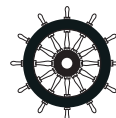


# Körapur 925 Marine



**Elastic, one component moisture curing adhesive and sealant suitable for use in the marine and boat industry**

- Overpaintable after skin formation
- Elastic vibration-resistant joint seals
- Good resistance to humidity and weathering
- Resistant to temperatures from -40°C to +90°C (for short intervals up to +120°C)
- Good adhesion to primed and painted metals, aluminium, wood and duroplastics
- Meets the requirements of the International Maritime Organization



## TECHNISCHE DATEN

Base	Polyurethane one component, cures on exposure to humidity	
Colour	White, grey, black	
Viscosity	Paste, spreadable, non-sag properties, usable by sealant applicator gun	
Density	Approx. 1,3 g/cm <sup>3</sup> (color specific)	DIN EN ISO 1183-1 <sup>1)</sup>
Skin formation time	45 min	1)
Curing	3-4 mm (on the first day)	1)
Change in volume	3 %	DIN 52 451
Hardness Shore A	45	ISO 868 / DIN 53 505
Elongation at tear	650 %	ISO 527 / DIN 53 504
Tensile strength	3 N/mm <sup>2</sup>	ISO 527 / DIN 53 504
Tear propagation strength	11 N/mm	ISO 34 / DIN 53 515
Building-material class	B2	DIN 4102 part 1 + part 4
<sup>1)</sup> standard climate 23/50-2 DIN 50014		

## PROCESSING

### Processing temperature

+5°C to +35°C

### Preparation

The surfaces to be bonded must be clean, dry and free from dust and grease. For cleaning we recommend **Körasolv PU**. In case of powder or gel coated substrates, **Körasolv WL** should be used.

To increase adhesion of non-porous substrates such as 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 925** 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. Alkyd resin based paints may show delayed or indented curing.

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 925 MARINE

## Bonding

The thickness of the layer depends on the expected mechanical movement within the joint

Join the material to be bonded within the skin formation time after application. Due to the low initial tack, we recommend mechanical fixing until a complete cure is obtained.

The time to achieve complete curing is dependent on temperature, humidity and joint dimensions.

To accelerate curing it is possible to moisten the joint with a water drizzle after the adhesive application.

## CLEANING

### Körasolv PU

Clean tools immediately after use.

Once cured material can only be removed mechanically.

## SPECIAL NOTES

### Tools

Spatula or gun

### Storage

Do not store at temperatures above +25°C

Cartridge and sausage: 12 months

### Precautions

When using **Körapur 925 Marine**, avoid direct skin contact of the uncured material. Wear suitable personal protective equipment (chemical resistant gloves/clothing).

Users should always refer to the Central Association of the Mutual Industrial Accident Insurance Funds, Central Office for Accident Prevention, when processing PUR-coating materials.

### IMO requirements

Meets the requirements of the International Maritime Organization up to a coating weight of 155 g/m<sup>2</sup>.

## 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

310 ml aluminium cartridge (carton à 12 pcs.)

600 ml sausage (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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**TÜVRheinland**

**CERT**

ISO 9001  
ISO 14001  
BS OHSAS 18001