

Technical data sheet



Product: 225

Manufacturer: H.B. FULLER

Product group: KLEBSTOFF

Article group: 2-K KLEBSTOFF

Download: 04.05.2024

KÖRAPOP 225

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Körapop 225

General Properties	Technology/Base	silane-modified polymer
	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 high heat resistance excellent moisture resistance excellent weather resistance

Technical Data

General

Physical Properties		
Density	1.4 g/cm ³	
Solid-content by weight	100%	
Glass Transition Temperature	-55 °C	DIN EN ISO 6721-1
Specific Volume Resistance	$> 1 \cdot 10^{10} \Omega \cdot \text{cm}$	Kö-test method 100262
Processing Guidelines and Parameters		
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	
Curing		
Skin Formation Time	25 min	Kö-test method 100109, Climate according to DIN 50014
Curing to Depth	3 mm/d	within first 24 h; Climate according to DIN 50014
Change in Volume	-3%	DIN EN ISO 10563
Cured Material Characteristics		
Shore Hardness (Type A)	42	DIN ISO 7619-1, after 28 d; thickness of specimen = 6 mm
Young's Modulus at 100 % Elongation	0.8 MPa	DIN EN ISO 527 / DIN 53 504
Tensile Strength	2.8 MPa	DIN EN ISO 527
Elongation at Break	500%	DIN EN ISO 527
G ₁₀ -Modulus	1.0 MPa	DIN EN 1465
Lap Shear Strength	2.6 MPa	DIN EN 1465, substrates: aluminum/aluminum
Tear Strength	20 N/mm	ASTM D624
Service Conditions		
Service Temperature	-60 °C to 90 °C	
Short-term temperature resistance	120 °C	60 min



Product Properties

Applications	Fields of Application	automotive construction industrial assembly transportation
Processing	Suitable Substrates	various galvanized steels 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	cartridge dispenser sachet dispenser dispensing system
	Product Overpaintability	wet-in-wet (depending on paint)
	Product is free of	solvents
Cleaning	Cleaner for Tools	Körasolv GL Körasolv PU
Hints	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 225 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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