

# Technical data sheet



Product: 125

Manufacturer: H.B. FULLER

Product group: KLEBSTOFF

Article group: 1-K KLEBSTOFF

Download: 05.05.2024

## KÖRAPUR 125

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# Körapur 125



**One component elastic adhesive and sealant, for the manufacture of vehicle 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
- 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, black and brown (further colours on request)		
Viscosity	Paste, spreadable, non-sag properties		
Density	approx. 1.2	g/cm <sup>3</sup> (depending on colour)	DIN EN ISO 1183-1 <sup>1)</sup>
Time for skin formation	45	min	<sup>1)</sup>
Curing	3	mm (on the first day)	<sup>1)</sup>
Change in volume	6	%	DIN 52 451
Hardness Shore A	48		ISO 868 / DIN 53 505
Elongation at tear	500	%	ISO 527 / DIN 53 504
Tensile strength	2	N/mm <sup>2</sup>	ISO 527 / DIN 53 504
Tear propagation strength	9	N/mm	ISO 34 / DIN 53 515
<sup>1)</sup> Normal Clima 23/50-2 DIN 50014			

## PROCESSING

### Processing temperature

+15°C to +35°C

Temper **Körapur 125** on at least +15°C before processing.

### 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 125** can be overpainted after skin formation. Adhesion must be tested for compatibility by carrying out preliminary trials. Please consider that the hardness and film thickness may impair elasticity of the sealant. Thus, the curing reaction proceeds slower and may lead to cracking of the paint.

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 125

## 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.

Drums and hobboscks: 9 months

Cartridges and sachets: 12 months

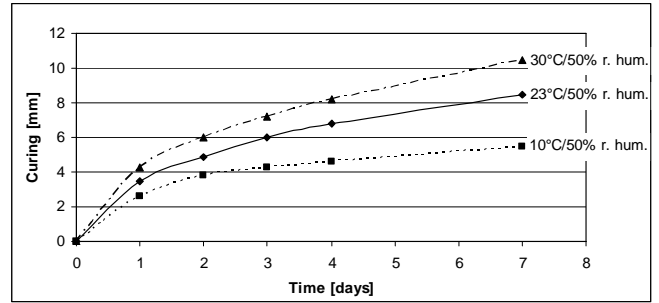
### Tools

spatula or gun

### Precautions

When processing **Körapur 125**, avoid direct skin contact with the uncured material. Use of safety gloves is recommended.

Curing time on exposure to air humidity (50% r.h.) at different temperatures:



## 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

23 kg hobbock

230 kg drum

300 ml aluminium cartridge (carton à 12 pcs.)

300 ml sachet (carton à 15 pcs.)

600 ml sachet (carton à 12 pcs.)

**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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