



Körapur 840

General Properties	Technology/Base	polyurethane
	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
	Color	beige
	Product Benefits	high impact strength no significant shrinkage wide range of pot life profiles available

Technical Data

Part A Körapur 840

Physical Properties		
Density	1.6 g/cm ³	DIN EN 542
Color	beige	
Processing Guidelines and Parameters		
Storage Temperature	15 °C to 25 °C	
Viscosity	420,000 mPa·s	Kö-test method 100000

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

Part B Köracur TH 724

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



General

Physical Properties		
Density	1.5 g/cm ³	DIN EN 542
Glass Transition Temperature	30 °C	DIN EN ISO 6721-1
Processing Guidelines and Parameters		
Mixing Ratio (Part A : Part B) by Weight	5.0 : 1	
Mixing Ratio (Part A : Part B) by Volume	4.0 : 1	
Processing Temperature	15 °C to 25 °C	
Viscosity	45,000 mPa·s	Kö-test method 100003, Köracur TH 650
Curing		
Potlife	2 min, 8 min, 10 min, 12 min, 15 min, 20 min, 45 min	Kö-test method 100178
Cured Material Characteristics		
Shore Hardness (Type D)	65	ISO 868 / DIN ISO 7619-1
Tensile Strength	12 MPa	DIN EN ISO 527
Elongation at Break	30%	DIN EN ISO 527
G ₁₀ -Modulus	80 MPa	DIN EN 14869-2
Lap Shear Strength	18 MPa	DIN EN 14869-2, substrates: aluminum/aluminum
Service Conditions		
Service Temperature	-160 °C to 90 °C	
Short-term temperature resistance	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 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 via two part mixing and metering systems using mixing cartridge
	Product is free of	solvents plasticizers
Cleaning	Cleaner for Tools	Körasolv PU
Certifications	Certifications and Declarations of Conformity	meets the requirements of the International Maritime Organisation (IMO)
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 840 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 (MSDS) 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 Material Safety Data Sheet (MSDS) for appropriate disposal instructions.

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