



# Körapur 666

<b>General Properties</b>	Technology/Base	Polyurethane (PU)
	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



## Typical Technical Data

### Part A Körapur 666

<b>Physical Properties</b> Density Color	14.2 lb/gal beige	DIN EN 542
<b>Processing Guidelines and Parameters</b> Storage Temperature Viscosity	59 F to 77 F 5,000,000 mPa·s	Kö-test method 100000

### Part B Köracur TH 650

<b>Physical Properties</b> Density NCO content Color	10.3 lb/gal 31 % brown	DIN EN 542
<b>Processing Guidelines and Parameters</b> Storage Temperature Viscosity	50 F to 77 F 300 mPa·s	Kö-test method 100000



**General**

<b>Physical Properties</b>		
Density	13.4 lb/gal	DIN EN 542
Glass Transition Temperature	122 F	DIN EN ISO 6721-1
<b>Processing Guidelines and Parameters</b>		
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	59 F to 77 F	
Viscosity	55,000 mPa·s	Kö-test method 100003
<b>Curing</b>		
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
<b>Cured Material Characteristics</b>		
Shore Hardness (Type D)	63	DIN EN ISO 868
Tensile Strength	15 MPa	DIN EN ISO 527
Elongation at Break	3 %	DIN EN ISO 527
G <sub>10</sub> -Modulus	140 MPa	DIN EN 14869-2
Lap Shear Strength	17 MPa	DIN EN 14869-2, substrates: aluminum/aluminum
<b>Service Conditions</b>		
Service Temperature	-256 F to 194 F	
Short-term temperature resistance	248 F	min. 60 min



**Product Properties**

<b>Applications</b>	Fields of Application	Automotive Construction Industrial assembly Transportation
	Typical Applications	Side wall, floor and roof assemblies for trailer constructions Sandwich assemblies
<b>Processing</b>	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	Non-sagging Pasty
	Surface Requirements	Dry Clean Free of grease Free of dust
	Application Method	Using mixing cartridge
	Application Equipment	Two part mixing and metering system
	Product is free of	Solvents Plasticizers
	<b>Cleaning</b>	Cleaner for Tools
<b>Certifications</b>	Certifications and Declarations of Conformity	Meets the requirements of the International Maritime Organisation (IMO)
<b>Hints</b>	Moisture Sensitivity	The adhesive must not be exposed to moisture before and during application. Moisture causes foaming leading to lower mechanical properties.

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## Additional Information

### Storage

Körapur 666 should be used within the shelf life specified on the packaging. The storage stability applies to material stored under appropriate conditions only (original unopened containers, recommended storage temperature).

### Safety

Please read our Safety Data Sheet (SDS) 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.

### Disposal

Please refer to the Safety Data Sheet (SDS) for disposal instructions.

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