

# Körapur 672 S

|                           |                       |   |
|---------------------------|-----------------------|---|
| <b>General Properties</b> | Technology/Base       | Polyurethane (PU)   |
|                           | Type of Product       | Adhesive  |
|                           | Curing                | Polyaddition curing   |
|                           | Mechanical Properties | Structural  |
|                           | Parts                 | Two part system   |
|                           | Part A (Resin)        | Körapur 672 S   |
|                           | Part B (Hardener)     | Köracur TH 650  |
|                           | Colour                | Beige   |
|                           | Product Benefits      | Improved humidity resistance<br>No significant shrinkage<br>Wide range of pot life profiles available |



## Typical Technical Data

### Part A Körapur 672 S

|   |                        |                       |
|---|------------------------|-----------------------|
| <b>Physical Properties</b>                  |                        |                       |
| Density                                     | 1.66 g/cm <sup>3</sup> | DIN EN 542            |
| Colour                                      | beige                  |                       |
| <b>Processing Guidelines and Parameters</b> |                        |                       |
| Storage Temperature                         | 15 °C to 25 °C         |                       |
| Viscosity                                   | 35,000 mPa·s           | Kö-test method 100000 |

### Part B Köracur TH 650

|   |                        |                       |
|---|------------------------|-----------------------|
| <b>Physical Properties</b>                  |                        |                       |
| Density                                     | 1.23 g/cm <sup>3</sup> | DIN EN 542            |
| NCO content                                 | 31%                    |                       |
| Colour                                      | brown                  |                       |
| <b>Processing Guidelines and Parameters</b> |                        |                       |
| Storage Temperature                         | 10 °C to 25 °C         |                       |
| Viscosity                                   | 300 mPa·s              | Kö-test method 100000 |

## General

|   |                        |                       |
|---|------------------------|-----------------------|
| <b>Physical Properties</b>                  |                        |                       |
| Density                                     | 1.57 g/cm <sup>3</sup> | DIN EN 542            |
| Glass Transition Temperature                | 40 °C                  | DIN EN ISO 6721-1     |
| <b>Processing Guidelines and Parameters</b> |                        |                       |
| Mixing Ratio (Part A : Part B) by Weight    | 5.0 : 1.0              |                       |
| Mixing Ratio (Part A : Part B) by Volume    | 3.7 : 1.0              |                       |
| Processing Temperature                      | 15 °C to 25 °C         |                       |
| Viscosity                                   | 10,000 mPa·s           | Kö-test method 100003 |



|   |  |   |
|---|--|---|
| <b>Curing</b><br>Potlife  | 60 min, 55 min,<br>45 min, 35 min,<br>20 min, 10 min,<br>4 min | Kö-test method 100178   |
| <b>Cured Material Characteristics</b><br>Shore Hardness (Type D)<br>Tensile Strength<br>Elongation at Break<br>G <sub>10</sub> -Modulus<br>Lap Shear Strength<br>Lap Shear Strength | 55<br>11 MPa<br>30%<br>30 MPa<br>8 MPa<br>12 MPa               | DIN EN ISO 868<br>DIN EN ISO 527<br>DIN EN ISO 527<br>DIN EN 14869-2<br>DIN EN 14869-2, substrates:<br>aluminium/aluminium<br>DIN EN 1465, substrates:<br>aluminium/aluminium |
| <b>Service Conditions</b><br>Service Temperature<br>Short-term temperature resistance   | -160 °C to 90 °C<br>120 °C                                     | min. 60 min   |

**Product Properties**

|                       |   |   |
|-----------------------|---|---|
| <b>Applications</b>   | Fields of Application                         | Automotive<br>Construction<br>Industrial assembly<br>Transportation   |
|                       | Typical Applications                          | Sandwich assemblies   |
| <b>Processing</b>     | Suitable Substrates                           | Polystyrene-rigid foam (EPS)<br>Various aluminium alloys<br>Various steel alloys<br>Polyurethane (PUR)<br>Polyvinyl chloride (PVC)<br>Various composite materials (e.g. CFRP, GFRP)<br>Wood<br>Various other substrates |
|                       | Consistency                                   | Pourable  |
|                       | Surface Requirements                          | Dry<br>Clean<br>Free of grease<br>Free of dust  |
|                       | Application Equipment                         | Two part mixing and metering system   |
|                       | Product is free of                            | Solvents<br>Plasticizers  |
| <b>Cleaning</b>       | Cleaner for Tools                             | Körasolv PU   |
| <b>Certifications</b> | Certifications and Declarations of Conformity | Meets the requirements of the International Maritime Organisation (IMO)   |
| <b>Hints</b>          | Moisture Sensitivity                          | The adhesive must not be exposed to moisture before and during application. Moisture causes foaming leading to lower mechanical properties.   |



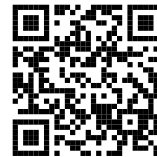
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Additional Information

Storage

Körapur 672 S 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.

Disposal

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

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