

## PRODUCT INFORMATION

# Körapur 672 NV



Two component reactive adhesive for bonding of certain materials such as PVC, PUR- and PS-foam, wood panel products of PVC hard, GRP, melamin-resin, steel and alu-sheets

- Suitable for the manufacturing of sandwich elements for the building industry and for the manufacture of vehicles and containers
- Low viscosity version

### TECHNICAL DATA

Base	Polyurethane, two-component, solvent free		
Hardener	<b>Köracur TH 650</b>		
Colour	Beige		
Consistency	Liquid, easily brushable		
Density			DIN EN ISO 28811 - 1
- resin	1.59	g/cm <sup>3</sup>	
- hardener	1.23	g/cm <sup>3</sup>	
- mix ratio	1.53	g/cm <sup>3</sup>	
Viscosity			Brookfield RVT
- resin	18.000	mPa*s	
- hardener	200	mPa*s	
- mix ratio	5.000	mPa*s	
Mixing ratio			
- resin : hardener	5 : 1	by weight	
- resin : hardener	3.9 : 1	by volume	
Pot life	40	min	Kö-Method 100172
Hardness Shore D	52		DIN ISO 7619
Shear strength	- 20°C: 20	MPa	DIN EN 1465
	+ 20°C: 7	MPa	
	+ 70°C: 2	MPa	
Tensile strength	6	MPa	DIN 53 504
Elongation at break	50	%	DIN 53 504
Consumption	250-300	g/m <sup>2</sup>	depending on substrate

# KÖRAPUR 672 NV

## PROCESSING

### Processing temperature

Do not apply at temperature below +15°C or above +25°C

### Preparation

The surfaces to be bonded must be clean, dry and free from dust and grease. We recommend that metal surfaces should be prepared by abrasion. Adhesion must be tested for compatibility by carrying out preliminary trials. Surfaces of GRP should be also prepared by abrasion. Thoroughly mix resin and hardener together (agitation 400 rpm) until an even colour is obtained.

### Bonding

Apply an even layer to the surfaces to be bonded using a spatula. We recommend mechanical fixing until the adhesive has attained full cure. When using **Körapur 672 NV** do not expose the bond to mechanical stress for at least 3 hours. Maximal bond strength is achieved after 24 hours. High temperature fasten the pot life, low temperature extend the pot life. Care should be taken that application is deposited on both substrates without entrapping air.

## CLEANING

### Körasolv PU

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

## SPECIAL NOTES

### Tools

spatula, roll or doctor blade

### Storage

Do not store below +10°C. When stored in unopened containers useable up to 12 months.

### Precaution

**Körapur 672 NV** is a skin, respiratory and eye irritant. Use of chemical resistant gloves are recommended. Hazardous fumes may form when the product is heated or sprayed. Follow the Bulletins issued by the Association of Mutual Industrial Accident Insurance Funds.

## 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

on request

## PRODUCT NUMBER

C44117

### 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.



**KÖMMERLING**

KÖMMERLING CHEMISCHE FABRIK GMBH

Zweibrücker Str. 200

D-66954 Pirmasens

Phone +49 6331 56-2000

Fax +49 6331 56-1999

eMail info@koe-chemie.de

Internet www.koe-chemie.de

