

## PRODUCT INFORMATION

# Körapur 135



**One component elastic adhesive and sealant, for the manufacture of vehicles body work, containers, metalwork, etc.**

- For primed and varnished metals, aluminium, wooden materials and duroplastics
- Overpaintable after curing
- Good adhesion to a wide range of substrates
- Low sagging and high extrusion rates
- Good resistance to humidity and weathering.
- Temperature resistant from -40°C to +90°C (up to +120°C for short intervals)

## TECHNICAL DATA

Base	One component polyurethane, curing by reaction with moisture		
Colour	White, grey ( further colours on request)		
Density	1.4	g/cm <sup>3</sup>	
Viscosity	Paste, spreadable, non-sag properties		
Time for skin formation	45	min	
Curing	3	mm (on the first day)	DIN 50 014 / NC 23/50-2 DIN 50 014 / NC 23/50-2 DIN 52 451
Change in volume	3	%	DIN 53 505
Hardness Shore A	45		DIN 53 504
Elongation at tear	650	%	DIN 53 504
Tensile strength	3.0	N/mm <sup>2</sup>	DIN 53 515
Tear propagation strength	11	N/mm	

## PROCESSING

### Processing temperature

+5°C to +35°C

### Preparation

The surfaces to be bonded must be clean, dry and free from dust and grease. For cleaning we recommend **Körasolv PU**. In the case of powder coated substrates, **Körasolv WL** should be used.

To increase bond strength of non-porous substrates such as glass, glass-fibre reinforced plastics, aluminium, stainless steel, etc. we recommend the use of **Körabond HG 81**. For porous substrates such as wood, **Körabond HG 74 E** is recommended.

For certain plastics such as ABS or PVC we recommend the use of **Körabond HG 77**.

Due to the diversity of substrates, preliminary tests are recommended.

As a tooling agent we recommend **Köratool AM 10**.

**Körapur 135** can be overpainted after skin formation. Adhesion and compatibility must be tested by preliminary trials. Please consider that the brittleness of the paint film may limit the elastic movement of the sealant and may lead to cracking of the paint. Thus, the curing reaction proceeds slower under the paint film.

Avoid direct contact with isocyanate reactive substances, especially alcohol such as spirit, dilutions and cleaning compounds until the adhesive has attained full cure. This will prevent the adhesive from curing properly.

By direct or indirect contact with some other organic products preliminary tests are recommended.

# KÖRAPUR 135

## BONDING

The thickness of the layer depends on the expected mechanical movement. Join the materials to be bonded within the skin formation time. Due to the low initial tack we recommend mechanical fixing until a complete cure is obtained. The cure time is dependent on temperature, humidity and the dimensions of the joint.

## CLEANING

### Körasolv PU

Clean tools immediately after use.

Once cured material can only be removed mechanically.

## SPECIAL NOTES

### Storage

Do not store at temperatures above +25 °C.

Cartridges and sachets: 12 months

### Tools

Spatula or gun

### Precautions

When processing **Körapur 135**, avoid direct skin contact with the uncured material. Use of safety gloves is recommended.

## SAFETY

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

300 ml cartridge (carton à 12 pcs.)

600 ml cartridge (carton à 12 pcs.)



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**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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DIN EN ISO 9001:2000  
Zertifikat: 01 100 044853  
ISO 14001:2004  
Zertifikat: 01 104 053913  
OHSAS 18001:1999  
Zertifikat: QA 05 116 4030