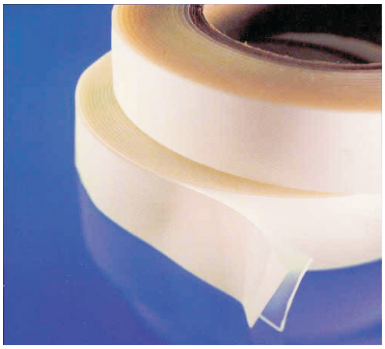
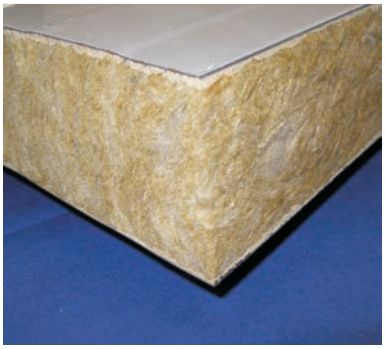
KÖMMERLING

ADHESIVES AND SEALANTS FOR INDUSTRIAL APPLICATIONS





KÖMMERLING
KÖMMERLING CHEMISCHE FABRIK GMBH

KÖMMERLING
KÖMMERLING CHEMISCHE FABRIK GMBH

KÖRAPUR 115 - KÖRAPUR 125

ELASTIC PUR ADHESIVES AND SEALANTS

For primed and varnished metals, aluminium, wooden materials and duroplastics. For containers, vehicles, vehicle bodywork, air conditioning and heating equipment, for bonding of panels and false floors.

Base	Polyurethane, one component, curing by reaction with moisture
Colour	White, grey, black
Density	1,2 g/cm³
Viscosity	Paste, non-sag properties, spreadable, applicable by gun
Curing	3 mm (on the first day)
Elongation at tear	450 %
Tensile strength	2 N/mm²
Skin formation time	45 minutes
Characteristics	Elastic, good resistance to moisture, weathering and temperatures from -40°C to +90°C (for short intervals up to +120°C), overpaintable after curing.

	KÖRAPUR 115	KÖRAPUR 125
Hardness Shore A	50	48
Change in volume	7 %	6 %
Tear propagation strength	6 N/mm	9 N/mm

KÖMMERLING
KÖMMERLING CHEMISCHE FABRIK GMBH

PRODUCT INFORMATION

KÖRAPUR 115 - KÖRAPUR 125

Processing temperature	+5°C to +35°C
Preparation	The surfaces to be bonded must be clean, dry and free of dust and grease. Adhesion and compatibility must be individually tested when used on plastics or paint. For cleaning we recommend Körasolv PU or CR. In the 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 we recommend the use of Körabond HG 77. Due to the diversity of substrates, preliminary tests are recommended.
Curing	Apply the product to the substrates using a sealant applicator gun or a spatula. The thickness of the layer depends on the expected mechanical movement. Join the materials to be bonded within 20 minutes after applying the adhesive. Due to the low initial tack we recommend mechanical fixing until a complete cure is obtained. The cure time is dependent on temperature, humidity and the dimensions of the joint.
Storage	Do not store below +5°C or above +25°C. When stored in unopened containers usable up to 9 months.
Cleaning	Clean tools immediately after use with Körasolv PU. Once cured material can only be removed mechanically.

For safety information refer to the Material Safety Data Sheet

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

KÖRAPUR 126

ELASTIC PUR ADHESIVE FOR BONDING OF HOLLOW FLOORS

For assembly of hollow floors on mineral or metal surfaces and on sealed substrates.

Base	Polyurethane, one component, curing by reaction with moisture
Colour	Grey
Density	1,2 g/cm³
Viscosity	Paste, non-sag properties, spreadable
Hardness Shore A	50
Curing	3 mm (on the first day)
Elongation at tear	500 %
Tensile strength	1,8 N/mm²
Tear propagation strength	8 N/mm
Skin formation time	45 minutes
Characteristics	Elastic, good resistance to moisture, weathering and temperatures from -40°C to +80°C (for short intervals up to +120°C), overpaintable after curing.

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

PRODUCT INFORMATION

KÖRAPUR 126

Processing temperature	+5°C to +35°C
Preparation	The surfaces to be bonded must be clean, dry and free of dust and grease. Adhesion and compatibility must be individually tested when used on plastics or paint. For cleaning we recommend Körasolv PU or CR. In the 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 we recommend the use of Körabond HG 77. Due to the diversity of substrates, preliminary tests are re commended.
Curing	Apply the product to the substrates using a sealant applicator gun or a spatula. The thickness of the layer depends on the expected mechanical movement. Join the materials to be bonded within 20 minutes after applying the adhesive. Due to the low initial tack we recommend mechanical fixing until a complete cure is obtained. The cure time is dependent on temperature, humidity and the dimensions of the joint.
Storage	Do not store below +5°C or above +25°C. When stored in unopened containers usable up to 9 months.
Cleaning	Clean tools immediately after use with Körasolv PU. Once cured material can only be removed mechanically.

For safety information refer to the Material Safety Data Sheet

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

KÖRAPUR 788

SOLVENT FREE PUR ADHESIVE

Fast reaction adhesive for spot bonding
Fast curing and adhesion to various metals, rigid plastics, fiber-reinforced composites (GRP, carbon fiber, fiberglass etc) and wood

Base	Polyurethane, two component
Colour	Black
Density	1,04 g/cm³ (A component) 1,19 g/cm³ (B component)
Viscosity	No slump
Solid content	100 %
Mix ratio	1 : 1 (by volume)
Hardener	Köracur TH 725
Pot life	40 s

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

PRODUCT INFORMATION

KÖRAPUR 788

Processing temperature	+10°C to +25°C
Preparation	The surfaces must be clean, dry and free of grease.
Bonding	Apply the adhesive on one side with the side-by-side cartridge. Due to the short pot life of approx. 40 seconds put the parts together as quickly as possible and fix them. Depending on temperature and film thickness light load is possible after approx. 10 minutes. The final strength is reached after approx. 1 hour. Higher temperatures accelerate the curing process, lower temperatures slow it down.
Storage	Do not store below +10°C and not for more than 6 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

KÖMMERLING
KÖMMERLING CHEMISCHE FABRIK GMBH

KÖRAPUR 175 - KÖRAPUR 177

FAST CURING PUR ADHESIVE

Fast curing and flexible adhesive for direct bonding of vehicle glass. Also suitable for use with integral aerials. Prevents contact corrosion.

Base	Polyurethane, one component, rapid curing by reaction with moisture
Colour	Black
Density	1,25 g/cm³
Viscosity	Paste, non-sag properties, spreadable
Curing	3 mm (on the first day)
Characteristics	Temperature resistant from -40°C to +100°C (up to +120°C for short intervals)

	KÖRAPUR 175	KÖRAPUR 177
Skin formation time	15 min	35 min
Electrical volume resistivity	10^9 Ω•cm	10^{10} Ω•cm
Hardness Shore A	60	55
Elongation at tear	> 400 %	> 600 %
Tensile strength	10 N/mm²	7.5 N/mm²
Drive away times	After 1-2 hours at a processing temperature between -5°C and +40°C (with or without driver and passenger airbag); tested according to FMVSS 212/208	After 4-6 hours at a processing temperature between +5°C and +35°C (with or without driver and passenger airbag); tested according to FMVSS 212/208
Characteristics	Suitable for cold and warm application; High modulus, maintains torsional rigidity and increases the vehicles NVH values; Capable of withstanding high dynamic stresses;	Suitable for cold application; Good stability; Good workability; Short cut-off string;

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

PRODUCT INFORMATION

KÖRAPUR 175 - KÖRAPUR 177

Processing temperature	+5°C to +35°C
Preparation	The adhesion on normal vehicle varnishes generally does not require the use of primer. It is advisable to carry out preliminary tests on the support. The surfaces to be bonded must be dry, clean and free from dust and grease. It is necessary to apply Körasolv CL 17 and Körabond HG 17 on glass.
Special notes	Avoid direct skin contact with isocyanate reactive substances, especially alcohol as spirit, dilutions and cleaning compounds until the adhesive has atteined full cure. When processing Körapur 175 or Körapur 177 avoid direct skin contact with the uncured material. The use of safety gloves is recommended.
Storage	Do not store below +5°C or above +25°C. When stored in unopened containers in a cool and dry place usable up to 12 months. Keep away from wet areas, direct sunlight and heat sources.
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

KÖMMERLING
KÖMMERLING CHEMISCHE FABRIK GMBH

KÖRAPUR 140 - KÖRAPUR 140 / 2-PART

ELASTIC PUR ADHESIVES AND SEALANTS

Moisture curing one and two component 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.

Base	Polyurethane, curing by reaction with moisture
Colour	White, grey, black
Density	1,2 g/cm³
Viscosity	Paste, non-sag properties
Elongation at tear	400 %
Tensile strength	4 N/mm²
Shear strength	3 N/mm² (at a layer thickness of 2mm)
Tear propagation strength	7 N/mm
Change in volume	7 %
Hardness Shore A	55
Characteristics	Elastic, good resistance to moisture, weathering and temperatures from -40°C to +90°C (for short intervalls up to +120°C), overpaintable after curing. For faster curing system, we recommend the use of Körapur 140 / 2-part plus hardener Köracur 110.

	KÖRAPUR 140	KÖRAPUR 140 / 2-PART
Pot life	-	20 min
Curing	3 mm (on the first day)	2-3 hours

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

PRODUCT INFORMATION

KÖRAPUR 140 - KÖRAPUR 140 / 2-PART

Processing temperature	+5°C to +35°C
Preparation	The surfaces to be bonded must be clean, dry and free of dust and grease. Adhesion and compatibility must be individually tested when used on plastics or paint. For cleaning we recommend Körasolv PU or CR. In the 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. For porous substrates such as wood, Körabond HG 74 E is recommended. For certain plastics such as ABS or PVC we recommend the use of Körabond HG 77 or HG 81. Due to the diversity of substrates, preliminary tests are re commended.
Bonding	Apply the product to the substrates using a sealant applicator gun. The thickness of the layer depends on the expected mechanical movement. Join the materials to be bonded within 10 minutes after applying the adhesive. Due to the low initial tack we recommend mechanical fixing until a complete cure is obtained. The cure time is dependent on temperature, humidity and the dimensions of the joint.
Storage	Do not store below +5°C or above +25°C. When stored in unopened containers usable up to 9 months.
Cleaning	Clean tools immediately after use with Körasolv PU. Once cured material can only be removed mechanically.

For safety information refer to the Material Safety Data Sheet

KÖMMERLING
KÖMMERLING CHEMISCHE FABRIK GMBH

KÖRAPOP 225 - KÖRAPOP 225 / 2-K

ELASTIC STP ADHESIVES AND SEALANTS

For vehicle bodywork, containers and vehicle manufacture, air conditioning, heating equipment, metalwork etc.
Good adhesion to glass, many kinds of metal (zinc, aluminium, steel), varnished and primed materials, wooden materials, duroplastics and thermoplastics.

Base	Silane modified polymer, curing by reaction with moisture
Colour	White (further colours on request)
Density	1,44 g/cm³
Viscosity	Paste, non-sag properties
Elongation at tear	500 %
Tear strength	3 N/mm²
Tear propagation strength	20 N/mm
Hardness Shore A	42
Characteristics	Elastic, good resistance to moisture, weathering and temperatures from -40°C to +80°C (for short intervalls up to +120°C). Oversprayable with many varnishes immediately after application. Isocyanate-free and silicone-free. For faster curing system, we recommend the use of Körapur 225 / 2-part plus hardener Köracur 310. Approved for indirect contact with food. Good UV resistance. Universally applicable.

	KÖRAPOP 225	KÖRAPOP 225 / 2-K
Pot life	-	20 min
Curing	3 mm (on the first day)	2-3 hours

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

PRODUCT INFORMATION

KÖRAPOP 225 - KÖRAPOP 225 / 2-K

Processing temperature	+5°C to +30°C
Preparation	The surfaces to be bonded must be clean, dry and free of grease. Adhesion and compatibility must be individually tested when used on plastics or paint. Körapop 225 can be used without primer on most materials. Preliminary tests are required.
Bonding	Apply Körapop 225 onto the surfaces using an application gun. The thickness of the layer depends on the types of material to be bonded. Join the materials to be bonded within 10 minutes after applying the adhesive. Due to the low initial tack we recommend mechanical fixing until a complete cure is obtained. The cure time is dependent on the thickness of the layer, temperature and air humidity.
Storage	Do not store below +5°C or above +25°C. Depending on type of container, the storage time is 9 to 12 months.
Cleaning	Clean tools immediately after use with Körasolv PU. Once cured material can only be removed mechanically.

For safety information refer to the Material Safety Data Sheet

KÖMMERLING
KÖMMERLING CHEMISCHE FABRIK GMBH

KÖRAPOP 235 - KÖRAPOP 240

ELASTIC STP ADHESIVES AND SEALANTS

For vehicle bodywork, containers and vehicle manufacture, air conditioning and heating equipment, metalwork, and for industrial applications.
Good adhesion to glass, many kinds of metal (zinc, aluminium, steel), varnished and primed materials, wooden materials, duroplastics, thermoplastics.

Base	Silane modified polymer, one component, curing by reaction with moisture
Colour	White (further colours on request)
Viscosity	Paste, non-sag properties
Skin formation time	10 minutes
Tensile strength	3,3 N/mm²
Characteristics	Elastic, good resistance to moisture, weathering and temperatures from -40°C to +90°C (for short intervalls up to +120°C), overpaintable after curing. Isocyanate-free and silicone-free. Good UV resistance.

	KÖRAPOP 235	KÖRAPOP 240
Density	1,44 g/cm³	1,41 g/cm³
Elongation at tear	550 %	430 %
Tensile shear strength	2,2 N/mm²	2,7 N/mm²
Tear propagation strength	24 N/mm	21 N/mm
Hardness Shore A	50	55

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

PRODUCT INFORMATION

KÖRAPOP 235 - KÖRAPOP 240

Processing temperature	+5°C to +30°C
Preparation	The surfaces to be bonded must be clean, dry and free of grease. Adhesion and compatibility must be individually tested when used on plastics or paint. Körapop 235 and Körapop 240 can be used without primer on most materials. Preliminary tests are required.
Boding	Apply Körapop 235 and Körapop 240 onto the surfaces using an application gun. The thickness of the layer depends on the types of material to be bonded. Join the materials to be bonded within 5 minutes after applying the adhesive. Due to the low initial tack we recommend mechanical fixing until a complete cure is obtained. The cure time is dependent on temperature, air humidity and dimensions of the joint.
Storage	Do not store below +5°C or above +25°C. Depending on type of container, the storage time is 6 to 12 months.
Cleaning	Clean tools immediately after use with Körasolv PU. Once cured material can only be removed mechanically.

For safety information refer to the Material Safety Data Sheet

KÖMMERLING
KÖMMERLING CHEMISCHE FABRIK GMBH

KÖRAPOP 315

ELASTIC STP SEALANT

For industrial applications, air conditioning and heating equipment, metal construction, metalwork, vehicle manufacture and Automotive Aftermarket, etc.
Good adhesion to glass, many kinds of metal (zinc, aluminium, steel), varnished and primed materials, wooden materials, duroplastics, thermoplastics (except PE, PP, PTFE) and mineral substrates.

Base	Silane modified polymer, one component, curing by reaction with moisture
Colour	White, black, grey
Density	1,59 g/cm³
Viscosity	Paste, non-sag properties
Skin formation time	35 minutes
Hardness Shore A	46
Elongaton at tear	220 %
Tensile strength	1,8 N/mm²
Tear propagation strength	24 N/mm
Characteristics	Good resistance to temperatures from -40°C to +90°C (for short intervals up to +120°C).

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

PRODUCT INFORMATION

KÖRAPOP 315

Processing temperature	+5°C bis +30°C
Preparation	The surfaces to be bonded must be clean, dry and free of grease. Adhesion and compatibility must be individually tested when used on plastics or paint. Körapop 315 can be used without primer on most materials. Preliminary tests are required.
Bonding	Apply Körapop 315 onto the surfaces using an application gun. The thickness of the layer depends on the types of material to be bonded. Join the materials to be bonded within 10 minutes after applying the adhesive. Due to the low initial tack we recommend mechanical fixing until a complete cure is obtained. The cure time is dependent on temperature, air humidity and thickness of the layer. Körapop 315 is suitable for spraying with many varnishes immediately after application. Adhesion problems may occur in case of some particular carnish systems.
Storage	Do not store below +5°C or above +25°C. When stored in unopened containers usable up to 12 months.
Cleaning	Clean tools immediately after use with Körasolv PU. Once cured material can only be removed mechanically.

For safety information refer to the Material Safety Data Sheet

KÖMMERLING
KÖMMERLING CHEMISCHE FABRIK GMBH

KÖRAPOP 330 - KÖRAPOP 335

SOLVENT FREE ELASTIC SEALANTS

Körapop 330 is a rapid hardening elastic sealing compound with excellent high initial tack for the building industry, vehicle manufacture, air conditioning, and industrial applications, etc.
Körapop 335 is suitable for waterproofing of swimming pools.
Körapop 330 and Körapop 335 show a good adhesion to glass, many kinds of metal (zinc, aluminium, steel), varnished and primed materials, wooden materials, thermosets, thermoplastics (except PE, PP, PTFE) and mineral substrates.

Base	Silane modified polymer, one component, curing by reaction with moisture
Colour	White, grey, Körapop 335 also available in blue
Viscosity	Paste, non-sag properties
Change in weight	1 %
Characteristics	Elastic, good resistance to moisture, weathering and termperatures from -40°C to +90°C (for short intervals up to +120°C).

	KÖRAPOP 330	KÖRAPOP 335
Density	1,60 g/cm³	1,44 g/cm³
Elongation at tear	200 %	320 %
Tensile strength	2,3 N/mm²	2,6 N/mm²
Tear propagation strength	24 N/mm	21 N/mm
Hardness Shore A	58	55
Skin formation time	10 min	25 min

KÖMMERLING
KÖMMERLING CHEMISCHE FABRIK GMBH

PRODUCT INFORMATION

KÖRAPOP 330 - KÖRAPOP 335

Processing temperature	+5°C to +30°C	
Preparation	The surfaces to be bonded must be clean, dry and free of grease. Adhesion and compatibility must be individually tested when used on plastics or paint. Körapop 330 and Körapop 335 can be used without primer on most materials. Preliminary tests are required. For porous substrates such as wood or concrete, Körabond HG 74 E is recommended. The adhesion on non-porous substrates can be improved by using cleaner Körasolv CR, Körasolv GL, Körasolv PU, or Körabond HG 81 or HG 83. Due to the diversity of substrates, preliminary tests are re commended.	
	KÖRAPOP 330	KÖRAPOP 335
Bonding	Apply Körapop 330 to the substrates using a gun. The thickness of the layer depends on the expected movement within the joint. Insert the material within 10 minutes and press together. The cure time is dependent on thickness of the layer, temperature and air humidity. Sealing Apply Körapop 330 using a sealant applicator gun and spread using a spatula. Ensure 2 to 5 bar when using an air pressure gun.	Apply Körapop 335 to the substrates using a gun. The thickness of the layer depends on the expected movement within the joint. Insert the material within the skin formation time and press together. Körapop 335 is suitable for wet-on-wet overpainting and up to 5 days with many varnishes immediately after application. To secure the bonding of the varnish preliminary tests are recommended. Overpainting defers the curing.
Storage	Do not store below +5°C or above +25°C. When stored in unopened containers usable up to 6 months.	Do not store below +5°C or above +25°C. When stored in unopened containers usable up to 12 months.
Cleaning	Clean tools immediately after use with Körasolv PU. Once cured material can only be removed mechanically.	

For safety information refer to the Material Safety Data Sheet

KÖMMERLING
KÖMMERLING CHEMISCHE FABRIK GMBH

KÖRAPOP 216 - KÖRAPOP 316

MULTIFUNCTIONAL, SPRAYABLE WELD SEALANT

Sprayable weld sealant for the manufacture of vehicles, vehicle body work, containers and metalwork, etc.·
Good adhesion to many kinds of metal (zinc, aluminium, steel), varnished and primed materials, wooden materials, thermoset plastics and thermoplastics (except PE, PP, PS, PC, PMMA, PTFE) and mineral surfaces.
Körapop 316 is solvent free, thus no shrinkage.

Base	Silane modified polymer, one component, curing by reaction with moisture
Colour	White (further colours on request)
Viscosity	Paste, lightly thixotropic, non-sag properties
Characteristics	Elastic, good resistance to moisture, weathering and termperatures from -40°C to +80°C (for short intervals up to +120°C). Suitable for overpainting with many varnishes within 5 days after application. Preliminary tests for compatibility are recommended. Good UV resistance.

	KÖRAPOP 216	KÖRAPOP 316
Density	1,48 g/cm³	1,63 g/cm³
Elongation at tear	270 %	140 %
Tensile strength	1,8 N/mm²	2,3 N/mm²
Tear propagation strength	6 N/mm	10 N/mm
Skin formation time	25 minutes	20 minutes
Hardness Shore A	40	50

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

PRODUCT INFORMATION

KÖRAPOP 216 - KÖRAPOP 316

Processing temperature	+5°C to +30°C	
Preparation	The surfaces to be bonded must be clean, dry and free of grease. Adhesion and compatibility must be individually tested when used on plastics or paint. Körapop 216 and Körapop 316 can be used without primer on most materials. Preliminary tests are required.	
Bonding	Cut open the cartridge at the thread and screw into the gun (follow the instructions of the gun manufacturer). The cartridge may remain in the gun until it is totally empty. Special adjustments directly on the gun allow applications forming a structural or profiled weld as well as an application as surface coating. Do not allow Körapop 216 and Körapop 316 to get in contact with fresh (not fully cured) PU material.	
Storage	Do not store below +5°C or above +25°C. When stored in unopened containers usable up to 15 months.	Do not store below +5°C or above +25°C. When stored in unopened containers usable up to 12 months.
Cleaning	Clean tools immediately after use with Körasolv GL or Körasolv PU. Once cured material can only be removed mechanically.	

For safety information refer to the Material Safety Data Sheet

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

KÖRAPUR 666 - KÖRAPUR 672

SOLVENT FREE 2-PART PUR REACTION ADHESIVE

Reaction adhesive for various bondings in the vehicle industry and for corner angels in aluminium window construction. For manufacture of sandwich elements in the construction and vehicle industry.

Base	Polyurethane, two component, solvent free
Colour	Beige
Characteristics	Good resistance to moisture, weathering and temperature. Good adhesion to aluminium, wood, PVC-rigid and GRP.

	KÖRAPUR 666	KÖRAPUR 672
Density	1,70 g/cm³ (resin) 1,23 g/cm³ (hardener) 1,63 g/cm³ (mix)	1,27 g/cm³ (resin) 1,63 g/cm³ (hardener) 1,60 g/cm³ (mix)
Pot life	Variable (3-90 minutes)	Variable (20-80 minutes)
Viscosity	50.000 mPas (mix)	8.000 mPas (mix)
Mix ratio	Resin : hardener 6 : 1 (by weight)	Resin : hardener 5 : 1 (by weight)
Initial strength	12-16 h (at +20°C and TZ 90 Min)	8 h (at +20°C and TZ 90 Min)
Shear strength	Aluminium / Wood 17 N/mm² at -20°C 14 N/mm² at +20°C 3,5 N/mm² at +80°C	

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

PRODUCT INFORMATION

KÖRAPUR 666 - KÖRAPUR 672

Processing temperature	+5°C to +25°C
Preparation	The surfaces to be bonded must be clean, dry and free of grease. We recommend that metal surfaces should be pretreated and sanded. Adhesion must be tested for compatibility by carrying out preliminary tests. The use of a suitable primer improves the bond strength and ageing characteristics, as well as resistance to hydrolysis. Thoroughly mix the components A + B intensively together until an even colour is obtained. Please notice the application instructions for mixing cartridges.
Bonding	Apply an even layer of adhesive to the surfaces to be bonded using a spatula and join them together. When using Körapur 666 the bond can be exposed to light strain after 12–16 hours. Final bond strength for Körapur 666 is reached after 36 hours, for Körapur 672 after 24 hours.
Storage	Do not store below +10°C or above +25°C. When stored in unopened containers usable up to 12 months.
Cleaning	Clean tools immediately after use with Körasolv PU. Once cured material can only be removed mechanically. When processing Körapur 666 and Körapur 672 avoid direct skin contact with the uncured adhesive. Wear protective gloves.

For safety information refer to the Material Safety Data Sheet

KÖMMERLING
KÖMMERLING CHEMISCHE FABRIK GMBH

KÖRAPUR 840 - KÖRAPUR 842

2-PART PUR REACTION ADHESIVE

Körapur 840 and Körapur 842 are reaction adhesives for various bondings within the container and shipbuilding industry.
Good adhesion to aluminium and steel, glass fibre-reinforced plastics, thermosets and several thermoplastics.

Base	Polyurethane, two component, solvent free	
Colour	Beige	
Characteristics	Good resistance to humidity and weathering. Good impact resistance. Körapur 842 is characterized by very good low temperature flexibility.	
Mix ratio	Resin : hardener 5 : 1 (by weight)	
	KÖRAPUR 840	KÖRAPUR 842
Density	1,55 g/cm³ (resin) 1,23 g/cm³ (hardener) 1,45 g/cm³ (mix)	1,50 g/cm³ (resin) 1,23 g/cm³ (hardener) 1,46 g/cm³ (mix)
Pot life	Variable (2/8/15/20/45 minutes)	Variable (15/20/80 minutes)
Viscosity	40.000 mPas (mix)	55.000 mPas (mix)
Initial strength	40 minutes - 8 hours (depending on TZ)	3 - 12 hours (depending on TZ)
Shear strength	Aluminium / Aluminium 24 N/mm² at -20°C 16 N/mm² at +20°C 4,4 N/mm² at +80°C	Aluminium / Aluminium 13 N/mm² at -20°C 9 N/mm² at +20°C 3 N/mm² at +80°C

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

PRODUCT INFORMATION

KÖRAPUR 840 - KÖRAPUR 842

Processing temperature	+5°C to +25°C
Preparation	The surfaces to be bonded must be clean, dry and free of dust and grease. We recommend that metal surfaces should be pretreated and sanded. For certain plastics such as PVC we recommend a pretreatment with Körabond HG 77. Thoroughly mix the components A + B intensively together until an even colour is obtained. Please notice the application instructions for mixing cartridges.
Bonding	Apply an even layer of adhesive to the surfaces to be bonded using a spatula and join them together. For Körapur 840 and Körapur 842 the bond can be exposed moderately after 12-16 hours. The final strength will be reached after 24 hours.
Storage	Do not store below +10°C or above +25°C. When stored in unopened containers usable up to 12 months.
Cleaning	Clean tools immediately after use with Körasolv PU. Once cured material can only be removed mechanically. When processing Körapur 840 and Körapur 842 avoid direct skin contact of the uncured material. Wear protective gloves.

For safety information refer to the Material Safety Data Sheet

KÖMMERLING
KÖMMERLING CHEMISCHE FABRIK GMBH

KÖRAPUR 572 - KÖRAPUR 648

SOLVENT FREE 2-PART PUR REACTION ADHESIVE

For the manufacture of sandwich elements in the refrigerated vehicles, caravans and motor home industry, and e.g. for the production of doors, cold storage facilities and roof insulation.
Good adhesion to wood, aluminium, steel, GRP, duroplastics and thermoplastics.

Base	Polyurethane, two component, solvent free	
Colour	Beige	
Characteristics	Good resistance to moisture and weathering. Very good adhesion properties.	
Mix ratio	Resin : hardener 5 : 1 (by weight)	
	KÖRAPUR 572	KÖRAPUR 648
Density	1,65 g/cm³ (resin) 1,23 g/cm³ (hardener) 1,60 g/cm³ (mix)	1,49 g/cm³ (resin) 1,23 g/cm³ (hardener) 1,23 g/cm³ (mix)
Pot life	60 minutes	120 minutes
Open time	90 minutes	180 minutes
Viscosity	8.000 mPas (mix)	1.400 mPas (mix)
Handling strength	6-8 hours	12-16 hours

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

PRODUCT INFORMATION

KÖRAPUR 572 - KÖRAPUR 648

Processing temperature	+5°C to +25°C
Preparation	The surfaces to be bonded must be clean, dry and free of dust and grease. We recommend that metal surfaces should be pretreated and sanded. For certain plastics such as PVC we recommend a pretreatment with Körabond HG 77. Thoroughly mix the components A + B intensively together until an even colour is obtained. Please notice the application instructions for mixing cartridges.
Bonding	Apply an even layer of adhesive to the surfaces to be bonded using a spatula and join them together. The thickness of the layer depends on the types of material to be bonded. The final strength for Körapur 572 will be reached after 24 hours, for Körapur 648 after 48 hours. Handling strength is reached earlier.
Storage	Do not store below +10°C or above +25°C. When stored in unopened containers usable up to 12 months.
Cleaning	Clean tools immediately after use with Körasolv PU. Once cured material can only be removed mechanically. When processing Körapur 572 and Körapur 648 avoid direct skin contact of the uncured material. Wear protective gloves.

For safety information refer to the Material Safety Data Sheet

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

KÖRAPUR 784/5

SOLVENT FREE 2-PART PUR REACTION ADHESIVE

For the building and automotive industry, manufacture of vehicles and aftermarket, etc.
For bonding various plastics, such as ABS, PVC-rigid, GRP, steel and aluminium.

Base	Polyurethane, two component, solvent free
Colour	Black
Density	1,2 g/cm³
Viscosity	40.000 mPas
Hardness Shore D	65
Mix ratio	Resin : hardener = 1 : 1,3 (by weight) Resin : hardener = 1 (by volume)
Characterisics	Different pot life versions.

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

PRODUCT INFORMATION

KÖRAPUR 784/5

Processing temperature	+5°C to +25°C
Preparation	The surfaces to be bonded must be clean, dry and free of dust and grease. We recommend that metal surfaces should be pretreated and sanded. The adhesion to the substrates to be bonded must be determined by preliminary tests. Bonding surfaces of GRP must also be sanded. Thoroughly mix the components A + B intensively together until an even colour is obtained.
Bonding	Apply adhesive evenly with a spatula or a doctor blade to the surfaces and join them. High temperatures will shorten the curing time, low temperatures will lengthen it. By different A-components, the pot life and the handling strength can be varied.
Storage	Do not store below +10°C or above +25°C. When stored in unopened containers usable up to 12 months.
Cleaning	Clean tools immediately after use with Körasolv PU. Once cured material can only be removed mechanically.

For safety information refer to the Material Safety Data Sheet

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

KÖRAPUR 201

SOLVENT FREE 1-PART PUR ADHESIVE

For the manufacture of sandwich elements, doors, panels, shutter boxes, gates and for the bonding of scouring pads.

Base	PUR-Prepolymer, one component, solvent free, curing by reaction with moisture
Colour	Brownish
Density	1,1 g/cm³
Viscosity	3.800 mPas
Open time	25 minutes
Flashing point	> 50°C
Characteristics	Good adhesion to pretreated metals, such as galvanized or primed steel, anodized aluminum, to thermosetting plastics, PS, GF-Polyesters, PVC-rigid, ABS, wood and cementitious materials.

KÖMMERLING
KÖMMERLING CHEMISCHE FABRIK GMBH

PRODUCT INFORMATION

KÖRAPUR 201

Processing temperature	+10°C to +25°C
Preparation	The surfaces to be bonded must be clean, dry and free of dust and grease. We recommend that metal surfaces should be pretreated and sanded. The surfaces to be bonded must be prepared that a secure bonding can occur. This includes a mechanical and / or chemical pretreatment.
Bonding	The adhesive is applied to one side of the material to be bonded. Depending on the application this can happen punctual, lamellar, respectively the entire surface using a spatula. Depending on this the consumption is between 100 and 200 g/m². To accelerate the curing water can be sprayed on the adhesive using a squirt bottle. When bonding steam-tight or dry material this is strictly necessary. A recombing through with a spatula or a back and forth of the combined parts is conductive for mixing the water. During the curing reaction carbon dioxide is released which slightly foams the adhesive. After adhesive application, respectively spraying with water the parts can be immediately folded and pressed. This must be done within the open time. Until the setting of the adhesive, the parts must be kept under a freeze pressure which is ensured by an intense contact of the surfaces. The amount of the required pressure and the pressing process is largely determined by the type and size of the bonded components since the adhesive itself needs no pressure to set but the freeze pressure keeps the bonding components together.
Pressing times	The pressing times are dependent on temperature and moisture range. The following guidelines count when water was sprayed: at +20°C approx. 45 minutes at +60°C approx. 10 minutes at +60°C approx. 7 minutes At these times a bond strength is generally reached which allows a processing of the parts. The final strength is reached after a few days.
Storage	Do not store below +10°C or above +25°C. When stored in unopened containers usable up to 12 months.
Cleaning	Clean tools immediately after use with Körasolv PU. Once cured material can only be removed mechanically.

For safety information refer to the Material Safety Data Sheet

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

KÖRACOLL WB 12

SOLVENT FREE DISPERSION ADHESIVE

For the wagon, caravan and container building industry, for bonding floor coverings, sound and thermal insulation, decorative laminates with each other and with wood, sheet metal, glass-fibre reinforced plastics and PUR elements, as well as painted surfaces. Universal adhesive for various applications.

Base	EVA / acrylic ester copolymer with self-cross-linking properties
Colour	White
Density	1,0 g/cm³
Viscosity	9.000 mPas - 13.000 mPas
Solid content	68 %
Consumption	250-400 g/m² (depending on surface)
Characteristics	Good resistance to temperature.

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

PRODUCT INFORMATION

KÖRACOLL WB 12

Processing temperature	+10°C to +35°C
Preparation	The substrates must be free of grease, even, constantly dry, clean, free of cracks, resistant to tensile and compressive strains.
Bonding	For unilateral bonding, apply the adhesive evenly to the substrate using a toothed spatula, toothing A2. Immediately, not later than 10 minutes after application, join the covering, brush or roll on thoroughly. Immediately remove excess adhesive with water. Open assembly time is of approx. 20 minutes. For contact bonds, apply adhesive to the materials to be bonded using a fine toothed spatula, toothing A4, or a brush. Allow to ventilate for about 20 to 40 minutes. Then join the materials and press intensively. During the first phase of curing (3-8 hours), the bond must not be exposed a tensile shear.
Storage	Do not store below +10°C or above +25°C. When stored in unopened containers usable up to 9 months. Protect against frost.
Cleaning	For removing fresh adhesive spots: water. For cleaning of tools and removing cured adhesive spots: Körasolv PU.

For safety information refer to the Material Safety Data Sheet

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

KÖRACOLL 3350

SOLVENT FREE DISPERSION ADHESIVE

For laminating PVC foam foils, PO foils, rigid and soft PVC foils. Also for laminating ABS foils on to wooden materials (particleboard, MDF, etc.), pressboard and other materials by heat sealing method (e. g. membrane pressing, procedure D 3).

Base	Polyurethane
Colour	White
Density	1,04 g/cm³
Solid content	49%
Viscosity	5.000 mPas
Consumption	60-80 g/m² (on closed surface)
Pot life	8 hours
Activating temperature	approx. + 45°C
Characteristics	Suitable for thermal activations to low temperature on temperature sensible substrates.

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

PRODUCT INFORMATION

KÖRACOLL 3350

Processing temperature	+15°C to +35°C
Preparation	The surfaces to be bonded must be clean, dry and free of dust and grease. Please notice application instructions!
Bonding	The adhesive is applicated by spraying equipment gun with a pressure of 3 – 5 bar and a nozzle of 1,5 mm diameter. After curing (approx. 60 min at room temperature, can be accelerated by heat) the adhesion follows, 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 pretests. The maximum temperature resistance is reached after 3 – 4 days.
Storage	Do not store below +10°C or above +25°C. When stored in unopened containers usable up to 6 months.
Cleaning	Cleaning: by water Solvent: Körasolv PU.

For safety information refer to the Material Safety Data Sheet

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

KÖRATEX 263

WATER BASED SYNTHETIC LATEX ADHESIVE

For the shoe industry, pre-assembling and lamination of upper materials. For the insertion of sock lining and insole production. Very good adhesion to synthetic materials. Application method: spray coating, roller coater, and brush.

Base	CR-Latex, solvent free
Colour	milky-white
Density	1,0 g/cm³
Viscosity	600 mPas
Open time	25 minutes
Flashing point	> 50°C
Characteristics	Long open time, high bond strength

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

PRODUCT INFORMATION

KÖRATEX 263

Processing temperature	Do not process adhesive and materials to be bonded below +18°C. Slightly undercooled adhesive should be warmed up and stirred well before use. Protect adhesive strictly from frost. Product will get damaged.
Preparation	The surfaces must be clean, dry and free of grease. One-side wet bonding Coat only one of the bonding surfaces with Köratex 263. Fix the other material while adhesive film is still wet and press intensively. Contact bonding Coat both of the bonding surfaces with Köratex 263. Wait for drying until adhesive films are transparent. Fix materials together and press.
Storage	6 months at +18°C. Containers, tins and adhesive vessels are to be kept tightly closed in order to avoid thickening of the adhesive due to the evaporation of solvents.
Cleaning	Water, or if adhesive film is dry use Körasolv CA.

For safety information refer to the Material Safety Data Sheet

KÖMMERLING
KÖMMERLING CHEMISCHE FABRIK GMBH

KÖRAPREN FU 35 - KÖRAPREN FU 36

POLYCHLOROPRENE CONTACT ADHESIVE

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

Base	Polychloroprene, containing solvent
Density	0,86 g/cm³
Consumption	250-300 g/cm³ (depending on surface)

	KÖRAPREN FU 35 Sprayable, for lager surfaces	KÖRAPREN FU 36 Adhesive for universal contact bonding
Colour	Bright yellow, transparent	Amber
Viscosity	400 mPas	3.200 mPas
Solid	21 %	25 %
Characteristics	Very high contact bonding, good resistance to humidity and heat.	Up to a limited resistance to humidity.

KÖMMERLING
KÖMMERLING CHEMISCHE FABRIK GMBH

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 of grease.
Storage	Do not store below +10°C or above +25°C. When stored in unopened containers usable up to 12 months.
Cleaning	Clean tools with Körasolv PU.

Bonding

KÖRAPREN FU 35

Apply adhesive with spray jet application on the two parts to be bonded large and regularly. Injection pressure and diameter of the spray jets are dependent on the particular application. After a waiting time (ventilation time) of 5–10 minutes place the parts accurately together and firmly press or join them together. The waiting time depends on the room temperature, thickness of the adhesive film and absorbency of the base surface.
The surfaces to be bonded should be placed together when the adhesive film is still slightly sticky but does not stick to the finger when it is pressed lightly.

KÖRAPREN FU 36

Apply adhesive with a brush or a slightly serrated spatula on the two parts to be bonded large and regularly. After a waiting time (ventilation time) of approx. 15 minutes place the parts to be bonded accurately together and briefly and firmly press or join them together. The parts have to be bonded together at least approx. 60 minutes after the application of the adhesive. The waiting time depends on the room temperature, thickness of the adhesive film and absorbency of the base surface.

For safety information refer to the Material Safety Data Sheet

KÖMMERLING
KÖMMERLING CHEMISCHE FABRIK GMBH

KÖRATAC HF 300 - KÖRATAC DF 841

COLD-WELDING AGENT

Cold-welding agent for PVC-rigid, PVC-soft and ABS.

Colour	Transparent	
	KÖRATAC HF 300 For bonding of PVC-rigid and ABS	**KÖRATAC DF 841** For bonding of PVC-soft
Base	Vinylchloride polymers in dissolved form	Synthetic resin
Density	1,0 g/cm³	0,9 g/cm³
Consumption	250-400 g/m²	60-100 g/m²
Characteristics	High resistance to water, alcohol, oils, benzine. Extremely resistant to yellowing. Resistant to temperatures from –25°C to +90°C.· A variant with low viscosity is available as Köratac HF 303.	Strong dissolving and swelling. High contact adhesion, good resistance to moisture and heat.

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

PRODUCT INFORMATION

KÖRATAC HF 300 - KÖRATAC DF 841

Processing temperature	+15°C to +25°C	
	KÖRATAC HF 300	KÖRATAC DF 841
Preparation	Bonding pipes and fittings Clean the pipe previously cut at right angles to the exact dimensions, trimmed and chamferred, as well as the fittings and socket ends using Körasolv CR or Körasolv PU and tissue paper after each cleaning sequence. Dry the cleaned surfaces with clean tissue paper. The surfaces to be bonded must be dry, clean and free of dust and grease.	Due to the multitude of different PVC types, in particular of plasticized PVC, preliminary tests have to be carried out for examination of swelling and dissolving characteristics of the material. Clean contaminated foils with Körasolv GL.
Storage	Do not store below +12°C. When stored in unopened containers usable up to 12 months.	

For safety information refer to the Material Safety Data Sheet

KÖMMERLING
KÖMMERLING CHEMISCHE FABRIK GMBH

KÖRATAC C 3 - KÖRATAC C 12

INSTANT BONDING ADHESIVE BASED ON CYANOACRYLATE

For bonding rubber, plastics for the automotive, building and vehicle industry.

Base	Cyanoacrylate
Colour	Transparent
Density	1,0 g/cm³

	KÖRATAC C 3	KÖRATAC C 12
Consistency	High vicosity	Low viscosity
Viscosity	1.100 mPas	50-85 mPas

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

PRODUCT INFORMATION

KÖRATAC C 3 - KÖRATAC C 12

Processing temperature	Adhesive and materials to be bonded should not be below +18°C.	
	KÖRATAC C 3	KÖRATAC C 12
Preparation	The surfaces to be bonded must be very well cleaned and free of grease. Acetone, and other grease-dissolving solvents are suitable. Rubber and other elastomers must be cleaned with acetone. If possible, the surfaces should be roughened by sanding or sandblasting to achieve a good fixation for the adhesive. In some cases, pretreatment of the surfaces with chemicals could be an advantage.	The surfaces to be bonded must be dry, clean and free of dust and grease. The surfaces must be prepared to allow a secure adhesion. This includes possibly a mechanical and / or chemical pre-treatment.
Storage	Köratac C 3 must be protected from sunlight, humidity and heat during storage. At max. +20°C, the shelf life is approx. 6 months.	Köratac C 12 must be protected from sunlight, humidity and heat during storage. At max. +18°C, the shelf life is approx. 12 months.

For safety information refer to the Material Safety Data Sheet

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

KÖRATAN UK 1000

SOLVENT-CONTAINING ADHESIVE BASED ON STYRENE RUBBER

For bonding EPDM and butyl foils with concrete, masonry, wood, glass, aluminium, steel and bitumen or lap joint connections.
Also suitable for bonding EPDM / EPPM or Butyl / Butyl.

Base	Styrene rubber, containing solvent
Colour	Black
Density	approx. 1,0 g/cm³
Viscosity	Paste
Open time	10 minutes
Solid	approx. 75 %
Consumption	approx. 200-300 g/m²

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

PRODUCT INFORMATION

KÖRATAN UK 1000

Processing temperature	-5°C to +35°C
Preparation	The surfaces must be dry, clean and free of dust and grease. Apply the adhesive to one surface using a spatula. Insert the EPDM foil immediately, after 10 minutes at the latest and press. The exact waiting time depends on room temperature, thickness of the adhesive film and absorbency of the base surface.
Storage	Do not store below +15°C. When stored in unopened containers usable up to 24 months.
Cleaning	Körasolv CR

For safety information refer to the Material Safety Data Sheet

KÖMMERLING
KÖMMERLING CHEMISCHE FABRIK GMBH

KÖRAPLAST SF - KÖRAPREN 1074

POLYCHLOROPRENE ADHESIVES

Suitable for many applications for the shoe industry such as the insertion of sock lining and insole production.
Köraplast SF is especially suited for extremely stressed contacts (e.g. in the field of heavy or sports shoes).

	KÖRAPLAST SF	KÖRAPREN 1074
Base	Polyurethane, solvent free	Polychloroprene,containing solvent
Colour	Transparent	Yellowish
Density	0,9 g/cm³	0,83 g/cm³
Viscosity	2.700 mPas	3.500 mPas
Pot life	6 to 8 h (with addition of Köracur TR 280)	-
Open time	-	15 minutes to 24 hours
Characteristics	As one or two component version available, for extremely stressed compounds.	Long open time

KÖMMERLING
KÖMMERLING CHEMISCHE FABRIK GMBH

PRODUCT INFORMATION

KÖRAPLAST SF - KÖRAPREN 1074

Processing temperatures	Not below +18°C	
	KÖRAPLAST SF	KÖRAPREN 1074
Preparation	Rough leather, rubber, crepe, PVC and PUR materials carefully. For PUR materials we recommend primering with Kö-PUR. PVC must be washed up. TR soles and rubber materials must be halogenated with Halosol S or Halosol 6.	The surface must be dry, free of dust and grease. Insole manufacturing: Rough leather- insoles. Sharpen thick leathers and dressed velour splits.
Storage	Do not store below +10°C. When stored in unopened containers usable up to 12 months.	Do not store below +18°C. When stored in unopened containers usable up to 6 months.
Cleaning	Körasolv CA, Körasolv PU	Körasolv CR, Körasolv M

For safety information refer to the Material Safety Data Sheet

KÖMMERLING
KÖMMERLING CHEMISCHE FABRIK GMBH

KÖRAPLAST 173 - KÖRAPLAST 179 M

SOLVENT-CONTAINING POLYURETHANE ADHESIVE AND PRIMER

	For bonding soles of leather, halogenated TPR / rubber, PVC, PUR and polyamide to leather / synthetic uppers. Köraplast 173 is suitbale for pretreatment of greasy and fibrous leather, bonding of household sponges.
Base	Polyurethane, containing solvent
Colour	Transparent
Pot life	4–6 hours with Köracur TR 400 6–8 hours with Köracur TR 280 20–24 hours with Köracur TR 203
Mix ratio	5 - 10 %

	KÖRAPLAST 173	KÖRAPREN 179 M
Density	0,84 g/cm³	0,85 g/cm³
Viscosity	750 mPas	3.000 mPas
Characteristics	High heat resistance, good machine running characteristics.	High initial bond strength, very good setting contact.

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

PRODUCT INFORMATION

KÖRAPLAST 173 - KÖRAPLAST 179 M

Processing temperature	Not below +18°C	
	KÖRAPLAST 173	KÖRAPLAST 179 M
Preparation	Rough leather soles as well as lasting margins carefully and remove dust.	Leather, rubber and PUR-soles as well as lasting margins have to be carefully roughened. For PUR-soles which cannot be roughed, we recommend primering with Körabond PUR 50 / PUR 65. Soles of TPR and rubber difficult to bond must be halogenated with Halosol W 5 FL / Halosol 6. For cleaning the surface wash PVC-soles with Körasolv M. Polyamide-soles must be pretreated with Körabond 5. Greasy and fibrous leathers must be primed with Köraplast 172 / Köraplast 173, extreme greasy leathers with Köraplast 154 LF.
Storage	Do not store below +18°C. When stored in unopened containers usable up to 6 months.	
Cleaning	Körasolv CA, Körasolv M	

For safety information refer to the Material Safety Data Sheet

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

KÖRATAN KS 527

SOLVENT ADHESIVE BASED ON SYNTHETIC RUBBER

Suitable for bonding polystyrene (Styrofoam®), polyurethane foams with outer layers made of thermoplastics, metal, wood, plaster, glass and masonry.
Often used for insulation sector and in the construction of refrigeration cabinets.

Base	Synthetic rubber, containing solvent
Colour	Beige
Density	approx. 0,8 g/cm³
Consistency	Easily brushable
Drying time	5 - 15 minutes
Solid	41 %
Consumption	150-200 g/m²
Characteristics	High initial bond strength (contact adhesion), resistant to temperatures from -30°C to +65°C.

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

PRODUCT INFORMATION

KÖRATAN KS 527

Processing temperature	+10°C to +30°C
Preparation	Apply adhesive with spray jet application on the two parts to be bonded large and regularly. Use nozzles with a diameter of approx. 1.5–2.0 mm and a spray pressure of 2,5–3 bar. After a waiting time (ventilation time) of 5 minutes, at the latest 15 minutes, place the parts accurately together and firmly press them together. The drying time should be at least 5 minutes to avoid solvent inclusions in the adhesive layer. The waiting time depends on the room temperature, thickness of the adhesive film and absorbency of the base surface. The surfaces to be bonded should be placed together when the adhesive film is still slightly sticky but does not stick to the finger when it is pressed lightly. During the first application store away from heat. The adhesive film contains a small rest of solvent – especially by use of non-absorbent materials.
Storage	Do not store below +10°C. When stored in unopened containers usable up to 6 months.
Cleaning	Körasolv KS

For safety information refer to the Material Safety Data Sheet

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

KÖRALIT F 140

SOLVENT ADHESIVE BASED ON NITRILE RUBBER

Resistant to oil and plasticizers adhesive for bonding PVC (rigid and soft), metals, ceramics, glass, wood, and stone, etc.

Base	Nitrile rubber, containing solvent
Colour	Yellowish-transparent
Density	approx. 0,9 g/cm³
Viscosity	3.000 mPas
Solid	27 %
Consumption	100 - 150 g/m²
Characteristics	Good moisture and temperature resistant, soft elastic. The characteristics of the adhesive are considerably improved by adding a hardener or accelerator.

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

PRODUCT INFORMATION

KÖRALIT F 140

Processing temperature	Not below +12°C.
Preparation	Apply an even thin layer of the adhesive on both surfaces using a brush or a fine-toothed spatula. After a waiting time of 2 to 5 minutes, depending on material, absorbency, temperature, etc. join the parts to be bonded and press or roll them. In case of extremely severe requirements with regard to resistance and stability of the bond, we recommend to add 5 % of accelerator / hardener Köracur TR 203, e.g. when bonding soft PVC or metals. Mix intensively if accelerator / hardener is added to the adhesive. Only prepare a quantity of mix which can be processed within about 5 hours (pot life). Stir the adhesive well.
Storage	Do not store below +10°C. When stored in unopened containers usable up to 6 months.
Cleaning	Körasolv PU

For safety information refer to the Material Safety Data Sheet

KÖMMERLING
KÖMMERLING CHEMISCHE FABRIK GMBH

KÖDIPLAST CS - KÖDIPLAST CT 100

BUTYL SEALANTS

Sealant for external joints, gaps and junctions on surfaces like concrete, wood, metal, glass, plastics and many other duroplastics and other materials. Sealant for caravans, camper, trucks, shipbuilding and apparatus construction.

Base	Butyl rubber, one component	
Colour	Grey	
Viscosity	Paste, spreadable	
Volume shrinkage	20%	
Loss of weight	15%	
Characteristics	Resistant to temperatures from -30°C to +80°C. Good resistant to weathering, not resistant to oils, solvent and fuels.	
	KÖDIPLAST CS Soft, plastic, non-sag properties	**KÖDIPLAST CT 100** Soft, plastic
Density	1,34 g/cm³	1,44 g/cm³

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

PRODUCT INFORMATION

KÖDIPLAST CS - KÖDIPLAST CT 100

Processing temperature	+15°C to +25°C
Preparation	The surfaces must be dry, clean and free of grease. To degrease non-porous surfaces like glass, metal, use Körasolv GL (use colourless crêpe paper or similar). Attention to plastics like Polycarbonate and PMMA (stress cracking!, please ask us for advise).
Jointing	For the processing guns are used, in which the sausages are inserted. Trapping of air bubbles have to be avoided. The final condition will be reached after total emission of all volatile components whereas the required time depends on the size of the gap and temperature. During application of Ködiplast as adhesive for EPDM-foils a trivial wrinkling of the foil could appear. After short time this effect is reversible.
Storage	Do not store below +5°C or above +30°C. When stored in unopened containers usbale up to 12 months.
Cleaning	For cleaning tools and to remove fresh adhesive spots: Körasolv PU For cleaning the bonding surfaces, especially glass, metal and plastics: Körasolv GL

For safety information refer to the Material Safety Data Sheet

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

KÖDITEC 114

SOLVENT FREE SILICONE SEALANT

Adhesive and sealant with high temperature resistance for bonding of glass plates for oven and sealing of parts and devices at high temperature, FIPG (Formed in Place Gasket) as wet and dry sealing in the engine production (oil pan, valve bonnet, etc.), for the manufacture of heat protection units.

Base	Silicone rubber, one component, curing by reaction with humidity
Colour	Anthracite
Density	1,2 g/cm³
Hardness Shore A	50
Skin formation time	5 minutes
Characteristics	Temperature resistant up to +250°C (long term), temperature resistant up to +350°C (short term), excellent resistance against motor oil and cooling liquid, high mechanical strengths.

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

PRODUCT INFORMATION

KÖDITEC 114

Preparation	The substrate must be dry and free of dust and grease, otherwise a decrease in adhesion may occur. In some cases a pretreatment of the surfaces is necessary. Körasolv GL (use colourless crepe paper, etc.) is suitable for degreasing non-porous surfaces, e.g. metal, glass. Be careful when cleaning plastic materials which are susceptible to stress cracking, e. g. polycarbonate, polyacrylates.
Vulcanisation	Köditec 114 vulcanises under the influence of air humidity. Low temperatures and low air humidity delay the curing process, higher values accelerate it. Thicker silicone layers take correspondingly longer to cure.
Joint dimensions	The joints to be sealed should be at least 4 mm wide and 4 mm deep. For joint widths up to approx. 5 mm, a joint with 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 is to be pressed into the joint. This insert material which should possibly be convex, e. g. polyethylene foam, is to be inserted in such a way that the adhesion surface on the joint flanks is as large as possible (see also German DIN standard 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 +5°C or above +30°C. When stored in unopened containers usable up to 12 months.
Cleaning	To clean tools and remove fresh spots use Körasolv GL.

For safety information refer to the Material Safety Data Sheet

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

KÖDISIL N

SOLVENT FREE SILICONE SEALANT

Fast curing elastic silicone sealant for sealing, filling and jointing of joints, cracks and junctions in and between concrete, stone, ceramics, glass, steel, aluminium, duroplastics and many thermoplastics (except PMMA), wood and other materials. For applications in the houseware industry, construction, vehicle, trailer, container and boat building, etc.
Ködisil N is suitable as a sanitary silicone by fungicidal setting.

Base	Silicone ruber, one component, curing by reaction with moisture
Colour	White, transparent
Density	1,27 g/cm³ (white) 1,02 g/cm³ (transparent)
Hardness Shore A	23 (white) 19 (transparent)
Skin formation time	5 minutes
Max. movement capability	25%
Characteristics	Good weathering and ageing resistance, largely resistant to many solvents, oils, fuels, water, some acids, cleaning agents, etc. Temperature resistant from -40°C to +160°C. Paint compatibility according to DIN 52452 T4.

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

PRODUCT INFORMATION

KÖDISIL N

Preparation	The joints must be dry and free of grease and dust, otherwise the adhesive strength may be reduced. Körasolv GL is suitable for degreasing non-porous surfaces such as glass and metal (use uncoloured crepe paper or similar). Care must be taken with plastics which are susceptible to stress cracking.
Jointing process	Inject Ködisil N into the gap using a skeleton gun. For better wetting, some pressure should be exerted on the edges of the joint when applying the material. Wider joints should be filled in several operations with the Silikon N being applied first to the joint edges to ensure contact between the sealant and the complete surface of the edges of the joint.
Joint dimension	The joints to be sealed should be at least 4 mm wide and 4 mm deep. For joint widths up to approx. 5 mm, a joint with 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 is to be pressed into the joint. This insert material which should possibly be convex, e. g. polyethylene foam, is to be inserted in such a way that the adhesion surface on the joint flanks is as large as possible (see also German DIN standard 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. When stored in unopened containers usable up to 12 months.
Cleaning	To clean tools and remove fresh spots use Körasolv GL.

For safety information refer to the Material Safety Data Sheet

KÖMMERLING
KÖMMERLING CHEMISCHE FABRIK GMBH

KÖRATAPE AT 2 - KÖRATAPE AT 3

ACRYLATE ADHESIVE TAPE

Köratape can be used in a variety of applications including automotive, railway and electrical industry, as well as in the furniture or metal industry.
Example applications: Side protection strips, logos, emblems, etc.

Base	Acrylat, solvent free
Thickness	0,64 mm to 2 mm
Width	6 mm to 457 mm
Temperature range	-35°C to +90°C

	KÖRATAPE AT 2 Acrylate adhesive tape with acrylate hard resin core	KÖRATAPE AT 3 Acrylate adhesive tape with acrylate hard resin core
Colour	Grey	Translucent
Tear strength	0,95 Mpa	1,4 Mpa
Elongation	900%	500%
Peel adhesion	1,75 N/mm	2,63 N/mm

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

PRODUCT INFORMATION

KÖRATAPE AT 2 - KÖRATAPE AT 3

Processing temperature	+10°C to +35°C
Preparation	The surfaces to be bonded must be dry, clean and free of dust and grease. Clean substrates at the earliest 15 minutes before bonding with Körasolv CR, GL, WL and then let it dry. To ensure removal of all contaminants without leaving any residue, use a clean, lint-free wiping cloth or disposable wipe (never recycled rags). Insure optimum substrate temperature, never below +15°C at application time.
Application instruction	1. Apply the part to be bonded without entrapping air between the tape and the substrate with a recommended minimum application pressure of 2.5 kg/cm of tape width to achieve adhesive to substrate contact and maximum bond strength. The strength of the bond depends on the contact between the glue with the surface to be bonded. 2. To connect with a second substrate remove the protective release and proceed as in step 1.
Storage	Two years minimum from date of manufacture (at +20°C and 50% rel. humidity).
Cleaning	Körasolv CR, GL oder WL

For safety information refer to the Material Safety Data Sheet

KÖMMERLING
KÖMMERLING CHEMISCHE FABRIK GMBH

KÖRAPUR 689 - KÖRAPUR 690

PUR COATING COMPOUND

Körapur 689 and Körapur 690 are PUR coating compounds for coating floors for transporting ships, containers, ferries, etc. on polyester, aluminium, primed steel sheets and timber.
Particularly suitable for fresh food vehicles, meat and fish vehicles as well as refrigerating vehicles (tested up to -30°C).
Approved for indirect food contact. Test certificate available.

Base	Polyurethane, two component
Colour	Grey
Characteristics	Good adhesion to a wide variety of substrates, good abrasion resistance, test according to EN 438

	KÖRAPUR 689 Self levelling	KÖRAPUR 690 Paste, structural viscosity
Density	1,40 g/cm³ (mix)	1,14 g/cm³ (mix)
Viscosity	3.600 mPas (mix)	33.000 mPas (mix)
Mix ratio	4 : 1 by weight	3 : 1 by weight
Consumption	2-5 kg/m²	600-800 g/m²
Pot life	35 minutes at +20°C	120 minutes at +20°C
Tensile strength	18 N/mm²	not measurable
Elongation at tear	15%	not measurable
Hardness Shore D	70	not measurable

KÖMMERLING
KÖMMERLING CHEMISCHE FABRIK GMBH

PRODUCT INFORMATION

KÖRAPUR 689 - KÖRAPUR 690

Processing temperature	+15°C to +25°C
Coating	Please notice the application instructions!
Preparation	**KÖRAPUR 689** The surfaces to be coated must be disposed horizontally, dry and free of dust and grease. The substrates must be prepared in order to assure a good adhesion. Uncoated wooden sheets must not exceed 8-12% of humidity. Coats on wooden sheets must be removed completely by grinding. Sheet joints are to be bended by tongue and groove and by frictional connection. If necessary, a glass fibre cloth strip must be inserted in order to avoid the formation of tearings and marks. Fill holes and sinkings, e.g. with Körapur 666. Polyester must be thoroughly grinded. Polyester surfaces which may contain release agents, such as paraffine, must be sand blasted. Degrease and grind stainless steel and aluminium surfaces. When repairing older floors, particular care must be given to the pretreatment of the substrate. Good results are achieved with sand blasting. **KÖRAPUR 690** The surfaces must be clean, dry and free of dust and grease. The substrates must be prepared in order to assure a good adhesion. This includes, where appropriate mechanical and / or chemical pretreatment. When repairing older floors, particular care must be given to the pretreatment of the substrate. Good results are achieved with sand blasting.
Storage	Do not store below +5°C or above +25°C. When stored in unopened containers usable up to 12 months.
Cleaning	Clean tools immediately after use with Körasolv PU. Once cured material can only be removed mechanically.

For safety information refer to the Material Safety Data Sheet

KÖMMERLING
KÖMMERLING CHEMISCHE FABRIK GMBH

KÖRAPOX BS 85 - KÖRAPOX BS 90

EPOXY RESIN SEALINGS

Körapox BS 85 and Körapox BS 90 are epoxy resin sealings for non-slipping sealings of coated floors for transporting ships, containers, ferries, etc. on polyester aluminium, primed steel sheets and timber. Particularly suitable for fresh food vehicles, meat and fish vehicles as well as refrigerating vehicles (tested up to -30°C). Approved for indirect food contact. Test certificate available.

Base	Epoxy, two component	
Colour	Grey	
Open time	30 minutes	
Characteristics	Good adhesion to a wide variety of substrates, good resistance to water, salt water and yellowing.	
	KÖRAPOX BS 85 Good resistance to yellowing	**KÖRAPOX BS 90** Good adhesion to metal
Density	1,14 g/cm³ (mix)	1,55 g/cm³ (mix)
Viscosity	Low viscosity	35.000 mPas (mix)
Mixing ratio	4 : 1 by weight	7 : 1 by weight
Consumption	250 g/m²	800-1.000 g/m²
Pot life	90 minutes at +20°C	8 hours at +20°C

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

PRODUCT INFORMATION

KÖRAPOX BS 85 - KÖRAPOX BS 90

Processing temperature	+15°C to +25°C	
Coating	Please notice application instructions!	
Preparation	**KÖRAPOX BS 85** The surfaces must be solid, clean, dry (no more than 15% humidity) and free of grease. Concrete slush, oil, colour-residues etc. must be removed thoroughly, if necessary by using a flame or sand jet. The substrate and pretreatment must be appropriate for final purpose. Mix components A and B (mixing ratio 4:1) thoroughly with a stirrer (approx. 400rpm), then pour the mixture in a clean pot and mix again. 1. Application step (priming coat): Dilute Körapox BS 85 with up to 20% Körasolv PU. 2. Application step (finishing coat): Use Körapox BS 85 without solvent or add up to a maximum of 10% Körasolv PR.	**KÖRAPOX BS 90** The surfaces must be clean, dry and free of dust and grease. The substrates must be prepared in order to assure a good adhesion. This includes, where appropriate mechanical and / or chemical pretreatment. Glass fibre-reinforced plastics and aluminium substrates should be pretreated by grinding or sanding. Aluminium surfaces must be sanded (sandpaper grit 60). Not suitable for sealing pliable substrates such as wood. When repairing older floors, particular care must be given to the pretreatment of the substrate. Good results are achieved with sand blasting.
Storage	Do not store below +5°C or above +25°C. When stored in unopened containers usable up to 12 months.	
Cleaning	Clean tools immediately after use with Körasolv PU. Once cured material can only be removed mechanically.	

For safety information refer to the Material Safety Data Sheet

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

KÖRABOND PR 262 - HALOSOL 6

PRIMER

Primer for pretreatment of difficult surfaces such as TPE, PE, PP, EVA, EPDM and of rubber-, TPR- and latex soles.

	KÖRABOND PR 262	HALOSOL 6 Flourescent
Base	Synthetic resins, solvent, containing chlorine	Derivate of halogens, solvent
Colour	Amber	Yellowish-transparent
Density	0,87 g/cm³	0,90 g/cm³
Viscosity	-	approx. 5 mPas at +20°C

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

PRODUCT INFORMATION

KÖRABOND PR 262- HALOSOL 6

	KÖRABOND PR 262	HALOSOL 6
Processing temperature	+15°C to +35°C	Do not process below +18°C. Undercooled halogenizer should be warmed up (not with open flame) and stirred well before use.
Preparation	Substrates to be primered must be dry, clean and free of dust and grease.	Halosol 6 is ready for use. Rough rubber- and latex soles, if possible, and remove dust. If necessary, wash TPR-soles with Körasolv KS for removing rests of release agent / colour. Application Apply Halosol 6 by metal-free brush with nylon hairs. Take care that primer is wetting the full surface. Brush intensively, but do not apply too much. Full surface coating can be checked within production process under UV-light (fluorescent-indicator). Wait for drying minimum 60 minutes before applying PUR-based main coat.
Storage	Do not store below +10°C. When stored in unopened containers usable up to 6 months.	Do not store below +18°C. When stored in unopened container usable up to 6 months. Avoid exposure of moisture.
Cleaning	Körasolv CR	Körasolv CA, Körasolv M

For safety information refer to the Material Safety Data Sheet

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

KÖRAPOX 565

2-PART REACTION ADHESIVES

Two part reaction adhesive for bonding of metals, for example steel or aluminium. Applications are e.g. high strength metal bondings for the railway vehicle manufacturing, the industry or the marine industry. In addition to bond irons, halogen lamps, corner angles in the window construction, boats, golf clubs, bicycles, filters , etc.

Base	Epoxy resin, two component, solvent free
Colour	White
Density	Component A: 1,45 g/cm³ Component B: 1,48 g/cm³ Mix: 1,47 g/cm³
Viscosity	Paste, easy to apply
Mixing ratio	A : B = 1 : 1
Pot life	50 minutes
Hardness Shore D	80
Characteristics	Resistant to moisture and humidity.

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

PRODUCT INFORMATION

KÖRAPOX 565

Preparation	The surfaces must be clean, dry and free of dust and grease. Metals must normally be pre-treated and possibly sanded. GRP-surfaces must also be sanded. Resin and hardener will be mixed with a static mixer.
Bonding	Apply adhesive evenly to the surfaces to be bonded and join them. The adhesive will cure in thin layer without shrinkage. The bond can be exposed moderate after 6-8 hours. The final strength will be reached after 24 hours. Higher temperatures shorten the curing time, lower temperatures extend it.
Storage	Store containers dry and tightly closed at room temperature (not below 0°C) and not more than 12 months.
Cleaning	Clean tools immediately after use with Körasolv PU. Once cured material can only be removed mechanically.

For safety information refer to the Material Safety Data Sheet

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

KÖRAPOX 551

2-PART REACTION ADHESIVE

Two-part reaction adhesive for bonding von metals, glass ceramics and many duromers and thermoplastics.

Base	Epoxy resin, two component, solvent free
Colour	White
Density	Component A: 1,7 g/cm³ Component B: 1,7 g/cm³ Mix: 1,7 g/cm³
Viscosity	Paste
Mix ratio	A : B = 1 : 1
Pot life	90 minutes
Hardness Shore D	87
Characteristics	Good resistance to moisture and weathering

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

PRODUCT INFORMATION

KÖRAPOX 551

Preparation	The surfaces must be clean, dry and free of grease. Metals must normally be pre-treated and possibly sanded. Resin and hardener must be fixed thoroughly with a stirrer (approx. 400 revs/min) until the mixture shows a uniform colour.
Bonding	Apply adhesive evenly 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.
Storage	Store containers dry and tightly closed at room temperature (not below 0°C) and not more than 6 months.
Cleaning	Clean tools immediately after use with Körasolv PU. Once cured material can only be removed mechanically.

For safety information refer to the Material Safety Data Sheet

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

KÖRASOLV PR - KÖRASOLV PU - KÖRASOLV WL neu - KÖRASOLV CR

CLEANER AND THINNER

	KÖRASOLV PR	KÖRASOLV PU	KÖRASOLV WL neu	KÖRASOLV CR
Application	Very powerful cleaner for old floors. Also for PVC foiled sheets.	Very effective cleaner for removing with adhesive soiled areas.	Mild cleaner based on gasoline for removing waxen surfaces etc.	Cleaner and thinner for Körapur, Körapox, and Köratac adhesive.
Base	Mixture of organic solvents, free of toluene	Mixture of organic solvents, free of toluene	Mixture of organic solvents	Mixture of organic solvents, free of toluene
Density	0,9 g/cm³	0,81 g/cm³	0,8 g/cm³	0,77 g/cm³

KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

KÖRABOND HG 74 E - KÖRABOND HG 77

PRIMER AND CLEANER

Körabond HG 74 E and Körabond HG 77 are primers for pretreatment of the substrates for subsequent bonding with 1-part PUR and 1-part POP adhesives and sealants. The use of the primer improves the adhesion and moisture resistance of the adhesive bond. The suitability has to be clarified by preliminary tests.

Base	Synthetic resin, containing solvent	
Viscosity	Low viscosity	
	KÖRABOND HG 74 Moisture curing primer	**KÖRABOND HG 77** 1-part primer
Colour	Yellowish, transparent, red	Colourless, transparent
Density	1,0 g/cm³	0,92 g/cm³
Consumption	100 g/m²	40-80 g/m²
Drying time	20 minutes	30 minutes
Application	For pretreatment of absorbant substrates like wood or concrete. For subsequent bonding of 1-part PUR or 1-Part POP adhesives and sealants.	Primer for pretreatment of rigid PVC and ABS for subsequent bonding. Full cure must be attained before overpainting with Körapop.

KÖMMERLING
KÖMMERLING CHEMISCHE FABRIK GMBH

PRODUCT INFORMATION

KÖRABOND HG 74 E - KÖRABOND HG 77

Processing temperature	+10°C bis +25°C
Preparation	The surfaces to be bonded must be clean, dry and free of dust and grease.
Storage	Store well sealed and dry, do not store below +10°C and no longer than 12 months.
Cleaning	Clean tools with Körasolv PU.
Bonding	**KÖRABOND HG 74 E** Apply adhesive with spray jet application on the two parts to be bonded large and regularly. Injection pressure and diameter of the spray jets are dependent on the particular application. After a waiting time (ventilation time) of 5–10 minutes place the parts accurately together and firmly press or join them together. The waiting time depends on the room temperature, thickness of the adhesive film and absorbency of the base surface. The surfaces to be bonded should be placed together when the adhesive film is still slightly sticky but does not stick to the finger when it is pressed lightly. **KÖRABOND HG 77** Apply Körabond HG 77 with a brush or a roller onto the surfaces to be bonded and let it dry for at least 30 minutes. The subsequent bonding must be done within 24 hours to achieve maximum adhesion. Otherwise, the primer must be applied again. For unknown and new materials suitability and compatibility tests are essential.

For safety information refer to the Material Safety Data Sheet

KÖMMERLING
KÖMMERLING CHEMISCHE FABRIK GMBH

KÖRABOND HG 81 - KÖRABOND HG 83

PRIMER

Primer for pretreatment of surfaces for subsequent bonding with 1-part PUR and 1-part POP adhesives and sealants. The use of the primer improves the adhesion and moisture resistance of the adhesive bond. The suitability is to be tested by preliminary tests.

Base	Synthetic resin, containing solvent
Viscosity	Low viscosity
Consumption	20-40 g/m²
Drying time	> 2 minutes
Application	For the pretreatment of non-absorbant substrates such as metals (aluminium, steel, VA-steel, brass, copper, zinc, tin), plastics (ABS, rigid PVC, PA, GRP, SMC, PUR), painted surfaces, gelcoat, enamel, ceramics and coated glass for the subsequent bonding with elastic adhesives and sealants.

	KÖRABOND HG 81 Primer	KÖRABOND HG 83 Primer
Colour	Yellowish transparent, red	Colourless, transparent
Density	0,8 g/cm³	0,77 g/cm³

KÖMMERLING

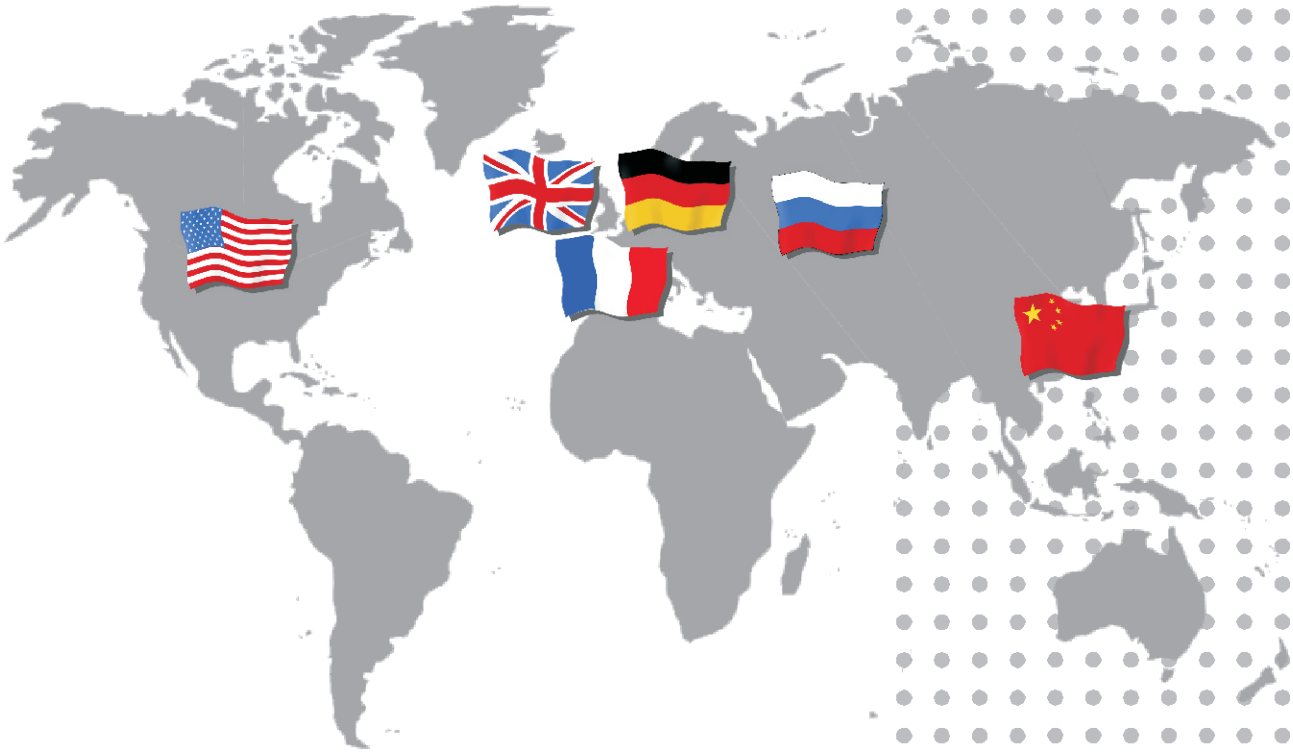
KÖMMERLING CHEMISCHE FABRIK GMBH

PRODUCT INFORMATION

KÖRABOND HG 81 - KÖRABOND HG 83

Processing temperature	+10°C to +35°C
Preparation	The surfaces to be bonded must be clean, dry and free of dust and grease.
Storage	Do not store below +10°C. When stored in unopened containers usable up to 12 months.
Processing	Apply Körabond HG 81 and HG 83 onto the surfaces to be bonded and let it dry. Apply only in one direction using a non-fibre cloth which should be changed frequently. Drying time will be approx. 10 minutes. The subsequent bonding must be done within 24 hours to achieve maximum adhesion. Otherwise the primer must be applied again. Allow proper drying time and do not use Körabond HG 81 or HG 83 on non-absorbent and porous surfaces. For unknown and new materials suitability and compatibility tests are essential.

For safety information refer to the Material Safety Data Sheet



KÖMMERLING

KÖMMERLING CHEMISCHE FABRIK GMBH

KÖMMERLING CHEMISCHE FABRIK GMBH
Zweibrücker Str. 200
D-66954 Pirmasens
Germany
0049 6331 56-2000 phone
0049 6331 56-1999 fax
e-mail: info@koe-chemie.de
www.koe-chemie.de

KOMMERLING UK Ltd.
27, Riverside Way
GB-Uxbridge Middlesex UB8 2YF
Great Britain
0044 1895 465-600 phone
0044 1895 465-617 fax
e-mail: enquiries@kommerlinguk.com
www.kommerlinguk.com

KOEMMERLING CHIMIE SARL
7, Rue des Corroyeus
FR-67200 Strasbourg
France
0033 388 0252-00 phone
0033 388 0252-18 fax
e-mail: info@koe-chemie.de
www.koe-chemie.fr

ADCO PRODUCTS INC.
4401 Page Avenue
US-Michigan Center MI 49254
USA
001 800 248-4010 phone
001 517 764-6697 fax
e-mail: info@adcocorp.com
www.adcocorp.com

E-89000 - 0611