwich elements for the building industry and the manufacture of vehicles and containers
- Usable as levelling compound*
- Resistant to humidity and weathering
- Very good adhesive properties
- Meets the requirements of the International Maritime Organization



*Please note technical information "Levelling compound"!

TECHNICAL DATA

Base	Polyurethane, 2-components, solvent-free		
Hardener	Köracur TH 650		
Colour	Beige		
Consistency	Highly fluid, easily brushable		
Density			
- Körapur 672	1.66 (resin)		
- Köracur TH 650	1.23 (hardener)		
- mixture	1.41	g/cm ³	DIN 53 479
Viscosity			
- resin	30.000		
- hardener	200		
- mixture	8000	MPa*s	Brookfield RVT
Mixing ratio			
- resin : hardener	5 : 1	units by weight	
- resin : hardener	3.7 : 1	units by volume	
Pot life	60	min	
Hardness Shore D	60		DIN 53 505
	-20 °C: ca. 24	N/mm ²	DIN 53 283
	+20 °C: ca. 18,5	N/mm ²	
Shear strength	+80 °C: ca. 5,2	N/mm ²	
Tensile strength	18	N/mm ²	DIN 53 404
Consumption	250-300	g/m ²	depending on substrate

KÖRAPUR 672

PROCESSING

Processing temperature

+15°C to +25°C

Preparation

The surfaces to be bonded must be clean, dry and free of grease.

Metals must normally be pre-treated and possibly sanded. Adhesion must be tested for compatibility by carrying out preliminary trials. The use of a suitable primer improves the bond strength and ageing characteristics, as well as resistance to hydrolysis.

Surfaces of glass fibre-reinforced plastics must also be sanded.

Resin and hardener must be fixed thoroughly with a stirrer (approx. 400 revs/min) until the mixture shows a uniform beige colour.

CLEANING

Körasolv PU.

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

SPECIAL NOTES

Storage

Do not store below +10°C and for more than 12 months.

Precautions

When processing **Körapur 672** avoid direct skin contact with the uncured adhesive. Wear protective gloves. Hazardous fumes may form when the product is heated or sprayed. Follow the Bulletins issued by the Association of Mutual Industrial Accident Insurance Funds.

IMO requirements

Meets the requirements of the International Maritime Organization up to a coating weight of 155 g/m².

Bonding

Apply adhesive evenly with a spatula or a doctor blade to the surfaces to be bonded and join them.

The thickness of the adhesive layer depends on the properties of the materials to be bonded. The adhesive will cure without shrinkage.

When using **Körapur 672**, the bond can be exposed to light strain after 8–12 hours. Final bond strength is reached after 24 hours.

High temperatures will shorten the curing time, low temperatures will lengthen it.

SAFETY

Please read our Safety-Data-Sheet and the labels of each product before use.

Pay particular attention to the directions given in the Dangerous Substance Regulations.

Make sure the safety data sheet is readily available as it gives valuable information regarding the safe usage and disposal of the product and what to do in the event of an accident involving the product.

PACKAGING UNITS

5 kg drum of resin
10 kg drum of resin
30 kg drum of resin
300 kg drum of resin
1500 kg container of resin

Hardener on request, depending on metering equipment.

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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CERT

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