H.B. Fuller | KÖMMERLING

ENGINEERING ADHESIVES

Adhesive Selection Guide For Marine Applications

DECK SYSTEM

Product	Technology	Key Properties	Skin formation time	Curing after 24 h	Shore A	Elongation at break	Tensile strength	IMO
Köraflex VP 990 Marine	1-k synthetic polymer	Good adhesion to wooden materials, many duroplastics and thermoplastics, good resistance to humidity and weathering, water and salt water, very high UV resistance	30 min	2 mm	42	410 %	2,0 MPa	◎
Körapur 928 Marine	1-k PUR	Bedding compound for teak decks with long open time, high flexibility	75 min	3 mm	45	800 %	3,0 MPa	◎

GLAZING

Product	Technology	Key Properties	Skin formation time	Curing after 24 h	Shore A	Elongation at break	Tensile strength	IMO
Körapur 178	1-k PUR	High viscosity, high initial tack and non-sag properties, high UV resistance and colour stability	35 min	3 mm	60	≥ 600 %	≥ 10 MPa	-
Körapop 250	1-k STP	High cold and heat resistance, excellent moisture and weather resistance	10 min	3 mm	56	350 %	4,7 MPa	-
Körapop 954 Marine	1-k STP	Fast curing, high UV stability	10 min	3 mm	58	380 %	3,2 MPa	◎
GD 826 N	1-k silicone	Weather seal silicone with very high UV stability	> 15 min	2 mm	23	550 %	0,7 MPa	-

Product	Technology	Key Properties	Pot life	Tack free after	Shore A	Elongation at break	Tensile strength	IMO
Ködiglaze SDG 30	2-k silicone	Fast curing structural glazing silicone, high UV stability	30 min	90 min	46	230 %	2,1 MPa	-

GENERAL BONDING AND SEALING

Product	Technology	Key Properties	Skin formation time	Curing after 24 h	Shore A	Elongation at break	Tensile strength	IMO
Körapop 954 Marine	1-k STP	Fast curing, high UV stability	10 min	3 mm	58	380 %	3,2 MPa	◎
Körapur 925 Marine	1-k PUR	Multi-purpose	45 min	3-4 mm	45	650 %	3,0 MPa	◎
Körapur 940 Marine	1-k PUR	High strength, long open time	70-90 min	3 mm	55	400 %	4,0 MPa	◎

PANEL PRODUCTION

Product	Technology	Key Properties	Viscosity	Mixed Viscosity	Pot life at 20 °C	Mix ratio by weight	IMO
Körapur 666	2-k PUR	Thixotropic, easy to spread with spatula, high humidity resistance, mixing cartridge available	Paste	55.000 mPas	Various between 3 and 90 min	6:1	
Körapur 672	2-k PUR	High humidity resistance	35.000 mPas	10.000 mPas	Various between 10 and 80 min	5:1	

Product	Technology	Key Properties	Skin formation time	Curing after 24 h	Shore A	Elongation at break	Tensile strength	IMO
Körapur 928 Marine	1-k PUR	Bonding of decorative panels, long open time, high flexibility	75 min	3 mm	45	800 %	3,0 MPa	

Product	Technology	Key Properties	Viscosity	Open Time at 20 °C	Pressing Time at 40 °C	IMO
Swift®bond 9060	1-k liquid PUR	Designed for the adhesion of various plastics substrates, and the assembly of large panel parts	5.500 mPas	30 min	45 min	
Icema™ R 145/31S	1-k liquid PUR	Medium open time, high bonding strength	7.400 mPas	15 min	30 min	
Icema™ R 145/75	1-k liquid PUR	Fast product, short open time and short pressing time	5.100 mPas	3 min	4 min	
Icema™ R 145/12	1-k liquid PUR	Medium open time, good adhesion grade to most of materials, including pre-treated metals	3.500 mPas	7 min	10 min	

Product	Technology	Key Properties	Viscosity	Open Time at 20 °C	IMO
Rapidex® NP 2075 LT	Reactive Hotmelt	Very high initial strength, very good bonding on tensioned substrates	45.000 mPas	3 min	-

Product	Technology	Key Properties	Open Time at 20 °C	Viscosity	pH Value	IMO
Rakoll® GXL 3	1-k water based	Easy to apply, very strong bonding, fulfills the requirements for D3	8-12 min	13.000 mPas	3,0	

STRUCTURAL BONDING

Product	Technology	Key Properties	Skin formation time	Curing after 24 h	Shore A	Elongation at break	Tensile strength	IMO
Körapop 954 Marine	1-k STP	Fast curing, high UV stability	10 min	3 mm	58	380 %	3,2 MPa	
Körapur 940 Marine	1-k PUR	High strength, long open time	70-90 min	3 mm	55	400 %	4,0 MPa	

Product	Technology	Key Properties	Viscosity	Mixed Viscosity	Pot life 20 °C	Mix ratio by weight	IMO
Körapur 666	2-k PUR	Thixotropic, easy to spread with spatula, high humidity resistance, mixing cartridge available	Paste	55.000 mPas	Various between 3 and 90 min	6:1	
Körapur 672	2-k PUR	High humidity resistance	35.000 mPas	10.000 mPas	Various between 10 and 80 min	5:1	
Körapur 840	2-k PUR	High impact strength, no significant shrinkage, wide range of pot life profiles available	420.000 mPas	45.000 mPas	Various between 2 and 45 min	5:1	

INFLATABLES

Product	Technology	Key Properties	Viscosity	Open time	Flashoff time	Pressing time	IMO
Köraplast 81 Marine	1- or 2-k PUR solvent based	Good resistance to humidity, long open time, toluene and NEP free	2.900 mPas	40 min	10 min	8-15 sec	-
Köraplast 82 Marine	1- or 2-k PUR solvent based	High initial tack, toluene free	2.700 mPas	5-20 min	10 min	8-15 sec	-
Körapren 88 Marine	1- or 2-k poly-chloroprene	High initial tack, toluene free	1.900 mPas	10-60 min	10 min	8-15 sec	-