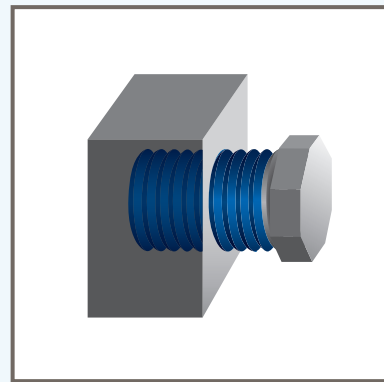


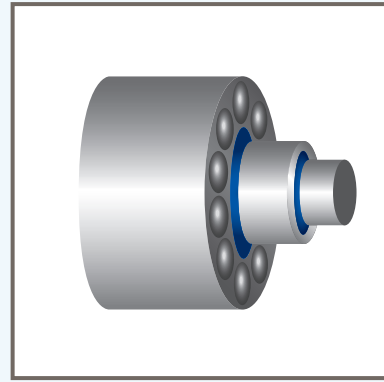
General Industry Product Application Guide

THREADLOCKING



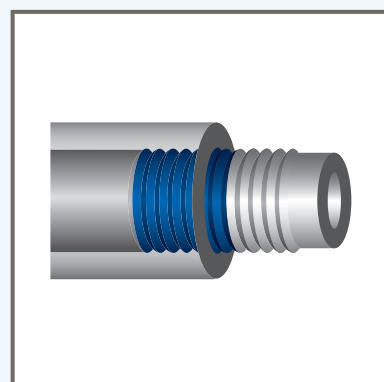
Required Strength	Product	Technology	Key Properties	Colour	Size of Thread	Temperature Resistance
Low	TM 11	Anaerobic Adhesive	Easy to dismantle thread locker, for precision screws.	Violet	M12	-50 to +150 °C
Medium	TM 44	Anaerobic Adhesive	Medium strength, thixotropic, for threaded joints which can be disassembled with standard hand tools. NSF P1 registered, potable water approval.	Blue	M20	-50 to +150 °C
High	TM 66	Anaerobic Adhesive	Solvent free, high strength, medium open time.	Green	M20	-50 to +150 °C

RETAINING



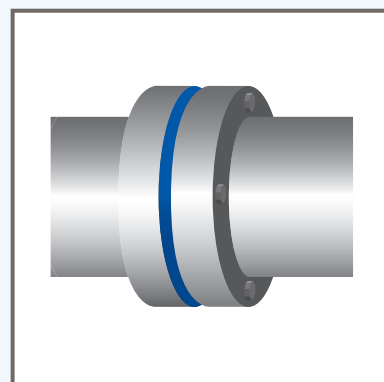
Required Viscosity	Product	Technology	Key Properties	Colour	Gap Filling	Temperature Resistance
Low, for precise joints	RL 67	Anaerobic Adhesive	For cylindrical parts like bearings, shafts, bushes, rotors, studs etc.; low viscosity.	Green	0,04 to 0,13 mm	-50 to +150 °C
Medium	RM 88	Anaerobic Adhesive	High temperature resistance; for cylindrical parts like bearings, bushes etc.	Green	0,05 to 0,15 mm	-50 to +180 °C
High, for large gaps	RH 98	Anaerobic Adhesive	High temperature resistance; gap filling; for dynamic loaded parts. It can be used also for high resistance threadlocking.	Green	0,10 to 0,30 mm	-50 to +200 °C

PIPE SEALING



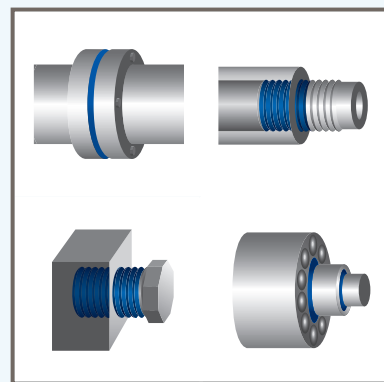
Required Strength	Product	Technology	Key Properties	Colour	Max Size of Thread	Temperature Resistance
Low	SH 22	Anaerobic Adhesive	Low strength; high viscosity pipe sealant; easy to dismantle.	White	3"	-50 to +150 °C
Medium, for precise threads	SM 40	Anaerobic Adhesive	For hydraulic and pneumatic fine threads.	Brown	MA20	-50 to +150 °C
Medium, for coarse threads	SH 27	Anaerobic Adhesive	Sealant for gas, steam and water pipes; DVGW certified for gas according DIN EN 751-1; approved for potable water.	Yellow	2"	-50 to +150 °C

GASKETING



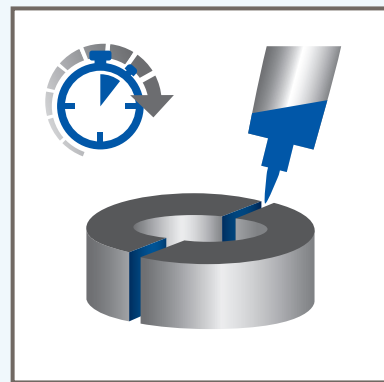
Required Strength	Product	Technology	Key Properties	Colour	Gap Filling	Temperature Resistance
Medium	SH 55	Anaerobic Adhesive	High viscosity and medium strength.	Red	0,1 to 0,3 mm	-50 to +150 °C
High	SH 58	Anaerobic Adhesive	Very high viscosity flange sealant for large gap filling and high strength.	Red	0,1 to 0,5 mm	-50 to +150 °C

4 in 1: GASKETING, PIPE SEALING, THREADLOCKING, RETAINING



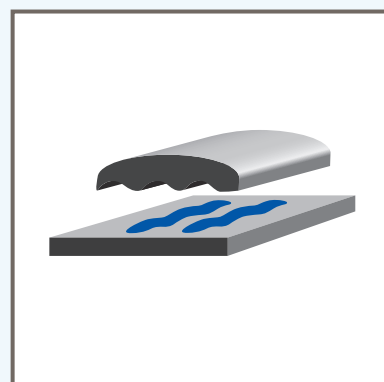
Required Strength	Product	Technology	Key Properties	Max. Thread / Gap Filling	Temperature Resistance
High	TT 69	Anaerobic Adhesive	4 in 1 product: high temperature thread locker, retaining compound, pipe and flange sealant. Thixotropic formulation for all maintenance operations in a pump dispensing bottle; NSF P1 registered; approved for gas and potable water.	1" / 0,1 to 0,2 mm	-50 to +150 °C

INSTANT BONDING



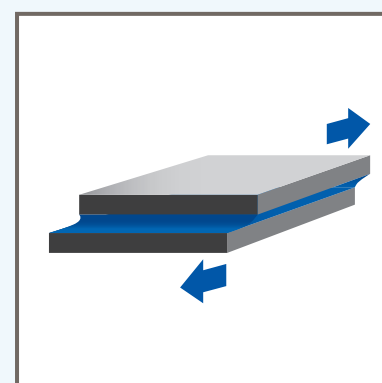
Requirements	Product	Technology	Key Properties	Setting Time on Rubber	Temperature Resistance
Multipurpose	CB 2610	Cyanoacrylate Adhesive	Multipurpose grade, suitable for metal, plastics, rubbers and materials such as wood, paper, leather and fabric; NSF P1 registered.	1-3 sec	-55 to +95 °C
Multipurpose, porous substrates	CB 2999	Cyanoacrylate Adhesive	Surface insensitive multipurpose grade in gel, suitable for metal, plastics, rubbers as well as wood, leather, cardboard and porous materials.	10-14 sec	-55 to +95 °C
Rubber and plastic bonding	CB 2006	Cyanoacrylate Adhesive	Very fast solution for rubber and plastic bonding with extremely good ageing properties; NSF P1 registered.	1-3 sec	-55 to +95 °C
High mechanical properties	CB 2240 Xtraflex	Cyanoacrylate Adhesive	Rubber toughened grade, for joints subject to dynamic stress and high temperature, especially metal/plastic and metal/rubber combinations; NSF P1 registered.	7-11 sec	-55 to +140 °C

STRUCTURAL BONDING



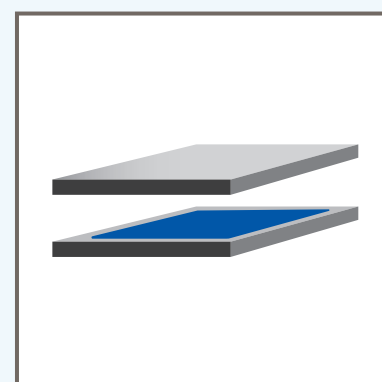
Application Substrate	Product	Technology	Key Properties	Pot Life	Temperature Resistance
General Purpose	AL 6070 Low odour	Methylmethacrylate Adhesive	Multipurpose high-strength transparent methacrylate structural adhesive for metals and plastics; low odour; suitable for composite.	3-5 min (Setting Time)	-40 to +120 °C
Polyolefines	AT 1740 PP/PE	Methylmethacrylate Adhesive	Suitable for bonding polyethylene (PE) and polypropylene (PP) without substrate pretreatment; thixotropic.	10-15 min (Setting Time)	-40 to +120 °C
Woods, aluminum, rigid PVC, FRP, PUR/PS foams	Körapur 666/90	2-K Polyurethane Adhesive	Thixotropic, easy to spread with spatula; high humidity resistance; available with many different pot life profiles.	90 min	-160 to +90 °C
Metals, foams, plastics	Körapur 790/30	2-K Polyurethane Adhesive	Non-sagging, easy to apply in the special u-TAH™ cartridge, fits into a standard dispensing gun; solvent- and plasticizer-free structural adhesive.	30 min	-160 to +90 °C
Glass, ceramic, stone, metals	Körapox 735	2-K Epoxy Resin	Reaction adhesive for fast bonding and casting of glass, ceramic, stone, metal and electronic parts.	5 min	-40 to +120 °C

ELASTIC BONDING AND SEALING



Requirements	Product	Technology	Key Properties	Skin Formation Time	Tensile Strength
High strength, suitability to powder coating	Körapox 240	1-K STP	Multipurpose elastic adhesive sealant with high mechanical properties and excellent weather resistance. Available in white, grey and black.	10 min	3,2 MPa
Multipurpose, excellent elongation no EHS labelling	Körapur 030	1-K Polyurethane Adhesive	Universal adhesive and sealant with excellent elongation at break and moisture resistance; label free according to GHS; good overpaintability. Available in white, grey and black.	45 min	2,9 MPa
Fast handling	Körapox 330	1-K STP	High green strength for fast handling; good resistance to humidity, weathering and temperatures. Available in white and grey.	10 min	2,3 MPa
High temperature, fungicide sealing	Ködisil N	1-K Silicone	Neutral curing multipurpose silicone sealant; fungicide and MEKO-free. Available in white and transparent.	5 min	0,6 MPa
Very high temperature sealing	Köditac 114	1-K Silicone	High heat resistance (-40 °C to +250 °C, +350 °C for 60 minutes); high mechanical strength; excellent resistance to motor oil and cooling liquids. Anthracite colour.	5 min	2,6 MPa
Multipurpose, medium open time	Körapox 225	1-K STP	Elastic moisture curing adhesive and sealant; high cold and heat resistance; excellent moisture resistance. Available in white, grey and black.	25 min	2,8 MPa
Large gap filling, faster curing	Körapox 225 2-K	2-K STP	Elastic adhesive; high cold and heat resistance; excellent moisture resistance. Available in white, grey and black.	20 min	2,6 MPa
Higher mechanical properties	Körapox 250	1-K STP	Elastic adhesive with very high mechanical features, high shore hardness, and suitable for a broader range of substrates. Black colour.	10 min	4,7 MPa
High strength, mold and fungus resistance	Körapox Alu	1-K STP	Elastic moisture curing adhesive and sealant; high cold and heat resistance; excellent moisture resistance; approved for HVAC use. Aluminum colour.	15 min	3,1 MPa
Multipurpose, long open time	Körapur 125	1-K Polyurethane Adhesive	Universal adhesive and sealant; high cold and heat resistance; excellent moisture and weather resistance. Available in white, grey and black.	45 min	2,0 MPa
High strength, long open time	Körapur 140	1-K Polyurethane Adhesive	High strength elastic adhesive; long open time. Available in white, grey and black.	45 min	4,0 MPa
Chemical and temperature resistance	Ködisil HAC-A	1-K Silicone	Good resistance to humidity, weathering, temperatures and chemicals. Either prevents from fungal attack on a long-term basis or delay its occurrence considerably. Transparent.	10 min	1,8 MPa
Sprayability, weld and seam sealing	Körapox 215	1-K STP	Sprayable elastic sealant for sealing welding lines and joints in metalworking in general. Product approved by various OEMs as a protective from gravel and stones. Available in black, grey and beige.	25 min	1,6 MPa
Transparency, good mechanical properties	Körapox transparent	1-K STP	Elastic moisture curing transparent adhesive and sealant with good mechanical features; excellent moisture and weather resistance.	10 min	3,0 MPa
Maximum gas impermeability	Ködiplast CT 100	1-K Butyl	Non-reactive removable sealant with excellent gas impermeability and weather resistance. Available in black and grey.	3 min	-
Good mechanical properties and high elongation, also for glass	Körapox 235	1-K STP	Elastic moisture curing adhesive with good mechanical features, excellent moisture and weather resistance, suitable also for glass bonding. Available in white, grey and black.	10 min	3,1 MPa

LARGE SURFACE BONDING



Requirements	Product	Technology	Key Properties	Viscosity	Open Time	Density	Consumption
Adhesion on a broad range of substrates	Isoma™ R 145/88	LMC	Suitable for a broad range of substrates, sag resistant, low foaming, short open time.	140.000 mPas	5 min	1,50 g/cm³	150-300 g/m²
High surface tack	SwiftTack 2050	Water based	High surface tack, good heat and plasticizer resistance.	20.000 mPas	3-5 min	1,01 g/cm³	80-150 g/m²

Requirements	Product	Technology	Key Properties	Viscosity	Open Time	Density	Solid Content
High strength and humidity resistance	Rakol® GXL3	Water based	Easy to apply and suitable for many processing conditions, provides a very strong bonding. D3 certified.	13.000 mPas	8-12 min	1,00 g/cm³	50 %
Low emissions and long open time	Köracoll WB 20	Water based	Rapid setting, long tack, Emicode EC1, Gliscode D1.	14.000 mPas	10-20 min	1,00 g/cm³	78 %

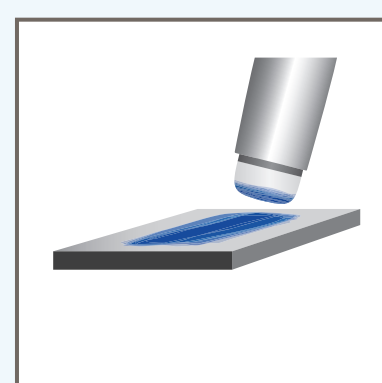
Requirements	Product	Technology	Key Properties	Curing time	Open Time	Consumption
High initial strength	TEC™ 540	Water based	High initial adhesion strength and final bond strength.	48-72 hours	1 hour	250-350 g/m²

Requirements	Product	Technology	Key Properties	Open Time	Consumption
Extremely stressed joints	Körplast SF	Solvent based	Universal PUR contact adhesive.	5-20 min	250 g/m²
Multipurpose	Körapren FU 36	Solvent based	Contact adhesive also for mineral grounds and metals.	15 min	250 g/m²
Vertical applications, high initial strength	TEC™ 238	Solvent based	Polychloroprene, in gel form, multipurpose, does not drip.	30-40 min	200-300 g/m²
Fast initial grab, sprayable	SwiftTack 9720	Solvent based	Multipurpose spray adhesive in cans; for contact and one-sided bonding; quick initial adhesion; low odour; transparent.	1 min	-

Requirements	Product	Technology	Key Properties	Open Time	Viscosity
Multipurpose, no EHS labelling	Rakol 5010	Hotmelt PUR	Multi purpose low-emission reactive hot melt, with high green strength, suitable for wood, metal, glass, textiles, PUR-foams, plastics and aluminum.	6 min	19.000 mPas at 120 °C
Very short open time	SwiftTack 2914	Hotmelt PUR	Offers a broad spectrum of adhesion, good temperature resistance and very short open time; can be used to assemble wood, plastic, metals, leather and glass.	10-25 sec	27.500 mPas at 120 °C
Multipurpose, good adhesion on plastics	SwiftTack 4023 F	Hotmelt PUR	Short open time and good adhesion properties to wood, leather, textiles, metals and plastics.	4 min	9.000 mPas at 120 °C

Requirements	Product	Technology	Key Properties	Softening Point	Viscosity
Good mechanical properties	Luramelt PS 4015	Hotmelt PSA	Strong self-adhesive, good balance between tackiness and cohesion, good temperature and shear resistance.	107-117 °C	4.500 mPas at 175 °C

SURFACE PREPARATION



Requirements	Product	Technology	Key Properties
Unpolar plastic priming	CB 9056	Solvent based	Primer to pretreat unpolar plastics such as Polyethylene (PE), Polypropylene (PP), Polyoxymethylene (POM), Silicone and thermoplastic Elastomers (TPE) prior to use instant adhesives.
	SwiftTack Prime 2599	Solvent based, toluene free	
	Conditioner Pen	Felt tip pen	
Metal cleaning prior to bonding	CB 9999	Solvent based	Cleaner in spray cans to remove oil, grease and dirt from metal parts prior to the bonding application. Suitable also for brakes.
General cleaning prior to bonding	Körasolv WL	Solvent based	Multipurpose cleaner and degreaser to be used prior to the bonding application. Suitable also for painted surfaces. Toluene free.

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