



# Körapur 116

|                           |                       |   |
|---------------------------|-----------------------|---|
| <b>General Properties</b> | Technology/Base       | polyurethane  |
|                           | Type of Product       | adhesive and sealant  |
|                           | Curing                | moisture curing   |
|                           | Mechanical Properties | elastic   |
|                           | Parts                 | one part system   |
|                           | Color                 | black, white, grey  |
|                           | Product Benefits      | high cold resistance<br>high heat resistance<br>excellent moisture resistance<br>excellent weather resistance |

## Technical Data

### General

|   |                       |  |
|---|-----------------------|--|
| <b>Physical Properties</b>                  |                       |  |
| Density                                     | 1.4 g/cm <sup>3</sup> |  |
| <b>Processing Guidelines and Parameters</b> |                       |  |
| 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                  |  |
| <b>Curing</b>                               |                       |  |
| Skin Formation Time                         | 40 min                | Kö-test method 100109, Climate according to DIN 50 014   |
| Curing to Depth                             | 3 mm/d                | within first 24 h; Climate according to DIN 50 014       |
| Change in Volume                            | -6%                   | DIN EN ISO 10563   |
| <b>Cured Material Characteristics</b>       |                       |  |
| Shore Hardness (Type A)                     | 50                    | DIN ISO 7619-1, after 28 d; thickness of specimen = 6 mm |
| Tensile Strength                            | 2.5 MPa               | DIN EN ISO 527   |
| Elongation at Break                         | 650%                  | DIN EN ISO 527   |
| Tear Strength                               | 11 N/mm               | ISO 34-1   |
| <b>Service Conditions</b>                   |                       |  |
| Service Temperature                         | -40 °C to 90 °C       |  |
| Short-term temperature resistance           | 120 °C                | 60 min   |



**Product Properties**

|                     |   |  |
|---------------------|---|--|
| <b>Applications</b> | Fields of Application                             | automotive<br>industrial assembly<br>transportation  |
| <b>Processing</b>   | Suitable Substrates                               | various galvanized steels<br>various aluminum alloys<br>various steel alloys<br>duroplastics<br>mineralic materials<br>wood<br>coated surfaces   |
|                     | Consistency                                       | non-sagging<br>pasty   |
|                     | Surface Requirements                              | dry<br>clean<br>free of grease   |
|                     | Surface Cleaning                                  | Körasolv PU<br>Körasolv WL   |
|                     | Adhesion Promoter (absorbing surface)             | Körabond HG 74 E   |
|                     | Adhesion Promoter (non absorbing surface)         | Körabond HG 81   |
|                     | Application Method                                | cartridge dispenser<br>sachet dispenser<br>dispensing system   |
|                     | Product Overpaintability                          | after skin formation (depending on paint)  |
| <b>Cleaning</b>     | Cleaner for Tools                                 | Körasolv PU  |
| <b>Hints</b>        | 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 116 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.

### 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 Material Safety Data Sheet (MSDS) for appropriate disposal instructions.

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