



# Körapur 840

<b>General Properties</b>	Technology/Base	Polyurethane (PU)
	Type of Product	Adhesive
	Curing	Polyaddition curing
	Mechanical Properties	Semi-structural
	Parts	Two part system
	Part A (Resin)	Körapur 840
	Part B (Hardener)	Köracur TH 650 Köracur TH 724
	Colour	Beige
	Product Benefits	High impact strength No significant shrinkage Wide range of pot life profiles available



## Typical Technical Data

### Part A Körapur 840

<b>Physical Properties</b> Density Colour	1.55 g/cm <sup>3</sup> beige	DIN EN 542
<b>Processing Guidelines and Parameters</b> Storage Temperature Viscosity	15 °C to 25 °C 420,000 mPa·s	Kö-test method 100000

### Part B Köracur TH 650

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

### Part B Köracur TH 724

<b>Physical Properties</b> Density Colour	1.25 g/cm <sup>3</sup> brown	DIN EN 542
<b>Processing Guidelines and Parameters</b> Storage Temperature Viscosity	15 °C to 25 °C 70,000 mPa·s	Kö-test method 100000



**General**

<b>Physical Properties</b>		
Density	1.50 g/cm <sup>3</sup>	DIN EN 542
Glass Transition Temperature	30 °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	4.0 : 1.0	
Processing Temperature	15 °C to 25 °C	
Viscosity	45,000 mPa·s	Kö-test method 100003, Köracur TH 650
<b>Curing</b>		
Potlife	2 min, 8 min, 10 min, 12 min, 15 min, 20 min, 45 min	Kö-test method 100178
<b>Cured Material Characteristics</b>		
Shore Hardness (Type D)	56	DIN EN ISO 868
Tensile Strength	12 MPa	DIN EN ISO 527
Elongation at Break	30%	DIN EN ISO 527
G <sub>10</sub> -Modulus	80 MPa	DIN EN 14869-2
Lap Shear Strength	18 MPa	DIN EN 14869-2, substrates: aluminium/aluminium
<b>Service Conditions</b>		
Service Temperature	-160 °C to 90 °C	
Short-term temperature resistance	120 °C	min. 60 min



**Product Properties**

<b>Applications</b>	Fields of Application	Automotive Construction Industrial assembly Transportation
	Typical Applications	Side wall, floor and roof assemblies for trailer constructions Sandwich assemblies
<b>Processing</b>	Suitable Substrates	Various aluminium alloys Various steel alloys Various composite materials (e.g. CFRP, GFRP) Wood Coated surfaces Various other substrates
	Consistency	Non-sagging Pasty
	Surface Requirements	Dry Clean Free of grease Free of dust
	Application Method	Using side-by-side cartridge with static mixer Using mixing cartridge
	Application Equipment	Two part mixing and metering system
	Product is free of	Solvents 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 840 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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