

PRODUCT INFORMATION

Körapur 840



Solvent free reactive adhesive for bonding metals, GRP, commonly used in the vehicle industry as well as in the industrial sector.

- For use as an assembly adhesive in the commercial motor vehicle industry
- non-sag properties at thin layers
- good adhesion to powder coated substrates
- good impact resistance
- Meets the requirements of the International Maritime Organization



TECHNICAL DATA

Base	Two-component polyurethane		
Colour	Beige		
Density			DIN 53479
- resin	1,55	g/cm ³	
- hardener TH 650	1,23	g/cm ³	
- hardener TH 724	1,25	g/cm ³	
- mixing	1,50	g/cm ³	
Viscosity			Kömmerring Method 100000, 23°C, Sp. 3/50 Upm
- resin		structural viscosity	
- hardener TH 650	300	mPa*s	
- hardener TH 724		structural viscosity	
- mixing	45 000	mPa*s	
Hardener	Köracur TH 650 or TH 724		
Mix ratio			
resin : hardener	4 : 1	by volume	
	5 : 1	by weight	
Pot life	2/8/10/15/20/45	min at +20°C	Kö-Method 100 178
Shore D hardness	65	at +23°C (3-sec-value) after 7 d 23°C/50% rel. Humidity	DIN 53 505
Elongation at tear	40	% at +23°C	DIN 53 504
Tensile strength	12	N/mm ² at +23°C	DIN 53 504

KÖRAPUR 840

PROCESSING

Processing temperature

+15°C to +25°C

Preparation

The surfaces must be clean, dry and free of dust and grease. Metals must normally be pretreated and possibly sanded.

Bonding

Care should be taken that application is deposited on both substrates. Avoid entrapping air.

Apply adhesive evenly to the surfaces using a spatula or gun and join them within pot life.

The thickness of the adhesive layer depends on the properties of the materials. (200 – 500 g/m²).

Typ	Loading capacity
840/02	15 - 20 min
840/08	40 - 60 min
840/10	50 - 70 min
840/12	70 - 90 min
840/15	80 - 100 min
840/20	2,5 - 3 h
840/45	6 - 8 h

Final bond strength is reached after 24 hours.

High temperature shorten the curing time and low temperature extend the curing time.

CLEANING

Körasolv PU

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

SPECIAL NOTES

Tools

Gun applicable for tandem- and mixing-cartridges, toothed spatula

Storage

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

Precautions

When processing **Körapur 840** avoid direct skin contact with the uncured adhesive. Wear protective gloves. Users should always refer to the Central Association of Mutual Industrial Accident Insurance Funds when processing PUR-coated materials.

IMO requirements

Meets the requirements of the International Maritime Organization up to a coating weight of 200 g/m².

SAFETY

Prior to application it is highly recommended to read our Safety Data Sheet containing health, safe handling, storage, disposal of chemical products and other safety related data.

Please also refer to the safety recommendations on the label before using the product.

Especially the directions of the Dangerous Substances Regulation should be carefully observed.

PACKAGING UNITS

360 g mixing cartridge
540 g tandem cartridge
5 kg bucket
300 kg drum

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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