

Technical data sheet



Product: 666

Manufacturer: H.B. FULLER

Product group: KLEBSTOFF

Article group: 2-K KLEBSTOFF

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KÖRAPUR 666

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Körapur 666

General Properties	Technology/Base	polyurethane
	Type of Product	adhesive
	Curing	polyaddition curing
	Mechanical Properties	structural
	Parts	two part system
	Part A (Resin)	Körapur 666
	Part B (Hardener)	Köracur TH 650
	Color	beige
	Product Benefits	improved humidity resistance high mechanical properties flexible use in various applications no significant shrinkage wide range of pot life profiles available

Technical Data

Part A

Physical Properties		
Density	1.70 g/cm ³	DIN EN 542
Color	beige	
Processing Guidelines and Parameters		
Storage Temperature	15 °C to 25 °C	
Viscosity	5,000,000 mPa·s	Kö-test method 100000

Part B Köracur TH 650

Physical Properties		
Density	1.23 g/cm ³	DIN EN 542
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	1.60 g/cm ³	DIN EN 542
Glass Transition Temperature	50 °C	DIN EN ISO 6721-1
Processing Guidelines and Parameters		
Mixing Ratio (Part A : Part B) by Weight	6.0 : 1.0	
Mixing Ratio (Part A : Part B) by Volume	4.5 : 1.0	
Processing Temperature	15 °C to 25 °C	
Viscosity	55,000 mPa·s	Kö-test method 100003



Curing Potlife	90 min, 60 min, 45 min, 30 min, 25 min, 20 min, 18 min, 10 min, 8 min, 5 min, 3 min	Kö-test method 100178
Cured Mechanical Properties Shore Hardness (Type D) Tensile Strength Elongation at Break Lap Shear Strength G ₁₀ -Modulus	70 15 MPa 3 % 17 MPa 140 MPa	ISO 868 / DIN 53 505 DIN EN ISO 527 DIN EN ISO 527 DIN EN 14869-2, substrates: aluminum/aluminum DIN EN 14869-2
Service Conditions Service Temperature Short-term temperature resistance (max. 1 h)	-160 °C to 90 °C 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	polystyrene-rigid foam (EPS) various aluminum alloys various steel alloys polyurethane (PUR) polyvinyl chloride (PVC) various composite materials (e.g. CFRP, GFRP) wood various other substrates
	Consistency (Part B Köracur TH 650)	liquid
	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	plasticizers solvents
Cleaning	Cleaner for Tools (Part B Köracur TH 650)	Körasolv PU
	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 666 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 refer to the Material Safety Data Sheet (MSDS) for safety advice.

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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