

PRODUCT INFORMATION**Körasolv KS**

For cleaning and dissolving Köratan-adhesives and also suitable for cleaning rigid PVC before bonding (no surface swelling effect)

TECHNICAL DATA

Base	Mixture of organic solvents		
Colour	colourless, transparent		
Density	approx. 0.7	g/cm ³	DIN 53 479

PROCESSING**Processing temperature**

+5 - +35 °C

PACKAGING UNITS

12 l flat can

200 l drum

SPECIAL NOTES**Storage**

Store containers tightly closed, in a dry place no longer than 12 months.

PRODUCT NUMBER

C 87029

SAFETY

Please notice the indications on our EC-safety-data-sheets and the safety-indications on the labels of each product for the treatment of our products.

Especially the directions of the Dangerous Substance Regulation have to be respected.

Keep the EC-safety-data-sheet of the product you treat ready to hand. It gives you valuable indications for the safe usage, disposal and in case of accidents.

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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PRODUCT INFORMATION

Halosol 6



One component halogenizer

- For pretreatment of rubber,- TPR- and latex soles
- Flourescent (enables processing control)

TECHNICAL DATA

Base	Derivate of halogens, solvent	
Colour	Yellow-transparent	
Density	0,90	g/cm ³
Viscosity	5	mPa.s
Drying time	60 min (can only be shortened by input of heat)	
Storing time (of pretreated soles)	max. 3 weeks (depending on material)	

PROCESSING

Processing temperature

Do not process halogenizer, adhesive and materials to be bonded below +18°C.

Undercooled halogenizer should be warmed up (not with open flame) and stirred well before use.

Preparation

Halosol 6 is ready for use.

Rough rubber- and latex soles, if possible, and remove dust. If necessary, wash TPR-soles with **Körasolv KS** for removing rests of release agent / colour.

Application

Apply **Halosol 6** by metal-free brush with nylon hairs. Take care that primer is wetting the full surface. Brush intensively, but do not apply to much.

Full surface coating can be checked within production process under UV-light (fluorescent-indicator).

Wait for drying minimum 60 minutes before applying PUR-based main coat.

HALOSOL 6

CLEANING

Körasolv CA, Körasolv M

SPECIAL NOTES

Storage

6 months at +18°C.

Containers, tin and adhesive vessels are to be kept tightly close in order to avoid thickening of the adhesive due to the evaporation of solvents.

SAFETY

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PACKAGING UNITS

Tins of 5 kg

PRODUCT NUMBER

C 89001

For safety related data please refer to the safety data sheet!

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Körplast 188

General Properties	Technology/Base	polyurethane, solvent borne
	Optional cross linking agent	Köracur TR 203 Köracur TR 280 Köracur TR 400
	Effects of Crosslinker	significantly improved resistance by additional chemical curing
	Type of Product	adhesive
	Curing	physical
	Color	transparent
	Product Benefits	good setting contact high initial bonding strength

Technical Data

General

Physical Properties		
Density	0.85 g/cm ³	DIN EN ISO 2811-1
Processing Guidelines and Parameters		
Storage Temperature	10 °C to 25 °C	up to 3 weeks, depending on the material. Kö-test method 100000
Processing Temperature	18 °C to 30 °C	
Flash off time / waiting time	min. 20 min	
Viscosity	3,000 mPa·s	
Press time	8 s to 15 s	
Activation Temperature ¹	60 °C to 70 °C	

¹ After exceeding the open time

With optional crosslinker

Processing Guidelines and Parameters		
Mixing ratio by weight	5 % to 10 %	
Flash off time / waiting time	20 min to 90 min	
Potlife	4 h to 6 h	with Köracur TR 400
Potlife	6 h to 8 h	with Köracur TR 280
Potlife	20 h to 24 h	with Köracur TR 203



Product Properties

Applications	Special Applications	Bonding of soles
Processing	Suitable Substrates	polyamide (PA) polyurethane (PUR) leather textile PVC-soles halogenated TR- and rubber-soles
	Consistency	liquid
	Surface Requirements	dry clean free of grease free of dust
	Application Method	with brush with machine
Cleaning	Cleaner for Tools	Körasolv PU Körasolv CA
Hints	Cross linking	By adding the crosslinker, the resistance of the adhesive can be significantly improved.
	Undercooled adhesive	Undercooled adhesive should be warmed up min. 3 days at +25°C to +35°C (not with open flame) and stirred well before use.



Additional Information

Storage

Körplast 188 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). High temperatures shorten the shelf life. Low temperatures temporary cause a higher viscosity.

Safety

Please read our material safety data sheet and the labels of each product before use. The valid safety regulations must be considered.

Preparation

Rough leather, rubber, crepe, PVC and PUR materials carefully. For PUR materials we recommend priming

with Kö-PUR. PVC must be washed up. TR soles and rubber materials must be halogenated with Halosol S or Halosol 6.

Bonding

Coat the bonding surface of the pretreated soles (pay attention to drying time of primers) with Körplast 188. Wait for drying minimum the fan off time . Activate the sole at Activation Temperature. Fix sole against upper and press. The pressure to be applied depends on the hardness of the sole material.

Cleaning

Clean tools immediately after use. Appropriate cleaners are listed in the product properties table. For further information please contact your local sales office.

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Resin

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Köracur TR 400

General Properties	Technology/Base	Polyisocyanate, solvent containing
	Type of Product	Hardener
	Product Benefits	Suitable for PUR- and CR-adhesives Fast reaction time

Technical Data

General

Resin = 3 bars < 4 bars - 10 to 16 sec

Physical Properties		
Density	0.97 g/cm ³	DIN 53479
Color	light yellowish	
Processing Guidelines and Parameters		
Storage Temperature	18 °C to 25 °C	
Viscosity	10 mPa·s	Kö-test method 100000

Product Properties

Applications	Special Applications	Hardener for increasing resistance to temperature hydrolysis, plasticizer, oil, grease and acid
Processing	Consistency	liquid
Cleaning	Cleaner for Tools	Körasolv CA Körasolv M



Additional Information

Storage

Köracur TR 400 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 refer to the Material Safety Data Sheet (MSDS) for safety advice.

Processing

Please refer to datasheet of the adhesive.

Disposal

Please refer to the Material Safety Data Sheet (MSDS) for appropriate disposal instructions.



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