Körapur 842

General Properties	Technology/Base	polyurethane
	Type of Product	adhesive
	Curing	polyaddition curing
	Mechanical Properties	semi-structural
	Parts	two part system
	Part A (Resin)	Körapur 842
	Part B (Hardener)	Köracur TH 650
	Color	beige
	Product Benefits	high flexibility even at low temperatures high impact strength no significant shrinkage wide range of pot life profiles available

Technical Data

Part A Körapur 842

Physical Properties		
Density	1.50 g/cm^3	DIN EN 542
Color	beige	
Processing Guidelines and Parameters		
Storage Temperature	15 °C to 25 °C	

Part B Köracur TH 650

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

General

Physical Properties		
Density	1.46 g/cm^3	DIN EN 542
Glass Transition Temperature	35 °C	DIN EN ISO 6721-1
Processing Guidelines and Parameters		
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	65,000 mPa·s	Kö-test method 100003
Curing		
Potlife	8 min, 20 min, 65 min	Kö-test method 100172

Cured Material Characteristics		
Shore Hardness (Type D)	45	ISO 868 / DIN 53 505
Tensile Strength	8 MPa	DIN EN ISO 527
Elongation at Break	40 %	DIN EN ISO 527
Lap Shear Strength	9 MPa	DIN EN 14869-2, substrates: aluminum/aluminum
G_{10}-Modulus	40 MPa	DIN EN 14869-2
Service Conditions		
Service Temperature	-160 °C to 90 °C	
Short-term temperature resistance (max. 1 h)	120 °C	

Product Properties

Applications	Fields of Application	automotive construction industrial assembly transportation
	Special Applications	side wall, floor and roof assemblies for trailer constructions sandwich assemblies
Processing	Suitable Substrates	various aluminum alloys various steel alloys various composite materials (e.g. CFRP, GFRP) wood various other substrates
	Consistency	non-sagging pasty
	Surface Requirements	dry clean free of grease free of dust
	Application Method	via two part mixing and metering systems using mixing cartridge
	Product is free of	solvents plasticizers
Cleaning	Cleaner for Tools	Körasolv PU
Hints	Moisture Sensitivity	The adhesive must not be exposed to moisture before and during application. Moisture causes foaming leading to lower mechanical properties.

Additional Information

Storage

Körapur 842 should be used within the shelf life specified on the packaging. The storage stability only applies to material stored under appropriate conditions (original unopened containers, recommended storage temperature).

Safety

Please read our material safety data sheet 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.

Disposal

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

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