

# Technical data sheet



Product: 240

Manufacturer: H.B. FULLER

Product group: KLEBSTOFF

Article group: 2-K KLEBSTOFF

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## KÖRAPOP 240-2K

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# Körapop 240-2K

<b>General Properties</b>	Technology/Base	silane-modified polymer
	Type of Product	adhesive and sealant
	Curing	polycondensation curing
	Mechanical Properties	elastic
	Parts	two part system
	Part A	Körapop 240
	Part B	Köracur 310 N Köracur 310 L Köracur 310 SL
	Color	black, white, grey
	Product Benefits	high cold resistance high heat resistance excellent moisture resistance excellent weather resistance cures also as one-component adhesive with humidity

## Technical Data

### Part A Körapop 240

<b>Physical Properties</b>		
Density	1.4 g/cm <sup>3</sup>	DIN EN 542
Solid-content by weight	100%	
<b>Processing Guidelines and Parameters</b>		
Storage Temperature	5 °C to 25 °C	

### Part B Köracur 310 N

<b>Physical Properties</b>		
Density	1.49 g/cm <sup>3</sup>	DIN EN 542
<b>Processing Guidelines and Parameters</b>		
Storage Temperature	15 °C to 25 °C	

### Part B Köracur 310 L

<b>Physical Properties</b>		
Density	1.49 g/cm <sup>3</sup>	DIN EN 542
<b>Processing Guidelines and Parameters</b>		
Storage Temperature	15 °C to 25 °C	

### Part B Köracur 310 SL

<b>Physical Properties</b>		
Density	1.49 g/cm <sup>3</sup>	DIN EN 542
<b>Processing Guidelines and Parameters</b>		
Storage Temperature	15 °C to 25 °C	

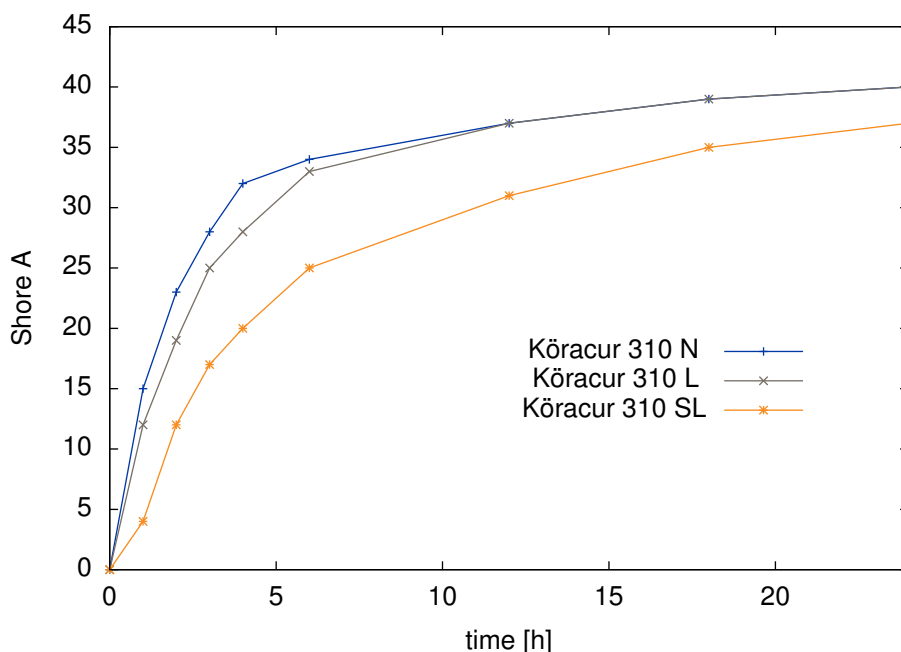


Figure 1: curing of Körapop 240-2K with different boosters, build up of Shore A

## General

<b>Physical Properties</b>		
Glass Transition Temperature	-64 °C	DIN EN ISO 6721-1
<b>Processing Guidelines and Parameters</b>		
Mixing Ratio (Part A : Part B) by Volume	10 : 1	
Processing Temperature	5 °C to 35 °C	
Recommended Minimum Layer Thickness	2 mm	
<b>Curing</b>		
Potlife	10 min	with Köracur 310 N
Potlife	16 min	with Köracur 310 L
Potlife	26 min	with Köracur 310 SL
Change in Volume	-3%	DIN EN ISO 10563
<b>Cured Material Characteristics</b>		
Shore Hardness (Type A)	54	DIN ISO 7619-1, after 14 d
Tensile Strength	2.8 MPa	DIN EN ISO 527
Elongation at Break	350%	DIN EN ISO 527
Lap Shear Strength	3.0 MPa	DIN EN 1465, substrates: aluminum/aluminum
Tear Strength	20 N/mm	ASTM D624
<b>Service Conditions</b>		
Service Temperature	-60 °C to 90 °C	
Short-term temperature resistance	150 °C	60 min



## Product Properties

<b>Applications</b>	Fields of Application	automotive construction industrial assembly transportation
<b>Processing</b>	Suitable Substrates	various galvanized steels metals various aluminum alloys various steel alloys duroplastics thermoplastics (except PE, PP, PTFE) various composite materials (e.g. CFRP, GFRP) glass mineralic materials wood coated surfaces
	Consistency	non-sagging pasty
	Surface Requirements	clean free of grease
	Surface Cleaning	Körasolv GL Körasolv PU Körasolv WL
	Adhesion Promoter (absorbing surface)	Körabond HG 74 E
	Adhesion Promoter (non absorbing surface)	Körabond HG 83
	Application Method	using side-by-side cartridge with static mixer via two part mixing and metering systems
	Product Overpaintability	wet-in-wet (depending on paint)
	Product is free of	solvents
<b>Cleaning</b>	Cleaner for Tools	Körasolv GL 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.





## Additional Information

### Storage

Körapop 240-2K 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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