



Körapop 330

General Properties	Technology/Base	Silane-modified polymer
	Type of Product	Adhesive and sealant
	Curing	Moisture curing
	Mechanical Properties	Elastic
	Parts	One part system
	Colour	Black, white, grey
	Product Benefits	Good resistance to humidity, weathering and temperatures High green strength

Typical Technical Data

General

Physical Properties		
Density	1.6 g/cm ³	Kö-test method 100031
Solid-content by weight	100%	
Processing Guidelines and Parameters		
Storage Temperature	5 °C to 25 °C	
Processing Temperature	5 °C to 30 °C	
Required Squeezing Pressure	2 bar to 5 bar	
Recommended Minimum Layer Thickness	2 mm	
Curing		
Skin Formation Time	10 min	Kö-test method 100109, Climate according to DIN 50014
Curing to Depth	3 mm/d	within first 24 h; Climate according to DIN 50014
Cured Material Characteristics		
Shore Hardness (Type A)	58	DIN ISO 7619-1, after 28 d; thickness of specimen = 6 mm
Tensile Strength	2.3 MPa	DIN EN ISO 527
Elongation at Break	200%	DIN EN ISO 527
Lap Shear Strength	1.3 MPa	DIN EN 1465, substrates: aluminium/aluminium
Service Conditions		
Service Temperature	-40 °C to 80 °C	
Short-term temperature resistance	120 °C	60 min



Product Properties

Applications	Fields of Application	Automotive Construction Industrial assembly Transportation
Processing	Suitable Substrates	Various galvanized steels Various aluminium alloys Various steel alloys Duroplastics Thermoplastics (except PE, PP, PTFE) Various composite materials (e.g. CFRP, GFRP) Glass Mineralic materials Wood Coated surfaces
	Consistency	Non-sagging Pasty
	Surface Requirements	Clean Free of grease Free of dust
	Surface Cleaning	Körasolv GL Körasolv PU Körasolv WL
	Adhesion Promoter (absorbing surface)	Körabond HG 74 E
	Application Equipment	Cartridge dispenser Sachet dispenser Dispensing system
Cleaning	Cleaner for Tools	Körasolv GL Körasolv PU
Hints	Resistance against UV Radiation	Not suitable for glass bonding with permanent UV radiation to the bonding area. Please ask your local sales office for products suitable for such applications.
	Stress Cracking	Preliminary tests must be carried out on plastics with a tendency to stress cracking. (PMMA, ABS, PC or PS)
	Compatibility with Polystyrene Foams	Not suitable for bonding polystyrene foams. Please ask your local sales office for products suitable for such applications.



Additional Information

Storage

Körapop 330 should be used within the shelf life specified on the packaging. The storage stability applies to material stored under appropriate conditions only (original unopened containers, recommended storage temperature).

Safety

Please read our Safety Data Sheet (SDS) and the labels of each product before use. The valid safety regulations must be considered.

Preparation

For some substrates the use of mechanical pre-treatment and/or cleaner or primer is necessary to achieve good adhesion. Refer to the product properties section of this data sheet for special surface requirements and suitable adhesion promoters.

Processing

Refer to the technical data table regarding processing parameters. Low temperatures can cause a temporary increase in viscosity resulting in reduced extrusion and slower curing rates.

Cleaning

Clean tools immediately after use. Once cured, the material can only be removed mechanically. Appropriate cleaners are listed in the product properties table. For further information please contact your local sales office.

Dimensioning

The required thickness of the adhesive layer depends on the expected maximum strength and joint movement. We recommend a minimum layer thickness of 2 mm.

Disposal

Please refer to the Safety Data Sheet (SDS) for appropriate disposal instructions.

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