Körapur 115

General Properties	Technology/Base	Polyurethane (PU)
	Type of Product	Adhesive and sealant
	Curing	Moisture curing
	Mechanical Properties	Elastic
	Parts	One part system
	Colour	Black, white, grey
	Product Benefits	High cold resistance High heat resistance Excellent moisture resistance Excellent weather resistance

Typical Technical Data

General

Physical Properties		
Density	1.2 g/cm^3	Kö-test method 100031
Solid-content by weight	92%	Kö-test method 100035
Glass Transition Temperature	-50 °C	DIN EN ISO 6721-1
Specific Volume Resistance	> 1 · 10^{10} Ω·cm	Kö-test method 100262
Processing Guidelines and Parameters		
Storage Temperature	5 °C to 25 °C	
Processing Temperature	5 °C to 35 °C	
Required Squeezing Pressure	2 bar to 5 bar	
Recommended Minimum Layer Thickness	2 mm	
Curing		
Skin Formation Time	45 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
Change in Volume	-7%	DIN EN ISO 10563
Cured Material Characteristics		
Shore Hardness (Type A)	50	DIN ISO 7619-1, after 28 d; thickness of specimen = 6 mm
Tensile Strength	1.4 MPa	DIN EN ISO 527
Elongation at Break	400%	DIN EN ISO 527
Tear Strength	8 N/mm	DIN ISO 34-1 Type B
Service Conditions		
Service Temperature	-40 °C to 90 °C	
Short-term temperature resistance	120 °C	60 min

Product Properties

Applications	Fields of Application	Automotive Industrial assembly Transportation
Processing	Suitable Substrates	Various galvanized steels Various aluminium alloys Various steel alloys Duroplastics Mineralic materials Wood Coated surfaces
	Consistency	Non-sagging Pasty
	Surface Requirements	Dry Clean Free of grease
	Surface Cleaning	Körasolv PU Körasolv WL
	Adhesion Promoter (absorbing surface)	Körabond HG 74 E
	Adhesion Promoter (non absorbing surface)	Körabond HG 81
	Application Equipment	Cartridge dispenser Sachet dispenser Dispensing system
	Product Overpaintability	After skin formation (depending on paint)
Cleaning	Cleaner for Tools	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.
	Avoid Contact with Isocyanate Reactive Substances	Avoid direct contact with isocyanate reactive substances, especially alcohol such as spirit, dilutions, cleaning compounds and fission products of silane-modified polymers or silicones until the adhesive has attained full cure. This will prevent the adhesive from curing properly.

Additional Information

Storage

Körapur 115 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 pretreatment 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.

Kömmerling Chemische Fabrik GmbH
Zweibrücker Straße 200 - 66954 Pirmasens - Germany
Tel.: +49 6331 56-2000
Fax: +49 6331 56-1999
www.koe-chemie.de
info@koe-chemie.de