

# Körapur 784



KÖMMERLING CHEMISCHE FABRIK GMBH

## Two component reaction adhesive for the building and automotive industry

- Different pot life versions
- For bonding ABS, rigid PVC, GRP, steel and aluminium

### TECHNICAL DATA

Base	Polyurethane, two component, solvent-free		
Colour	Component A: black Component B: yellow-white		
Density			DIN 53 479
- component A	1,2	g/cm <sup>3</sup> ( <b>Körapur 784</b> )	
- component B	1,6	g/cm <sup>3</sup> ( <b>Köracur TH 715</b> )	
Viscosity			Brookfield RVT
- component A	40 000	mPa•s	
- component B	20 000	mPa•s	
Mixing ratio	A : B	1 : 1,3	by weight
	A : B	1 : 1	by volume
Hardener	<b>Köracur TH 715</b>		
Pot life	5/1	min depending on A-component (see chart below)	
Shear Strength	13	N/mm <sup>2</sup>	
Hardness Shore D	65	DIN 53 505	

### PROCESSING

#### Processing temperature

+15°C to +25°C

#### Preparation

The surfaces must be clean, dry and free of grease. Metals must normally be pretreated and possibly sanded. Surfaces of glass fibre-reinforced plastics must also be sanded.

Resin and hardener must be thoroughly mixed with a stirrer (approx. 400 revs/min) until the mixture shows a uniform colour.

Prepare tandem cartridge as instructed.

#### Bonding

Apply adhesive evenly with a spatula or a doctor blade to the surfaces and join them.

The thickness of the adhesive layer depends on the properties of the materials to be bonded.

By different A-components, the pot life and the bond strengths can be varied. When using **Körapur 784**, the bond can be exposed to light strain after 12 hours. Final bond strength is reached after 24 hours.

High temperatures will shorten the curing time, low temperatures will lengthen it.

A-component	Pot life	Handling time after
Körapur 784/5	5 minutes	1-2 hours
Körapur 784/1	1 minute	15 minutes

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## CLEANING

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### Körasolv PU.

Clean tools immediately after use. Cured adhesive can only be removed mechanically.

## SPECIAL NOTES

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### Storage

Do not store below +10°C and for more than 12 months.

### Precautions

When processing **Körapur 784** avoid direct skin contact with the uncured adhesive. Wear protective gloves. Hazardous fumes may form when the product is heated or sprayed.

## SAFETY

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Please read our Safety-Data-Sheet and the labels of each product before use.

Pay particular attention to the directions given in the Dangerous Substance Regulations.

Make sure the safety data sheet is readily available as it gives valuable information regarding the safe usage and disposal of the product and what to do in the event of an accident involving the product.

## PACKAGING UNITS

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50 ml Tandem cartridge (2 pieces per packaging unit) with static mixer

400 ml Tandem cartridge with static mixer

more packaging on requests

**For safety related data please refer to the safety data sheet!**

**Please note:** All given data are based on careful examination in our laboratories and our past practical experience. These are non-binding indications. Given the high number of materials appearing on the market and the different methods of use which are beyond our influence and control, we naturally cannot accept any responsibility for the results of your work, also with regard to third party patent rights. We recommend that sufficiently thorough tests be carried out to ascertain whether the product described will meet the requirements of your particular case. Please also note our Terms of Sale, Delivery and Payment. This product information replaces all previous issues.



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