

Sealants and Adhesives



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Facts about 1-C polyurethanes

Processing

Use commercially available manual or pneumatic applicator guns, such as TITGEMEYER's high-quality "Hand tool", "Air tool" or "Rechargeable tool", in temperatures ranging from +5 °C to +35 °C. Between 2 to 6 bar are required when working with compressed air. Lower material temperatures will lead to increased viscosity, higher temperatures to reduced viscosity. Depending on the ambient temperature and humidity, the seal weld will need to be smoothed out while the skin is forming. We recommend that you use Köratool AM10 to do this.

Pre-treatment

The surface must be clean, dry and free from grease. Each item must be individually checked to determine how compatible the products are with - and how well they adhere to - synthetic materials and paint. To improve performance on non-porous surfaces, such as glass, FRP, aluminium, stainless, bare or galvanised steel, we recommend pre-cleaning the surface using Körabond HG 81 or Körasolv WL as prescribed in the current pre-treatment table.

Bonding

Apply to the substrate directly from the cartridge/foil pack tip. The bead geometry will depend on the quality and properties of the materials being joined and the use requirements. Insert the contact material (part to be bonded) while the skin is forming and press into place. Given the pasty consistency, it is recommended that you secure the connected parts until the adhesive has cured. The curing time will depend on the temperature and moisture content.

Paint compatibility

I-C PUR can be painted over using commercially available, industrial one and two component paint systems when cured. Standox paint systems have delivered very good results in the past. A strengthened skin formation (after two hours) is sufficient for trouble free painting. If attempted too soon, blisters may form that can prevent the sealant from curing properly. It should be noted that normal paint systems are mostly inflexible, which, when applied to an elastic sealant/adhesive, can lead to tearing. If a smoothing material is applied to smooth out the seam, care should be taken to ensure that the outer surface is cleaned before painting, as sanding residue can impair paint adhesion. We recommend using Köratool AM 10 as a smoothing agent.

Storage and transportation

- Store in a dry place in its closed original container at +5 °C to +25 °C
- Transport class not applicable
- Product contains isocyanate and solvents
- See safety data sheet

Körapur 128s

One-component, elastic, moisture-curing sealant for bodywork, container and vehicle manufacture, metalwork, and ventilation and air conditioning equipment.



Benefits at a glance

- For primed and varnished metals, aluminium, wood and duroplastics
- Self-spreading
- Paintable after curing
- Broad range of adhesive applications
- Very resistant to humidity and weathering
- Temperature-resistant from -40 °C to +90 °C (and up to +120 °C for brief intervals)



Technical specifications

Base:	One-component polyurethane, hardens in presence of moisture
Colour:	White
Viscosity:	Slightly liquid, self-spreading
Density:	approx. 1.2 g/cm ³ , DIN EN ISO 1183-1 ¹
Skin forming time:	35 min ¹
Rate of hardening:	3 mm (on day 1) ¹
Volume change:	1%, DIN 52 451
Hardness:	Shore A 45, ISO 868 / DIN 53 505
Breaking strain:	450%, ISO 527 / DIN 53 504
Tensile strength:	2 N/mm ² , ISO 527 / DIN 53 504
Tear propagation resistance:	5 N/mm, ISO 34 / DIN 53 515
Building material class:	B2, DIN 4102 Part 1 + Part 4
Working temperature:	+15 °C to +35 °C
Storage temperature:	+5 °C to +25 °C

¹ Normal climate 23/50-2 DIN 50014

Delivery types

Colour	Foil pack 600 ml (pack of 12)	Hobbock 23 kg
White	850 000 100	On request

Pre-treatment products

Surface	Product / Packaging	Article No.
Closed, dirty	Körasolv PU 1-litre tin	870 812 000
General and powder-coated	Körasolv WL 1-litre tin	870 810 000
Metals, bare, smooth/painted	Körabond HG 81 1-litre tin	870 820 000
Open-pored, absorbent	Körabond HG 74 E 1-litre tin	870 821 000
ABS, PVC	Körabond HG 77 1-litre tin	870 822 000

Shelf life: 12 months after manufacture / Extended data sheet and safety data sheet available on request.

Körapur 125

One-component, elastic, moisture-curing sealant for bodywork, container and vehicle manufacture, metalwork, etc.



Benefits at a glance

- For primed and painted/lacquered metals, aluminium, wood and duroplastics
- Paintable / sandable after curing
- Harmless food contact material in acc. with EG 1935/2004
- Broad range of adhesive applications
- Very resistant to humidity and weathering
- Temperature-resistant from -40 °C to +90 °C (and up to +120 °C for brief intervals)

Technical specifications

Base:	One-component polyurethane, hardens in presence of moisture
Colour:	White, grey, black, dark brown
Viscosity:	Thin paste, spreadable and smoothable
Density:	approx. 1.2 g/cm ³ (depending on colour), DIN EN ISO 1183-1 ¹
Skin forming time:	45 min ¹
Rate of hardening:	3 mm (on day 1) ¹
Volume change:	6%, DIN 52 451
Hardness:	Shore A 48, ISO 868 / DIN 53 505
Breaking strain:	450%, ISO 527 / DIN 53 504
Tensile strength:	2 N/mm ² , ISO 527 / DIN 53 504
Tear propagation resistance:	9 N/mm, ISO 34 / DIN 53 515
Building material class:	B2, DIN 4102 Part 1 + Part 4
Working temperature:	+15 °C to +35 °C
Storage temperature:	+5 °C to +25 °C

¹ Normal climate 23/50-2 DIN 50014



Delivery types

Colour	Cartridge 300 ml (pack of 12)	Foil pack 600 ml (pack of 12)
White	870 100 000	870 110 000
Grey	870 101 000	870 116 000
Black	870 102 000	870 112 000
Dark brown (similar to screen print board)		850 117 100

Pre-treatment products

Surface	Product / Packaging	Article No.
Closed, dirty	Körasolv PU 1-litre tin	870 812 000
General and powder-coated	Körasolv WL 1-litre tin	870 810 000
Metals, bare, smooth/painted	Körabond HG 81 1-litre tin	870 820 000
Open-pored, absorbent	Körabond HG 74 E 1-litre tin	870 821 000
ABS, PVC	Körabond HG 77 1-litre tin	870 822 000

Shelf life: 12 months after manufacture / Extended data sheet and safety data sheet available on request.

Körapur 135

One-component, elastic, moisture-curing sealant and adhesive for bodywork, container and vehicle manufacture, metalwork, etc.



Benefits at a glance

- For primed and painted/lacquered metals, aluminium, wood and duroplastics
- Paintable / sandable after curing
- Harmless food contact material in acc. with EC 1935/2004
- Broad range of adhesive applications
- Very good stability
- Low shrinkage ratio
- Ventilation/air-conditioning version in acc. with DIN 6022; can be used for ventilation/air-conditioning manufacture
- Very resistant to humidity and weathering
- Temperature-resistant from -40 °C to +90 °C (and up to +120 °C for brief intervals)



Technical specifications

Base:	One-component polyurethane, hardens in presence of moisture
Colour:	White, grey, black
Viscosity:	Thick paste, malleable, very good stability
Density:	approx. 1.4 g/cm ³ (depending on colour), DIN EN ISO 1183-1 ¹
Skin forming time:	45 min ¹
Rate of hardening:	3 mm (on day 1) ¹
Volume change:	3%, DIN 52 451
Hardness:	Shore A 50, ISO 868 / DIN 53 505
Breaking strain:	650%, ISO 527 / DIN 53 504
Tensile strength:	3 N/mm ² , ISO 527 / DIN 53 504
Tear propagation resistance:	11 N/mm, ISO 34 / DIN 53 515
Building material class:	B2, DIN 4102 Part 1 + Part 4
Working temperature:	+15 °C to +35 °C
Storage temperature:	+5 °C to +25 °C

¹ Normal climate 23/50-2 DIN 50014



Delivery types Körapur 135

Colour	Cartridge 300 ml (pack of 12)	Foil pack 600 ml (pack of 12)
White	850 100 100	850 110 100
Grey	850 101 100	850 111 100
Black	850 102 100	850 112 100

Delivery types Körapur 135 RLT

Colour	Foil pack 600 ml (pack of 12)
White	On request

Shelf life: 12 months after manufacture

Pre-treatment products

Surface	Product / Packaging	Article No.
Closed, dirty	Körasolv PU 1-litre tin	870 812 000
General and powder-coated	Körasolv WL 1-litre tin	870 810 000
Metals, bare, smooth/painted	Körabond HG 81 1-litre tin	870 820 000
Open-pored, absorbent	Körabond HG 74 E 1-litre tin	870 821 000
ABS, PVC	Körabond HG 77 1-litre tin	870 822 000

Shelf life: 12 months after manufacture / Extended data sheet and safety data sheet available on request.

Körapur 140

One-component, elastic, moisture-curing adhesive for bodywork, container and vehicle manufacture, metalwork, etc.



Benefits at a glance

- For primed and painted/lacquered metals, aluminium, wood and duroplastics
- Paintable / sandable after curing
- Broad range of adhesive applications
- Especially high stability
- Elastic-constructive bonding
- Very resistant to humidity and weathering
- Temperature-resistant from -40 °C to +90 °C (and up to +120 °C for brief intervals)

Technical specifications

Base:	One-component polyurethane, hardens in presence of moisture
Colour:	White, black
Viscosity:	Thick paste, malleable, very good stability
Density:	approx. 1.2 g/cm ³ (depending on colour), DIN EN ISO 1183-1 ¹
Skin forming time:	45 min ¹
Rate of hardening:	3 mm (on day 1) ¹
Volume change:	7%, DIN 52 451
Hardness:	Shore A 55, ISO 868 / DIN 53 505
Breaking strain:	400%, ISO 527 / DIN 53 504
Tensile strength:	4 N/mm ² , ISO 527 / DIN 53 504
Tear propagation resistance:	7 N/mm, ISO 34 / DIN 53 515
Shear strength:	4 N/mm ² , ISO 4587 / DIN EN 1465
Building material class:	B2, DIN 4102 Part 1 + Part 4
Working temperature:	+15 °C to +35 °C
Storage temperature:	+5 °C to +25 °C

¹ Normal climate 23/50-2 DIN 50014

² Layer thickness 2 mm; length of overlap 10 mm; test speed 100 mm/min

Delivery types

Colour	Cartridge 300 ml (pack of 12)	Foil pack 600 ml (pack of 12)
White	870 140 000	870 143 000
Black	870 141 000	870 145 000

Shelf life: 12 months after manufacture



Pre-treatment products

Surface	Product / Packaging	Article No.
Closed, dirty	Körasolv PU 1-litre tin	870 812 000
General and powder-coated	Körasolv WL 1-litre tin	870 810 000
Metals, bare, smooth/painted	Körabond HG 81 1-litre tin	870 820 000
Open-pored, absorbent	Körabond HG 74 E 1-litre tin	870 821 000
ABS, PVC	Körabond HG 77 1-litre tin	870 822 000

Shelf life: 12 months after manufacture / Extended data sheet and safety data sheet available on request.

Sikaflex 221

Elastic, moisture-curing sealant for bodywork, container and vehicle manufacture, metal and apparatus engineering, etc.

Benefits at a glance

- For primed and varnished metals, bare aluminium, wood and duroplastics
- Paintable / sandable after curing
- Harmless food contact material in acc. with EG 1935/2004

Delivery types

Colour	Cartridge 300 ml (pack of 12)	Foil pack 600 ml (pack of 12)
White	811 100 000	811 110 000
Grey	811 101 000	811 111 000
Black	811 102 000	811 112 000
Dark brown	811 107 000	811 114 000

Shelf life: 12 months after manufacture



Sikaflex 252

Elastic, moisture-curing adhesive for bodywork, container and vehicle manufacture, metal and apparatus engineering, etc.

Benefits at a glance

- For primed and varnished metals, bare aluminium, wood and duroplastics
- Paintable / sandable after curing

Delivery types

Colour	Cartridge 300 ml (pack of 12)	Foil pack 600 ml (pack of 12)
White	811 181 000	811 185 000
Black	811 180 000	811 186 000
Fire red	811 182 000	

Shelf life: 12 months after manufacture



Sikaflex 260

Rigid-elastic, moisture-curing adhesive for primed and painted/lacquered metals, bare aluminium, wood and duroplastics

Benefits at a glance

- Paintable / sandable after curing

Delivery types

Colour	Cartridge 300 ml (pack of 12)
Black	811 310 000



Shelf life: 9 months after manufacture

Pre-treatment products for the Sikaflex 200 series

Surface	Product / Packaging	Article No.
Closed, dirty	Activator 1-litre tin	830 003 000
General and powder-coated		
Metals, bare, smooth/painted	Adhesive cleaner 205 1-litre tin	830 006 000
Open-pored, absorbent		
ABS, PVC	Primer 215 1-litre tin	830 046 000

Shelf life: 9 months after manufacture / Extended data sheet and safety data sheet available on request.

Sikaflex 265

Rigid-elastic, moisture-curing glazing adhesive

Benefits at a glance

- For primed and painted/lacquered metals, bare aluminium and duroplastics with glass
- Especially suited for heavy commercial vehicle glazing

Delivery types

Colour	Cartridge 300 ml (pack of 12)	Foil pack 600 ml (pack of 12)
Black	811 195 000	811 196 000

Shelf life: 9 months after manufacture



SikaPower 415 P1

Epoxy resin / polyurethane

Rigid-elastic, moisture-curing and heat-curing metal sealant

Benefits at a glance

- For use on bare metals before powder coating or cathodic dip coating
- For kiln processes of up to 220 °C/10 min.

Delivery types

Colour	Cartridge 400 g (pack of 12)
Black	811 411 000

Shelf life: 5 months after manufacture, at 5 °C - 15 °C; storage at warmer temperatures will shorten shelf life



Pre-treatment products for the Sikaflex 200 series

Surface	Product / Packaging	Article No.
Closed, dirty	Activator 1-litre tin	830 003 000
General and powder-coated		
Metals, bare, smooth/painted	Adhesive cleaner 205 1-litre tin	830 006 000
Open-pored, absorbent		
ABS, PVC	Primer 215 1-litre tin	830 046 000

Shelf life: 3months after manufacture, store at 5 °C - 15 °C
Extended data sheet and safety data sheet available on request.

Facts about 2-C polyurethane adhesives

Pre-treatment and handling Ensure that the surfaces to be glued are clean, dry and free from dust and grease. Please also be sure to consult the pre-treatment table for 2-C PUR adhesives. Metals must be pre-treated first, including sanding where required. See pre-treatment table.

Using a stirrer or stirring rod, mix A+B comp. extensively in the mix cartridge (approx. 400 UpM) until the mixture turns a uniform colour.

Repot if necessary.

Using a spatula, apply the adhesive evenly across the parts to be glued and then join. The thickness of the adhesive layer will depend on the quality and properties of the materials to be joined. Depending on the type of product used, the applied adhesive may be subjected to light loads after 1 - 16 hours. It should reach its ultimate strength after 16 - 36 hours. Higher temperatures will reduce the curing time, while lower ones will increase it. Always clean your tools immediately after use.

Hardened material can only be removed mechanically.

Do not allow the uncured material to come into direct contact with the skin.

Wear protective gloves.

Körapur 666/90

Reactive adhesive for bonding metal. Good adhesion to aluminium, wood, rigid PVC and FRP/CFRP

Benefits at a glance

- Bonds aluminium corner angles and profiles used in windows, containers, commercial vehicles and apparatus engineering
- Very resistant to humidity and weathering
- Very easy to spread using a notched trowel; can be used to create composite surfaces
- Rigid and tough
- Can be chemically and thermally accelerated
- Temperature-resistant from -30 °C to +120 °C; up to 150 °C for brief intervals

Technical specifications

Base:	Two-component polyurethane, solvent-free
Colour:	Beige
Viscosity:	Mixture 50000 MPa
Density:	Mixture 1.6 g/cm ³
Pot life:	90 min ¹ ; can be accelerated by using Köracur PU
Open time:	150 min ¹
Dry to handle:	14 h ¹
Rate of hardening:	up to 36 h ¹
Hardener:	TH 650
Mixing ratio:	A/B-weight: 6/1, Volume: 4.5/1
Shear strength:	Alum./wood: 17 MPa at -20 °C, 14 MPa at 20 °C, 3.5 MPa at 80 °C
Working temperature:	+15 °C to +25 °C
Storage temperature:	+10 °C to +25 °C

¹ Normal climate 23/50-2 DIN 50014



Delivery types

Description	Packaging	Article No.
666/90 A comp.	6 kg tin, pack of 1	870 250 000
TH 650 B comp.	1 kg tin, pack of 1	870 600 000
Mix cartridge A+B	0.35 kg cartridge, pack of 12	870 200 000

Accessories for mix cartridge

- Stirrer / nozzles, pack of 1; 12 items per pack – Article No. 860 110 000

Pre-treatment products

Surface	Product / Packaging	Article No.
General and powder-coated	Körasolv WL 1-litre tin	870 810 000
Metals, bare	Körabond HG 79 0.5-litre tin	870 825 000
ABS, PVC	Körabond HG 77 1-litre tin	870 822 000

Shelf life: 12 months after manufacture / Extended data sheet and safety data sheet available on request.

Körapur 840

2-C structural adhesive for bonding metals, duroplastics – FRP/CFRP

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Benefits at a glance

- Stable on vertical surfaces when applied as a bead or using a trowel
- Good adhesion properties on powder coatings
- Good impact resistance
- Can be chemically and thermally accelerated
- Temperature-resistant from -30 °C to +120 °C; up to 150 °C for brief intervals

Technical specifications

Base:	Two-component polyurethane, solvent-free
Colour:	Beige
Viscosity:	Mixture 40000 MPa
Density:	Mixture 1.5 g/cm ³
Pot life:	2, 15, 20, 45 min ¹ ; can be accelerated by using Köracur PU 8 – 60 min ¹
Open time:	8 – 60 min ¹
Dry to handle:	15 min. – 8 h ¹
Rate of hardening:	2 – 24 h ¹
Hardener:	TH 650
Mixing ratio:	A/B weight: 5/1, Volume: 4/1
Hardness:	Shore D 73 1)
Shear strength:	Alum./Alum.: 24 MPa at -20 °C, 16 MPa at 20 °C, 4.4 MPa at 80 °C
Elongation at break:	15% at -20 °C; 70% at +20 °C
Working temperature:	+15 °C to +25 °C
Storage temperature:	+10 °C to +25 °C

¹ Normal climate 23/50-2 DIN 50014



Delivery types

Description	Packaging	Article No.
840/45 A comp.	5 kg tin, pack of 1	870 350 000
TH 650 B comp.	1 kg tin, pack of 1	870 600 000
Mix cartridge A+B	0.35 kg cartridge, pack of 12	870 300 000 ³
Dual cart. 840/45 A+B	0.54 kg cartridge, pack of 12	870 320 000 ²
Dual cart. 840/20 A+B	0.54 kg cartridge, pack of 10	870 321 000 ²
Dual cart. 840/08 A+B	0.54 kg cartridge, pack of 10	870 322 010 ²
Dual cart. 840/02 A+B	0.54 kg cartridge, pack of 10	870 322 000 ²

Accessories for mix and dual cartridges

- ² Static mixing tube, 24 spiral, ø 8 mm, pack of 1 – Article No. 870 710 000
- ² Static mixing tube, 24 spiral, ø 10 mm, pack of 1 – Article No. 870 712 000
- ³ Stirrer / nozzles, pack of 1; 12 items per pack – Article No. 860 110 000
- ² Pneumatic tool for squeezing dual cartridges – Article No. 845 111 000
- ² Hand tool for squeezing dual cartridges – Article No. 845 110 000

Körapur 840

Pre-treatment products

Surface	Product / Packaging	Article No.
General and powder-coated	Körasolv WL 1-litre tin	870 810 000
Metals, bare	Körabond HG 79 0,5-litre tin	870 825 000
ABS, PVC	Körabond HG 77 1-litre tin	870 822 000

Shelf life: 9 months after manufacture / Extended data sheet and safety data sheet available on request.

Körapur 648

Self-spreading sandwich panel adhesive for manufacturing sandwich elements

Benefits at a glance

- For panels, rigid PVC, FRP, CFRP, steel and aluminium
- For foams: PUR, PVC, PS
- Very easy to spread; for creating composite surfaces
- Can be chemically and thermally accelerated
- Temperature-resistant from -30 °C to +120 °C; up to 150 °C for brief intervals

Technical specifications

Base:	Two-component polyurethane, solvent-free
Colour:	Beige
Viscosity:	Mixture 1400 MPa
Density:	Mixture 1.42 g/cm ³
Pot life:	120 min ¹ ; can be accelerated by using Köracur PU
Open time:	180 min ¹
Dry to handle:	12 – 16 h ¹
Rate of hardening:	up to 36 h ¹
Hardener:	TH 650
Mixing ratio:	A/B weight: 3.5/1
Shear strength:	Alum./Alum.: 13 MPa at 20 °C, 3 MPa at 80 °C
Working temperature:	+15 °C to +25 °C
Storage temperature:	+10 °C to +25 °C

¹ Normal climate 23/50-2 DIN 50014

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Delivery types

Description	Packaging	Article No.
648 A comp.	30 kg tub, pack of 1	870 400 000
TH 650 B comp.	1 kg tin, pack of 1	870 600 000
TH 650 B comp.	10 kg tin, pack of 1	870 620 000

Shelf life: 9 months after manufacture / Extended data sheet and safety data sheet available on request.

Pre-treatment products

Surface	Product / Packaging	Article No.
General and powder-coated	Körasolv WL 1-litre tin	870 810 000
Metals, bare	Körabond HG 79 0.5-litre tin	870 820 000
ABS, PVC	Körabond HG 77 1-litre tin	870 822 000

Shelf life: 12 months after manufacture / Extended data sheet and safety data sheet available on request.

Körapur 672

Medium-viscosity sandwich panel adhesive for manufacturing sandwich elements



Benefits at a glance

- For panels, rigid PVC, FRP, CFRP, steel and aluminium
- For foams: PUR, PVC, PS
- Very easy to spread using a notched trowel; can be used to create composite surfaces
- Can be chemically and thermally accelerated
- Temperature-resistant from -30 °C to +120 °C; up to 150 °C for brief intervals



Technical specifications

Base:	Two-component polyurethane, solvent-free
Colour:	Beige
Viscosity:	Mixture 8000 MPa
Density:	Mixture 1.60 g/cm ³
Pot life:	60 min ¹ ; can be accelerated by using Köracur PU
Open time:	100 min ¹
Dry to handle:	8 h ¹
Rate of hardening:	up to 24 h ¹
Hardener:	TH 650
Mixing ratio:	A/B weight: 5/1
Working temperature:	+15 °C to +25 °C
Storage temperature:	+10 °C to +25 °C

¹ Normal climate 23/50-2 DIN 50014

Delivery types

Description	Packaging	Article No.
672 A comp.	30 kg tub, pack of 1	870 500 000
TH 650 B comp.	1 kg tin, pack of 1	870 600 000
TH 650 B comp.	10 kg tin, pack of 1	870 620 000

Shelf life: 9 months after manufacture

Pre-treatment products

Surface	Product / Packaging	Article No.
General and powder-coated	Körasolv WL 1-litre tin	870 810 000
Metals, bare	Körabond HG 79 0.5-litre tin	870 820 000
ABS, PVC	Körabond HG 77 1-litre tin	870 822 000

Shelf life: 12 months after manufacture / Extended data sheet and safety data sheet available on request.

Facts about silyl modified polymers

Pre-treating substrates

SMPs adhere very well to many metals, synthetic materials and wood types without these having to be specially pre-treated first, using e.g. primers. These especially include aluminium, stainless steel, bare / galvanised/ painted/lacquered steel, copper, brass, glass, rigid PVC, PC, FRP, and wood. Surfaces must be thoroughly cleaned and free from dust and grease; to this end and depending on the surface, we recommend using Supergrip 5001 HR, which improves the adhesion qualities of the sealant/adhesive. For special surfaces, such as powder coatings or ABS, and for instances where large thermal and moisture stresses are anticipated, we recommend using Prep. M. Apply using a cloth; drying time: 10 minutes. As a rule, it is recommended that the surfaces be finely abraded using emery cloth. Condensation may form if the surface is too cold and the temperature falls below the dew point. This can be avoided by allowing the surface to warm up to the required temperature. Please note: before use, always consult the pre-treatment table for 1-C SMP products as well as the technical data sheets for Supergrip 5001 HR and Prep M. Always test the product first before beginning the actual application.

Processing

Use commercially available hand or compressed air guns, such as TITGEMEYER's high-quality "Hand tool", "Air tool" and "Rechargeable tool", in temperatures ranging from +5 °C to +35 °C. Between 2 to 6 bar are required when working with compressed air. Lower material temperatures will lead to increased viscosity, and higher temperatures to reduced viscosity.

Sealing

Depending on the ambient temperature and humidity, the sealing seam will need to be smoothed out within the skin forming time.

Gluing

Depending on the desired use, the material should be applied as a round or triangular bead in individual dimensions. The advantage of the triangular bead is that its shape aids the uniform distribution of the adhesive when later joining the parts and also has the ability to bridge large tolerances. The greater the thickness of the adhesive, the more distortion can be accommodated by the elasticity of the adhesive. For this reason, the adhesive layer thickness should be determined based on the application/use. Layer thicknesses of between 1 and approx. 10 millimetres (1-C) should be observed. To maintain more exact layer thicknesses and make the bond even more secure (better handling), we recommend the additional use of double-sided adhesive tape or "fixpoints" (individual adhesive points). The elements to be connected must be joined together within the open time prescribed after the adhesive has been applied.

1-C silyl modified polymers:

As 1-C silyl modified polymers are moisture-curing adhesives, the hardening times depend on the ambient temperature and humidity. The higher the level, the shorter the hardening time. The open time falls as the temperature and humidity level rise. Depending on the intended use, the glued joints should be mechanically secured during the initial hardening phase. To shorten the curing time, we recommend lightly spraying the surrounding areas using an atomiser once the individual parts have been joined.

**Gluing
(cont'd)**

2-C silyl modified polymers:

When working with 2-C silyl modified polymers, a reaction accelerating paste is force mixed with the A component of the SMP. This 2-C makeup causes the curing reaction to begin not just on the outside but also simultaneously throughout the entire adhesive mass. As a result, the SMP bead can fully cure within 2 -6 hours irrespective of the type used or the exterior temperature.

Paintability

SMPs can be painted wet-in-wet (after the skin has formed) using standard, industrial 1-C and 2-C car touch-up paint. In doing so, the rate at which the sealant/adhesive hardens is only minimally slowed. If painted, the ideal level of paint adhesion is achieved within 72 hours of the adhesive/sealant being applied. If the item is painted at a later date, the adhesive/sealant will need to be sanded in order to ensure a good level of paint adhesion. For best painting results, a top coat should be applied. For this reason, we recommend first priming the surface, then sealing, and finally applying a top coat. Should a smoothing agent be used, it must be ensured that, prior to applying the paint, the surface is cleaned and sanded to avoid any residual smoothing agent diminishing the level of adhesion between the seam and the paint. Always carry out a preliminary test before commencing the job. Please note that normal paint systems are mostly inflexible, which, when applied to an elastic adhesive/sealant, can lead to tearing. Since SMPs exhibit little volume shrinkage, the paint tends to sink in less and thus to tear, blister or peel less. Depending on the envisaged use, adhesives/sealants with a high Shore A hardness are recommendable as their stiffness further prevents the paint from peeling or cracking.

**Storage, transport and
safety regulations**

This product is not susceptible to frost.

Store in a dry place in its closed original container at +5 °C to +30 °C.

Transport class not applicable.

No special safety measures are required; please observe the safety data sheet.

Bostik Simson ISR 70-07

One-component, elastic, moisture-curing, sprayable SMP-based sealant / surface adhesive. For bodywork, container and vehicle manufacture, metal and apparatus engineering, etc.



Benefits at a glance

- For primed and painted/lacquered metals, aluminium, wood, and duroplastics, thermoplastics
- Paintable wet in wet - after skin has formed
- Sound-absorbing, vibration-damping, stone chip protection
- Can be used as a surface adhesive
- Contains no isocyanates, silicone or solvents
- Extremely broad range of adhesion applications
- Good stability, spreadability
- Low shrinkage ratio
- Excellent moisture, weathering and UV resistance
- Temperature resistant from -40 °C to +100 °C

Technical specifications

Base:	One component silyl modified polymer, hardens in presence of moisture
Colour:	Grey
Viscosity:	Viscous
Density:	approx. 1.4 g/cm ³ , DIN 52451-PY
Skin forming time:	< 30 min ¹
Rate of hardening:	2 mm (on day 1) ¹
Volume change:	< 4%, DIN 52 451-PY
Hardness:	Shore A approx. 45, DIN 53 505
Elongation at break:	175%, DIN 53504/ISO 37
Tensile strength:	approx. 1.5 MPa
Extension (100%):	approx. 1.1 MPa
Tear resistance:	approx. 6 MPa
Working temperature:	+5 °C to +40 °C
Storage temperature:	+5 °C to +25 °C

¹ Normal climate 23/50-2 DIN 50014

Delivery types

Colour	Cartridge 290 ml (pack of 12)
Grey	816 805 000

¹ Normal climate 23/50-2 DIN 50014



Bostik Simson ISR 70-07

Pre-treatment products

Surface	Product / Packaging	Article No.
Closed, dirty Metals, bare, smooth/painted	Supergrip 5001 HR 1-litre tin	816 896 000
Powder-coated Moisture tolerant	Prep M 0.5-litre tin	816 890 000
PE, PP	Prep PP/PE 0.5-litre tin	850 498 000

Shelf life: 18 months after manufacture / Extended data sheet and safety data sheet available on request.

Bostik Supergrip Multi H551

One-component, elastic, moisture-curing sealant for bodywork, container and vehicle manufacture, metal and apparatus engineering, etc.



Benefits at a glance

- For primed and painted/lacquered metals, aluminium, timber, duroplastics and multiple thermoplastics
- Paintable wet in wet - after skin has formed
- Contains no isocyanates, silicone or solvents
- Broad range of adhesive applications
- Stable
- Low shrinkage ratio
- Harmless food contact material in acc. with EC 1935/2004
- Excellent moisture, weathering and UV resistance
- Temperature resistant from -40 °C to +100 °C

Technical specifications

Base:	One component, neutral curing silyl modified polymers
Colour:	White, grey, black
Viscosity:	Stable paste
Density:	approx. 1.5 g/cm ³ , DIN 52451-ST-U 26-23
Skin forming time:	approx. 15 min ¹
Rate of hardening:	3 mm (24h) ¹
Volume change:	< 3%, DIN 52 451-PY
Hardness:	Shore A 55, (DIN 53 505, 4 weeks ¹)
Breaking strain:	400%
Max. relative movement:	10% (relative to initial width of joint)
Tensile strength:	approx. 2.5 MPa
Working temperature:	+5 °C to +40 °C (component temp.)
Temperature resistance:	approx. -40 to +100
Storage temperature:	+5 °C to +25 °C

¹ Normal climate 23/50-2 DIN 50014

Delivery types

Colour	Cartridge 290 ml (pack of 12)
White	816 263 000
Grey	816 264 000
Black	816 265 000

Pre-treatment products

Surface	Product / Packaging	Article No.
Closed, dirty	Supergrip 5001 HR 1-litre tin	816 896 000
Metals, bare, smooth/painted		
Powder-coated, ABS, PVC	Prep M 0.5-litre tin	816 890 000

Shelf life: 18 months after manufacture / Extended data sheet and safety data sheet available on request.



Bostik Simson ISR 70-03

One-component, elastic, moisture-curing sealant/adhesive for bodywork, container and vehicle manufacture, metal and apparatus engineering, etc.



Benefits at a glance

- For primed and painted/lacquered metals, aluminium, wood, and duroplastics, thermoplastics
- Paintable wet in wet - after skin has formed
- Contains no isocyanates, silicone or solvents
- Extremely broad range of adhesion applications
- Good stability, spreadability
- Exceptionally low shrinkage ratio
- Can also be used as a (2-component) dual SMP
- Harmless food contact material in acc. with EC 1935/2004
- Excellent moisture, weathering and UV resistance
- Temperature resistant from -40 °C to +110 °C

Technical specifications

Base:	One-component silyl modified polymer, hardens in presence of moisture
Colour:	White, grey, black
Viscosity:	Stable paste
Density:	approx. 1.5 g/cm ³ , DIN 52451-PY
Skin forming time:	< 15 min ¹
Rate of hardening:	3 mm (on day 1) ¹
Volume change:	< 3%, DIN 52 451-PY
Hardness:	Shore A 58, DIN 53 505
Breaking strain:	250%, DIN 53504/ISO 37
Tensile strength:	approx. 2.9 MPa
Extension (100%):	approx. 2 MPa
Tear resistance:	approx. 16 MPa
Working temperature:	+5 °C to +40 °C
Storage temperature:	+5 °C to +25 °C

¹ Normal climate 23/50-2 DIN 50014



Delivery types

Colour	Cartridge 290 ml (pack of 12)	Foil pack 600 ml (pack of 12)
White	816 801 000	816 832 000
Grey	816 802 000	816 822 000
Black	816 803 000	816 808 000

Shelf life: 18 months after manufacture for cartridges; 12 months for tubular bags

For use as DUAL SMP in 400 ml foil packs, pack of 12 foil packs:

- White – Article No. 816 826 000
- Grey – Article No. 816 829 000
- Black – Article No. 816 824 000

Pre-treatment products

Surface	Product / Packaging	Article No.
Closed, dirty Metals, bare, smooth/painted	Supergrip 5001 HR 1-litre tin	816 896 000
Powder-coated Moisture-tolerant	Prep M 0.5 litre tin	816 890 000
PE, PP	Prep PP/PE 0.5 litre tin	850 498 000

Shelf life: 12 months after manufacture / Extended data sheet and safety data sheet available on request.

Bostik Simson ISR 70-03 FR

One-component, elastic, moisture-curing sealant/adhesive tested in compliance with DIN EN 45545-HL3, for railway vehicle manufacturing and mass transportation subject to fire protection regulations.



Benefits at a glance

- Oxygen index, smoke density, toxicity in acc. with EN 45545 - hazard class 3 (R22)
- For primed and painted/lacquered metals, aluminium, wood, duroplastics, and thermoplastics
- Contains no isocyanates, silicone or solvents
- Extremely broad range of adhesion applications
- Good stability, spreadability
- Exceptionally low shrinkage ratio
- Excellent moisture, weathering and UV resistance
- Temperature resistant from -40 °C to +100 °C

Technical specifications

Base:	One component, silyl modified polymer, hardens in presence of moisture
Colour:	Black
Viscosity:	Stable paste
Density:	approx. 1.4 g/cm ³ , DIN 52451-PY
Skin forming time:	< 10 min ¹
Rate of hardening:	3 mm (on day 1) ¹
Volume change:	< 3%, DIN 52 451-PY
Hardness:	Shore A 50, DIN 53 505
Breaking strain:	200%, DIN 53504/ISO 37
Tensile strength:	approx. 3.0 MPa
Extension (100%):	approx. 1.8 MPa
Tear resistance:	approx. 10 MPa
Working temperature:	+5 °C to +40 °C
Storage temperature:	+5 °C to +25 °C

¹ Normal climate 23/50-2 DIN 50014



Delivery types

Colour	Cartridge 290 ml (pack of 12)
Black	816 845 0000

Pre-treatment products

Surface	Product / Packaging	Article No.
Closed, dirty Metals, bare, smooth/painted	Supergrip 5001 HR 1-litre tin	816 896 000
Powder-coated Moisture tolerant	Prep M 0.5-litre tin	816 890 000
PE, PP	Prep PP/PE 0.5-litre tin	850 498 000

Shelf life: 12 months after manufacture / Extended data sheet and safety data sheet available on request.

Bostik Simson ISR 70-05 AP

Ring sensor

One-component, elastic, moisture-curing adhesive for bodywork, container and vehicle manufacture, metal and apparatus engineering, etc.



Benefits at a glance

- For primed and painted/lacquered metals, aluminium, wood, duroplastics, and thermoplastics
- Paintable wet in wet - after skin has formed
- Contains no isocyanates, silicone or solvents
- Extremely broad range of adhesion applications
- Good stability, spreadability
- Exceptionally low shrinkage ratio
- Excellent moisture, weathering and UV resistance
- Temperature resistant from -40 °C to +110 °C

Technical specifications

Base:	One component silyl modified polymer, hardens in presence of moisture
Colour:	White, grey, black
Viscosity:	Stable paste
Density:	approx. 1.5 g/cm ³ , DIN 52451-PY
Skin forming time:	< 15 min ¹
Rate of hardening:	3 mm (on day 1) ¹
Volume change:	< 3%, DIN 52 451-PY
Hardness:	Shore A 60, DIN 53 505
Breaking strain:	250%, DIN 53504/ISO 37
Shear strength:	2.4 MPa
E-module (100%):	5.5 MPa
Tear resistance:	approx. 16 MPa
Working temperature:	+5 °C to +40 °C
Storage temperature:	+5 °C to +25 °C

¹ Normal climate 23/50-2 DIN 50014



Delivery types

Colour	Cartridge 290 ml (pack of 12)	Foil pack 600 ml (pack of 12)
White	816 852 000	816 952 000
Grey	816 853 000	816 953 000
Black	816 854 000	816 954 000

Pre-treatment products

Surface	Product / Packaging	Article No.
Closed, dirty	Supergrip 5001 HR 1-litre tin	816 896 000
Metals, bare, smooth/painted		
Powder-coated	Prep M 0.5-litre tin	816 890 000
Moisture tolerant		
PE, PP	Prep PP/PE 0.5-litre tin	850 498 000

Shelf life: 12 months for Foil packs, 18 months for cartridges after manufacture / Extended data sheet and safety data sheet available on request.

Bostik Simson ISR 70-08 AP

One-component, elastic, moisture-curing adhesive for bodywork, container and vehicle manufacture, metal and apparatus engineering, etc.



Benefits at a glance

- For primed and painted/lacquered metals, aluminium, wood and duroplastics
- Paintable wet in wet - after skin has formed
- Contains no isocyanates, silicone or solvents
- Extremely broad range of adhesion applications
- Excellent stability, good wet strength, very good spreadability
- Low shrinkage ratio
- Can also be used as a (2-component) dual SMP
- Excellent moisture, weathering and UV resistance
- Temperature resistant from -40 °C to +110 °C

Technical specifications

Base:	One-component silyl modified polymer, hardens in presence of moisture
Colour:	Black
Viscosity:	Very stable paste, high wet strength
Density:	approx. 1.5 g/cm ³ , DIN 52451-PY
Skin forming time:	< 15 min ¹
Rate of hardening:	3 mm (on day 1) ¹
Volume change:	< 3%, DIN 52 451-PY
Hardness:	Shore A 57, DIN 53 505
Breaking strain:	180%, DIN53504/ISO 37
Shear strength:	2.4 MPa
E-module (100%):	5.5 MPa
Tear resistance:	approx. 16 MPa
Working temperature:	+5 °C to +40 °C
Storage temperature:	+5 °C to +25 °C

¹ Normal climate 23/50-2 DIN 50014



Delivery types

Colour	Cartridge 290 ml (pack of 12)	Foil pack 600 ml (pack of 12)
Black	816 828 000	816 811 000

For use as DUAL SMP in 400 ml foil packs, pack of 12:
Article No. 816 827 000

Pre-treatment products

Surface	Product / Packaging	Article No.
Closed, dirty Metals, bare, smooth/painted	Supergrip 5001 HR 1-litre tin	816 896 000
Powder-coated Moisture-tolerant	Prep M 0.5 litre tin	816 890 000
PE, PP	Prep PP/PE 0.5 litre tin	850 498 000

Shelf life: 12 months for Foil packs, 18 months for cartridges after manufacture / Extended data sheet and safety data sheet available on request.

Körpop Transparent / silver metallic

One-component, elastic, moisture-curing sealant for bodywork, container and vehicle manufacture, and metalwork, etc.



Benefits at a glance

- Seals all adhesive surfaces with a clear/transparent or silver coating
- Broad range of adhesive applications
- Silver metallic compliant to DIN 6022, RLT certified
- Harmless food contact material in acc. with EC 1935/2004
- Very resistant to humidity and weathering
- Temperature-resistant from -40 °C to +90 °C (and up to +120 °C for brief intervals)



Technical specifications

Base:	One-component silyl modified polymer, hardens in presence of moisture
Colour:	Clear/transparent, silver/alum. metallic
Viscosity:	Thin paste, spreadable and smoothable
Density:	approx. 1.05 g/cm ³ (depending on colour), DIN EN ISO 1183-11
Skin forming time:	10 - 15 min ¹
Rate of hardening:	3 mm (on day 1) ¹
Volume change:	1% weight change
Hardness:	Shore A 40, ISO 868 / DIN 53 505
Breaking strain:	approx. 290%, ISO 527 / DIN 53 504
Tensile strength:	3 N/mm ² , ISO 527 / DIN 53 504
Tear propagation resistance:	9 N/mm, ISO 34 / DIN 53 515
Building material class:	B2, DIN 4102 Part 1 + Part 4
Working temperature:	+15 °C to +35 °C
Storage temperature:	+5 °C to +25 °C

¹ Normal climate 23/50-2 DIN 50014

Delivery types

Colour	Cartridge 300 ml (pack of 12)
Körpop, transparent	870 935 000
Körpop, silver metallic	870 939 000

Shelf life: 12 months after manufacture

Pre-treatment products

Surface	Product / Packaging	Article No.
Closed, dirty	Körasolv PU 1-litre tin	870 812 000
General and powder-coated	Körasolv WL 1-litre tin	870 810 000
Metals, bare, smooth/painted	Körabond HG 81 1-litre tin	870 820 000
Open-pored, absorbent	Körabond HG 74 E 1-litre tin	870 821 000
ABS, PVC	Körabond HG 77 1-litre tin	870 822 000

Shelf life: 12 months after manufacture / Extended data sheet and safety data sheet available on request.

Dual SMP

Two component, solvent-free, elastic sealant and adhesive for bodywork, container and vehicle manufacture, and metalwork. Two component application from the Bostik ISR product range.



Benefits at a glance

- For primed and painted/lacquered metals, aluminium, glass, wood, and duroplastics and thermoplastics (PP, PE, PTFE with primer)
- Uniform curing/hardening due to 2 component technology
- Not moisture-dependent
- Paintable / sandable after curing
- Broad range of adhesive applications
- Very resistant to humidity and weathering

The Bostik Dual SMP is a two-component adhesive system from Bostik's ISR range. The use of specially designed application tools and a B component also enable high-viscosity SMP-based adhesives to cure uniformly.

A components are available in 400 ml foil packs. Please consult the ISR types (ISR 70-03, ISR 70-08).

System components

Item	Article No.
Dual SMP 400P applicator gun / pneumatic	845 115 000
Simson static mixer (pack of 12)	860 112 000
Inner A tube (spare/consumable part for SMP 400 P) (pack of 1)	845 115 001
Simson B component 10,5 ml (pack of 12)	816 851 000

Shelf life: 12 months after manufacture / Extended data sheet and safety data sheet available on request.

Pre-treatment products

Surface	Product / Packaging	Article No.
Closed, dirty	Supergrip 5001 HR 1-litre tin	816 896 000
Metals, bare, smooth/painted		
Powder-coated	Prep M 0.5-litre tin	816 890 000
Moisture tolerant		
PE, PP	Prep PP/PE 0.5-litre tin	850 498 000

Shelf life: 12 months after manufacture / Extended data sheet and safety data sheet available on request.

Körpop 225 - 2-C

Two-component, solvent-free, elastic adhesive and sealant for bodywork, container and vehicle manufacture, the metalworking, ventilation and air-conditioning industries.



Benefits at a glance

- For primed and painted/lacquered metals, aluminium, glass, wood, duroplastics, and thermoplastics (except PP, PE, PTFE)
- Uniform curing/hardening
- Paintable / sandable after curing
- Broad range of adhesive applications
- Very resistant to humidity and weathering
- Temperature-resistant from -40 °C to +90 °C (and up to +120 °C for brief intervals)

Technical specifications

Base:	Silyl terminated polymer, solvent-free
Colour:	White, black
Viscosity:	Stable paste, spreadable and smoothable
Density:	A comp. 1.44 g/cm ³ (depending on colour), DIN EN ISO 1183-11 B comp. 1.49 g/cm ³ (depending on colour), DIN EN ISO 1183-11
Pot life:	approx. 20 min. ¹
Breaking strain:	450%, ISO 527 / DIN 53 504
Tensile strength:	2.6 N/mm ² , ISO 527 / DIN 53 504
Tear propagation resistance:	18 N/mm, ISO 34 / DIN 53 515
Working temperature:	+15 °C to +35 °C
Storage temperature:	+5 °C to +25 °C

¹ Normal climate 23/50-2 DIN 50014



Pre-treatment products

Colour	Dual cartridge 490 ml (pack of 6) excl. static mixer	Dual cartridge 220 ml (pack of 8) incl. static mixer
White	870 933 000	870 932 000
Grey		870 929 000
Black	870 934 000	870 928 000

Shelf life: 3 months after manufacture / Extended data sheet and safety data sheet available on request.

Pre-treatment products

Surface	Product / Packaging	Article No.
Closed, dirty	Körasolv PU 1-litre tin	870 812 000
General and powder-coated	Körasolv WL 1-litre tin	870 810 000
Metals, bare, smooth/painted	Körabond HG 81 1-litre tin	870 820 000
Open-pored, absorbent	Körabond HG 74 E 1-litre tin	870 821 000
ABS, PVC	Körabond HG 77 1-litre tin	870 822 000

Shelf life: 12 months after manufacture / Extended data sheet and safety data sheet available on request.

Dispensing tools

Pneumatic hand tool for 490 ml container

- **Article No. 845 149 000**

Static mixer for 490 ml cartridge

- **Article No. 870 715 000**

Pneumatic hand tool for 220 ml container

- **Article No. 845 118 000**

Static mixer for 220 ml cartridge

- **Article No. 870 711 000**

Facts about 1-C methacrylate adhesives

Pre-treating substrates

For best results, the parts to be installed should first be degreased and cleaned with e.g. Körasolf GL Article No. 870 815 000 or IPA. Weicon Lock can also be used on uncleaned surfaces, however, e.g. on screws in their originally delivered condition. General guideline: the cleaner the surface, the better the adhesion.

Processing

Apply Weicon Lock directly and evenly through the tip of the bottle, making sure that the tip does not come into direct contact with any metal. Always apply to both mating surfaces if joining crimp connections or larger components. For blind hole applications, fill the drill holes with sufficient amounts of Weicon Lock. For screws and bolts, apply in a ring shape. Never pour Weicon Lock back into the bottle once it has come into contact with metal. Even the tiniest amount of metal can cause the contents inside the bottle to cure and harden. For series production, we recommend the use of dosing equipment. Process at a room temperature of between 5 °C and 35 °C.

Storage, transport and safety regulations

Weicon Lock has a shelf life of at least one year if stored in its original sealed container at 20 °C. Store away from heat and direct sunlight. The air inside the bottle keeps the Weicon Lock liquid.

Transport class not applicable.

Weicon Lock does not generally cause an allergic skin reaction. It does, however, contain small amounts of an irritant which may cause a sensitive skin reaction if it comes into excessive contact with the skin. Constant direct contact with the skin should therefore be avoided, e.g. by wearing suitable protective gloves. EC safety data sheets are available on request for professional users.

Weicon Lock AN 302-43

Medium-strength adhesive for threadlocking steel and copper materials



Benefits at a glance

- Medium-strength, anaerobic adhesive for active metal surfaces
- Suitable for low-alloy steel, copper and brass screws and bolts
- Universal threadlocking, medium-strength
- Higher viscosity
- Colour: blue
- Normal to remove

Technical specifications

For threaded fasteners up to size	M 36
Viscosity at 25 °C, Brookfield	1000 mt mPa*s
Max. gap filling capacity	0.20 mm
Breakaway torque Nm (thread)	14 - 18 Nm
Residual torque Nm (thread)	5 - 8 Nm
Shear strength N/mm ² (DIN 54452)	8 - 12 N/mm ²
Fixture time at room temperature	10 - 20 min.
Final strength at room temperature	3 - 6 h
Temperature resistance	-60 °C to +150 °C



Delivery types

Colour	Dose area 50 ml
Blue	880 800 100

Pre-treatment products

All surfaces	Product / Packaging	Article No.
	Körasolv GL 1-litre tin	870 815 000

Weicon Lock AN 302-60

High-strength adhesive for threadlocking steel and copper materials



Benefits at a glance

- Medium-strength, anaerobic adhesive for active metal surfaces
- Suitable for all screws and bolts
- High-strength threadlocking, medium-strength
- Medium viscosity
- Colour: green
- Hard to remove

Technical specifications

For threaded fasteners up to	M 20 or ¾"
Viscosity at 25 °C, Brookfield	700 - 1000 mt mPa*s
Max. gap filling capacity	0.50 mm
Breakaway torque Nm (thread)	30 - 35 Nm
Residual torque Nm (thread)	55 - 70 Nm
Shear strength N/mm ² (DIN 54452)	25 - 35 N/mm ²
Fixture time at room temperature	2 - 5 min.
Final strength at room temperature	2 - 4 h
Temperature resistance	-60 °C to +180 °C



Delivery types

Colour	Dose area 50 ml
Green	880 810 100

Pre-treatment products

All surfaces	Product / Packaging	Article No.
	Körasolv GL 1-litre tin	870 815 000

Dekaseal 8869

One component, plastic elastic, removable sealant for bodywork, container and vehicle manufacture and metalworking, etc.

Benefits at a glance

- For untreated, primed and painted/varnished metals, aluminium, timber and duroplastics
- Can be painted after curing
- RLT certified to VDI 6022
- Broad range of adhesive applications
- Good weather resistance
- Temperature-resistant from -30 °C to +100 °C

Technical specifications

Base:	Synthetic rubber, contains solvents
Colour:	Grey
Viscosity:	Viscous paste, approx. 80000 MPa
Density:	approx. 1.7 g/cm ³ (depending on colour), DIN EN ISO 1183-11
Solids content:	80%
Volume change:	6%, DIN 52 451
Danger classification:	A1, highly inflammable
Working temperature:	+15 °C to +35 °C
Storage temperature:	+5 °C to +25 °C

¹ Normal climate 23/50-2 DIN 50014

Delivery types

Colour	Cartridge 300 ml (pack: of 12)
Grey	812 110 000

Shelf life: 6 months after manufacture

Pre-treatment products

Surfaces	Product / Packaging	Article No.
Closed, dirty	Körasolv PU 1-litre tin	870 812 000
General and powder-coated	Körasolv WL 1-litre tin	870 810 000

Shelf life: 12 months after manufacture / Extended data sheet and safety data sheet available on request.

DEKALIN



Bostik construction silicone

One component, elastic, universal sealant for the entire construction industry as well as bodywork and container manufacture and metalworking, etc.



Benefits at a glance

- For all surfaces except PP, PE and PTFE
- Can be painted after curing
- Low odour
- Very broad range of adhesive applications
- Very weather-resistant
- Temperature-resistant from -60 °C to +150 °C

Technical specifications

Base:	Silicone rubber, one component
Colour:	Clear, coloured
Rigidity:	Rigidity < 2 mm
Density:	approx. 1.0 -1.05 g/cm ³ (depending on colour), DIN EN ISO 1183-11
Skin forming time:	approx. 15 min.
Rate of hardening:	approx. 5 mm/week
Volume change:	6.5 - 8.5%
Relative movement:	25%
Hardness:	Shore A approx.18 for clear, approx. 30 for coloured
Working temperature:	+5 °C to +40 °C
Storage temperature:	+5 °C to +25 °C

¹ Normal climate 23/50-2 DIN 50014



Delivery types

Colour	Cartridge 300 ml (pack of 20)	Foil pack 600 ml (pack of 20)
Clear	816 450 000	
Grey		816 455 000
Black	816 456 000	
Brown	816 458 000	816 459 000

Shelf life: 6 months after manufacture

Pre-treatment products

Surface	Product / Packaging	Article No.
Closed, dirty, general and powder-coated	Solvent 270 1-litre tin	830 422 000

Shelf life: 12 months after manufacture / Extended data sheet and safety data sheet available on request.

Bostik sanitary silicone

One component, elastic universal sealant for the entire sanitary industry as well as the building sector, container manufacture and apparatus engineering, etc.



Benefits at a glance

- For all surfaces except PP, PE and PTFE
- Sticks securely to surfaces, with no priming required
- Anti-fungal (deters fungal growth)
- Very broad range of adhesive applications
- Very weather-resistant
- Not compatible with paint, not to be used on bare metals
- Temperature-resistant from -60 °C to +150 °C

Technical specifications

Base:	Silicone rubber, one component, acetic
Colour:	Clear, coloured
Rigidity:	Rigidity < 1 mm
Density:	approx. 1.0 -1.05 g/cm ³ (depending on colour), DIN EN ISO 1183-11
Skin forming time:	approx. 12 min.
Rate of hardening:	approx. 7 mm/week
Volume change:	4.8%
Relative movement:	25%
Hardness:	Shore A approx.18 for clear, approx. 30 for coloured
Working temperature:	+5 °C to +40 °C
Storage temperature:	+5 °C to +25 °C

[†] Normal climate 23/50-2 DIN 50014



Delivery types

Colour	Cartridge 300 ml (pack of 20)	Foil pack 600 ml (pack of 20)
Clear	816 443 000	

Shelf life: 12 months after manufacture

Pre-treatment products

Surface	Product / Packaging	Article No.
Closed, dirty, general and powder-coated	Solvent 270 1-litre tin	830 422 000

Shelf life: 12 months after manufacture / Extended data sheet and safety data sheet available on request.

Bostik Nibosil 3057 HT

One component, elastic, high-temperature sealant for heating, furnace, ventilation, apparatus and mechanical engineering, etc.



Benefits at a glance

- For all surfaces except PP, PE and PTFE
- Sticks securely to uncoiled surfaces, with no priming required
- Very broad range of adhesive applications; not to be used on zinc or non-ferrous metals
- Not compatible with paint
- Temperature resistant from -40 °C to +200 °C,
- up to 250 °C for brief intervals

Technical specifications

Base:	Silicone rubber, one component, acetic
Colour:	Red
Rigidity:	Rigidity < 1 mm
Density:	approx. 1.3 g/cm ³ , DIN EN ISO 1183-11
Skin forming time:	approx. 30 min.
Rate of hardening:	approx. 7 mm/week
Volume change:	-3%
Relative movement:	approx. 20%
Working temperature:	+5 °C to +40 °C
Storage temperature:	+5 °C to +25 °C

¹ Normal climate 23/50-2 DIN 50014



Delivery types

Colour	Cartridge 300 ml (pack of 20)	Foil pack 600 ml (pack of 20)
Red	816 449 000	

Shelf life: 6 months after manufacture

Pre-treatment products

Surface	Product / Packaging	Article No.
Closed, dirty, general and powder-coated	Solvent 270 1-litre tin	830 422 000

Shelf life: 12 months after manufacture / Extended data sheet and safety data sheet available on request.

Köditec 114

One component, elastic, high-temperature sealant for heating, furnace, ventilation, apparatus and mechanical engineering, etc.



Benefits at a glance

- For all surfaces except PP, PE and PTFE
- Sticks securely to unoiled surfaces, with no priming required
- Very broad range of adhesive applications; not to be used on zinc or non-ferrous metals
- Very high oil and coolant resistance
- Not compatible with paint
- Temperature resistant from -40 °C to +250 °C, – up to 350 °C for brief intervals

Technical specifications

Base:	Silicone rubber, one component, acetic
Colour:	Anthracite
Rigidity:	Rigidity < 2 mm
Density:	approx. 1.3 g/cm ³ , DIN EN ISO 1183-11
Skin forming time:	approx. 5 min.
Tensile strength:	2.6 MPa
Elongation at break:	300%
Hardness:	Shore A approx. 50
Working temperature:	+5 °C to +40 °C
Storage temperature:	+5 °C to +30 °C

Delivery types

Colour	Cartridge 300 ml (pack of 20)
Anthracite	870 944 000

Shelf life: 12 months after manufacture

Pre-treatment products

Surface	Product / Packaging	Article No.
Closed, dirty, general and powder-coated	Solvent 300 1-litre tin	830 429 000

Shelf life: 12 months after manufacture / Extended data sheet and safety data sheet available on request.

Körplast SF

Solvent-containing, PU-based contact adhesive for soft and rigid PVC

Benefits at a glance

- Especially suited for cover strips for PVC hard/soft seals in the automotive industry
- For repairing PVC tarpaulins and foils
- Contact adhesive for PUR, ABS, rubber and leather
- Broad range of adhesive applications
- Non-bleaching
- Very resistant to humidity and weathering
- Applies directly from the tube



Technical specifications

Base:	Polyurethane, contains solvents
Colour:	Clear
Viscosity:	2700 MPa x s (at 20 °C)
Density:	0.9 g/cm ³
Application temperature:	-30 °C to +70 °C
Flash point when liquid:	-17 °C
Consumption:	approx. 150 - 200 g/m ²
Working temperature:	> +18 °C
Storage temperature:	> +10 °C

¹ Normal climate 23/50-2 DIN 50014

Use Körasolv PU to remove loose adhesive residue

Delivery types

Colour	Metal tube 60 g (pack: of 1)
Clear	820 200 000

Pre-treatment products

Surface	Product / Packaging	Article No.
Closed, dirty, general and powder-coated	Körasolv PU 1-litre tin	870 812 000

Shelf life: 12 months after manufacture / Extended data sheet and safety data sheet available on request.

PVC foam tape 3257/3259

PVC foam tape made of medium-hard, closed-cell foam, with a single-sided acrylic adhesive coat. Air and water-tight.

Benefits at a glance

- Strong paper release liner on outer side
- Watertight at 30% compression
- Fast-acting, no securing required
- Frostproof due to low water absorption
- Permanent, rot resistant
- Cushioning

Technical specifications

Raw density:	160 kg/m ³
Colour:	Light grey, anthracite black
Required compression:	30%
Restoring force:	97%
Adhesion:	13 N/25 mm after 24 h
Tensile strength:	45 N/cm ²
Elongation at break:	120%
UV resistance:	Good
Chemical resistance:	Good on diluted acids and alkalis
Temperature range:	- 30 °C to +70 °C
Fire rating:	B2 based on DIN 4102
Hardness:	25 Shore A
Force required to compress:	4 N/cm ²



Delivery types

Dimensions Thickness x Width [mm]	Length per roll [m]	Article No. Grey 3257 (Sold per roll)	Article No. Black 3259 (Sold per roll)
1.5 x 15	50	815 215 000	815 200 000
1.5 x 20	50	815 216 000	815 201 000
1.5 x 25	50	815 225 000	815 202 000
1.5 x 30	50	815 230 000	815 203 000
1.5 x 35	50	815 231 000	815 204 000
1.5 x 40	50	815 232 000	815 205 000
3.0 x 15	25	815 235 000	815 206 000
3.0 x 20	25	815 239 000	815 207 000
3.0 x 25	25	815 240 000	815 208 000
3.0 x 30	25	815 245 000	815 209 000
3.0 x 35	25	815 246 000	815 210 000
3.0 x 40	25	815 250 000	815 211 000
3.0 x 50	25	815 255 000	815 212 000
3.0 x 70	25	815 260 000	815 213 000
4.5 x 15	15	815 251 000	815 295 000
4.5 x 20	15	815 252 000	815 281 000
4.5 x 25	15	815 253 000	815 283 000
4.5 x 30	15	815 254 000	815 296 000
4.5 x 35	15	815 256 000	815 285 000
4.5 x 40	15	815 257 000	815 284 000
6.0 x 15	12	815 258 000	815 289 000
6.0 x 20	12	815 259 000	815 290 000
6.0 x 25	12	815 261 000	815 291 000
6.0 x 30	12	815 262 000	815 292 000
6.0 x 35	12	815 263 000	815 293 000
6.0 x 40	12	815 264 000	815 294 000

Pre-treatment products

All surfaces	Product / Packaging	Article No.
	Körasolv GL 1-litre tin	870 815 000

Shelf life: 12 months after manufacture / Extended data sheet and safety data sheet available on request.

PVC foam tape 3507/3509

PVC foam tape made of hard, closed-cell foam, with a single-sided acrylic adhesive coat. Air and watertight.

Benefits at a glance

- Strong paper release liner on outer side
- Watertight at 30% compression
- Fast-acting, no securing required
- Frostproof due to low water absorption
- Permanent, rot resistant
- Cushioning
- Very durable

Technical specifications

Raw density:	260 kg/m ³
Colour:	Light grey, anthracite black
Required compression:	30%
Restoring force:	95%
Adhesion:	13 N/25 mm after 24 h
Tensile strength:	90 N/cm ²
Elongation at break:	150%
UV resistance:	Good
Chemical resistance:	Good on diluted acids and alkalis
Temperature range:	- 30 °C to +70 °C
Fire rating:	B2 based on DIN 4102
Hardness:	50 Shore A
Force required to compress:	8 N/cm ²



Delivery types

Dimensions Thickness x Width [mm]	Length per roll [m]	Article No. Grey 3507 (Sold per roll)	Article No. Black 3509 (Sold per roll)
0.8 x 15	60	815 301 000	815 351 000
0.8 x 20	60	815 302 000	815 352 000
0.8 x 25	60	815 303 000	815 353 000
0.8 x 30	60	815 304 000	815 354 000
0.8 x 35	60	815 305 000	815 355 000
0.8 x 40	60	815 306 000	815 356 000
1.5 x 15	50	815 311 000	815 361 000
1.5 x 20	50	815 312 000	815 362 000
1.5 x 25	50	815 313 000	815 363 000
1.5 x 30	50	815 314 000	815 364 000
1.5 x 35	50	815 315 000	815 365 000
1.5 x 40	50	815 316 000	815 366 000
3.0 x 15	25	815 321 000	815 371 000
3.0 x 20	25	815 322 000	815 372 000
3.0 x 25	25	815 323 000	815 373 000
3.0 x 30	25	815 324 000	815 374 000
3.0 x 35	25	815 325 000	815 375 000
3.0 x 40	25	815 326 000	815 376 000
4.5 x 15	15	815 331 000	815 381 000
4.5 x 20	15	815 332 000	815 382 000
4.5 x 25	15	815 333 000	815 383 000
4.5 x 30	15	815 334 000	815 384 000
4.5 x 35	15	815 335 000	815 385 000
4.5 x 40	15	815 336 000	815 386 000
6.0 x 15	12	815 341 000	815 391 000
6.0 x 20	12	815 342 000	815 392 000
6.0 x 25	12	815 343 000	815 393 000
6.0 x 30	12	815 344 000	815 394 000
6.0 x 35	12	815 345 000	815 395 000
6.0 x 40	12	815 346 000	815 396 000

Pre-treatment products

All surfaces	Product / Packaging	Article No.
	Körasolv GL 1-litre tin	870 815 000

Shelf life: 12 months after manufacture / Extended data sheet and safety data sheet available on request.

Rubber resin adhesive tape 0485

Solvent-free, flexible, extruded, strong, double-sided adhesive transfer tape



Benefits at a glance

- Tape complete with rigid backing film
- Aids installation/assembly jobs (3rd hand)
- Sticks very aggressively; pressure-sensitive adhesive
- Non-hardening, permanently elastic
- Permanent, rot resistant
- Very ductile

Technical specifications

Raw density:	0.98 g/cm ³
Colour:	Amber, cloudy/clear
Adhesion:	200 N/25 mm
Dyn. tensile strength:	50 N/cm ²
Elongation at break:	1000%
UV resistance:	Little; store in a dark place
Chemical resistance:	Not oil or solvent resistant
Temperature range:	-10 °C to +60 °C
Fire rating:	B2 based on DIN 4102



Delivery types

Dimensions Thickness x Width [mm]	Metres per roll	Article No. Amber (Sold per roll)
0.4 x 12	30	815 661 000
0.4 x 19	30	815 662 000
0.4 x 25	30	815 663 000
1.0 x 12	20	815 664 000
1.0 x 19	20	815 665 000
1.0 x 25	20	815 666 000

Pre-treatment products

Surface	Product / Packaging	Article No.
Closed, dirty, general and powder-coated	Solvent 270 1-litre tin	830 422 000

Shelf life: 12 months after manufacture / Extended data sheet and safety data sheet available on request.

Clear 50 / 100

Core consists of closed-cell acrylic foam carrier, coated on both sides with aggressively adhesive acrylic foam; very good mechanical and thermal properties

3M



Benefits at a glance

- Tape complete with rigid backing film
- Exceptional adhesion
- Exceptional resistance to weathering
- Very UV stable
- Sticks very aggressively; pressure-sensitive adhesive
- Permanent, rot resistant
- Very dimensionally stable

Technical specifications

Peel strength 90° angle (alum./glass):

50 – 60 N/cm based on ASTM D-3330

Peel strength 90° angle (alum./polycarb.):

17 – 18 N/cm based on ASTM D-3330

Peel strength 90° angle (alum./PMMA):

21 N/cm based on ASTM D-3330

Static shear strength with glass:

10000 min. based on ASTM D-3654/D-3654M

Static shear strength with polycarb.:

4000 min. based on ASTM D-3654/D-3654M

Static shear strength with PMMA:

7000 min. based on ASTM D-3654/D-3654M

Temperature resistance:

140 °C based on ASTM D-3654/D-3654M

Delivery types

Dimensions Thickness x Width [mm]	Metres per roll	Article No. Clear with white liner (Sold per roll)
0.5 x 6	66	815 596 000
0.5 x 8	66	815 608 001
0.5 x 12	66	815 601 001
0.5 x 19	66	815 610 000
1.0 x 12	33	815 604 001
1.0 x 16	33	815 607 001
1.0 x 19	33	815 605 001
1.0 x 25	33	815 606 001

Pre-treatment products

All surfaces	Product / Packaging	Article No.
	Körasolv GL 1-litre tin	870 815 000

Shelf life: 12 months after manufacture / Extended data sheet and safety data sheet available on request.

PE foam adhesive tape 5464

PE foam tape comprising closed-cell foam, coated on both sides with acrylic adhesive. With paper release liner.



Benefits at a glance

- Good adhesion
- UV-resistant
- Low-cost, quick and easy to apply
- Long-lasting adhesion
- Universal use

Technical specifications

Raw density:	70 kg/m ³
Colour:	White
Adhesion:	23 N/25 mm after 24 h
Static shear strength:	4.8 N/cm ² after 500 h
Tensile strength:	100 N/cm ²
Elongation at break:	> 150%
UV resistance:	Good
Chemical resistance:	Good on diluted acids and alkalis
Temperature range:	- 40 °C to +80 °C
Fire rating:	B2 based on DIN 4102



Delivery types

Dimensions	Metres per roll	Article No.
Thickness x Width		White
[mm]		(Sold per roll)
1.0 x 12	60	815 631 000
1.0 x 19	60	815 632 000
1.0 x 25	60	815 633 000
2.0 x 12	30	815 634 000
2.0 x 19	30	815 635 000
2.0 x 25	30	815 636 000

Pre-treatment products

All surfaces	Product / Packaging	Article No.
	Körasolv GL 1-litre tin	870 815 000

Shelf life: 12 months after manufacture / Extended data sheet and safety data sheet available on request.

PE foam adhesive tape 5474

PE foam tape comprising closed-cell foam, coated on both sides with cross-linked synthetic resin-based adhesive. With paper release liner.



Benefits at a glance

- Aggressive adhesion
- Very fast adhesion build-up, including on low-energy surfaces
- Low-cost, quick and easy to apply
- Long-lasting adhesion
- Universal use

Technical specifications

Raw density:	67 kg/m ³
Colour:	White
Adhesion:	27 N/25 mm after 24 h
Static shear strength:	7 N/cm ² after 500 h
Dynamic shear strength:	41 N/cm ²
Tensile strength:	100 N/cm ²
Elongation at break:	> 150%
UV resistance:	Good
Chemical resistance:	Good on diluted acids and alkalis
Temperature range:	- 40 °C to +70 °C
Working temperature:	+15 °C to +40 °C



Delivery types

Dimensions Thickness x Width [mm]	Metres per roll	Article No. White (Sold per roll)
1.0 x 12	60	815 621 000
1.0 x 19	60	815 622 000
1.0 x 25	60	815 623 000
2.0 x 12	30	815 624 000
2.0 x 19	30	815 625 000
2.0 x 25	30	815 626 000

Pre-treatment products

All surfaces	Product / Packaging	Article No.
	Körasolv GL 1-litre tin	870 815 000

Shelf life: 12 months after manufacture / Extended data sheet and safety data sheet available on request.

Butyl sealing tape 0316

Extruded butyl tape with UV-resistant aluminium foil, laminated, single-sided adhesive tape.

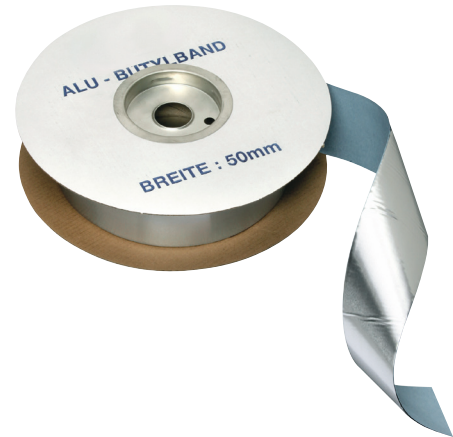


Benefits at a glance

- Easy to work with
- Very good adhesion on all surfaces
- Mathematical gas proofness as of 50 mm width
- Completely UV and weather resistant

Technical specifications

Density:	1.58 kg/cm ³
Colour:	Silver-grey
Adhesion:	Very good
UV resistance:	Excellent
Water absorption:	None
Chemical resistance:	Good on diluted acids and alkalis
Temperature range:	- 40 °C to +80 °C
Working temperature:	+10 °C to +40 °C



Delivery types

Dimensions	Metres per roll	Article No.
Thickness x Width		
[mm]		(Sold per roll)
1.5 x 40	20	817 721 000
1.5 x 50	20	817 722 000
1.5 x 60	20	817 723 000
1.5 x 80	20	817 724 000

Pre-treatment products

All surfaces	Product / Packaging	Article No.
	Körasolv GL 1-litre tin	870 815 000

Shelf life: 12 months after manufacture / Extended data sheet and safety data sheet available on request.

Bostik Prestik AE 3301

Extruded butyl-based round strip for sealing plastics that cannot be subject to mechanical loads. For indoor and outdoor use; removeable.



Benefits at a glance

- Easy to work with
- Very good adhesion on all surfaces
- Easy to remove
- Self-blotting
- Non-shrinking; age and weather resistant
- Prevents contact corrosion
- Sound and vibration damping

Technical specifications

Compound:	Synthetic rubber (polyisobutyl)
Density:	1.75 kg/cm ³
Colour:	Grey
Adhesion:	Very good
UV resistance:	Excellent
Water absorption:	None
Chemical resistance:	Good on diluted acids and alkalis
Temperature range:	- 30 °C to +90 °C
Working temperature:	+10 °C to +40 °C



Delivery types

Cross-section [mm]	Length per roll [m]	Packaging unit Rolls	Article No. Light grey
ø 6	120	3	817 818 000

Pre-treatment products

All surfaces	Product / Packaging	Article No.
	Körasolv GL 1-litre tin	870 815 000

Shelf life: 12 months after manufacture / Extended data sheet and safety data sheet available on request.

Bostik Prestik putty seal

Bostik Prestik putty seal for sealing plastics that cannot be subjected to mechanical loads. For indoor and outdoor use; removeable.



Benefits at a glance

- Easy manual application
- Very good adhesion on all surfaces
- Easy to remove
- Self-blotting
- Non-shrinking; age and weather resistant
- Prevents contact corrosion
- Sound and vibration damping



Technical specifications

Compound:	Synthetic rubber (polyisobutyl)
Density:	1.6 kg/cm ³
Colour:	Blue-grey
Adhesion:	Very good
UV resistance:	Excellent
Water absorption:	None
Shrinkage:	None
Chemical resistance:	Good on diluted acids and alkalis
Temperature range:	- 30 °C to +90 °C
Working temperature:	+10 °C to +40 °C

Delivery types

Colour	Packet 250 g (20 per carton)	Packet 1000 g (16 per carton)
Blue-grey	818 376 000	818 336 000

Pre-treatment products

All surfaces	Product / Packaging	Article No.
	Körasolv GL 1-litre tin	870 815 000

Shelf life: 12 months after manufacture / Extended data sheet and safety data sheet available on request.

Multifoil Safety Treat

Multifoil Safety Treat is an acrylic adhesive tape coated with a sharp-edged corundum grain structure.

Benefits at a glance

- Maximum anti-slip resistance of "R 13" based on DIN 51130
- Very easy to install
- Very clean application
- Waterproof and weatherproof
- Flexible
- UV-resistant

Technical specifications

Compound:	Acrylic adhesive tape
Thickness:	1.2 mm
Colour:	Anthracite
Adhesion:	Very good
UV resistance:	Excellent
Water absorption:	None
Shrinkage:	None
Chemical resistance:	Good on diluted acids and alkalis
Temperature range:	- 30 °C to +100 °C
Working temperature:	+10 °C to +40 °C

Delivery types

Dimensions Width in [mm]	Metres per roll	Article No. Roll
50	18	815 810 000
100	18	815 811 000
300	18	815 812 000
400	18	815 813 000

Pre-treatment products

All surfaces	Product / Packaging	Article No.
	Körasolv GL 1-litre tin	870 815 000

Shelf life: 12 months after manufacture / Extended data sheet and safety data sheet available on request.

Bostik Marothaan

Self-levelling 2-C polyurethane floor finish with a high relative movement, for use in commercial vehicle construction. Available in various versions, ranging from smooth/glossy to decorative and very coarse and non-slip. Can be applied to wood, steel, VA steel, zinc, aluminium, etc.



Benefits at a glance

- Low weight per m²
- Very elastic, 50% elongation at break
- Contains no solvents or plasticisers
- Easy to apply
- Self-levelling
- Customised designs possible
- Can be used in areas in close proximity to food (ISEGA)
- High chemical resistance
- Sound-absorbing
- No joints, waterproof but vapour diffusing
- Non-conductive
- Cargo control floor: coefficient of friction proven to be > 0.60 μ



Technical specifications

Base:	Polyurethane
Colour:	Grey, similar to RAL 7023
Viscosity:	Pourable
Density:	1.54 g/cm ³
Application temperature:	- 40 °C to +90 °C
Consumption:	per 1 mm layer thickness 1.54 kg/m ²
Curing time:	Walkable after approx. 7 h
Pot life:	approx. 55 min.
Hardness:	Shore A 98, Shore D 70
Mixing ratio:	100/22.5 weight ratio, 100/31 volume ratio
Working temperature:	+1 °C to +30 °C
Storage temperature:	+5 °C to +25 °C

Delivery types

Product	Form of supply/Weight	Article No.
Marothaan A comp.	Tin 10 kg	830 260 000
Hardener 4300 B	Tin 2.34 kg	830 264 000
Marothaan B comp.	Tin 5 kg	830 261 000
Hardener 4300 B	Tin 1.17 kg	830 262 000

Shelf life: 12 months after manufacture / Extended data sheet and safety data sheet available on request.

Detailed installation instructions for all listed versions available separately on request.

Items highlighted in the same colour refer to 'A' and 'B' components that are always required together.

Primer

Product	Form of supply/Weight	Article No.
Primer 209 A	Tin 5 kg	830 215 000
Hardener 4300 B	Tin 1.17 kg	830 262 000

Granules

Description	Form of supply/Weight	Article No.
Mandurax granules, fine 0.7 - 1.2 mm	Sack 25 kg	830 210 000
Mandurax granules, coarse 1.0 - 2.0 mm	Sack 25 kg	830 211 000
Coloured flakes for spreading, white	Tin 0.5 kg	830 235 009
Coloured flakes for spreading, black	Tin 0.5 kg	830 235 010
Coloured flakes for spreading, English red	Tin 0.5 kg	830 235 003
Coloured flakes for spreading, royal blue	Tin 0.5 kg	830 235 004
Coloured flakes for spreading, grass green	Tin 0.5 kg	830 235 007
Coloured flakes for spreading, grey	Tin 0.5 kg	830 235 008

Other colours available on request.

Sealer

Description	Form of supply/Weight	Article No.
Sealer		
UV protective sealer, gloss	Canister 4 kg	830 297 000
Marotop sealer, RAL 7023, A comp.	Tin 2.2 kg	830 263 000
Hardener 4300 B	Tin 1.17 kg	830 262 000
Marocoat silica sand sealer, A comp.	Tin 3.0 kg	830 220 000
Marocoat hardener	Tin 0.75 kg	830 221 000

Shelf life: 12 months after manufacture / Extended data sheet and safety data sheet available on request.

Detailed installation instructions for all listed versions available separately on request.

Items highlighted in the same colour refer to 'A' and 'B' components that are always required together.

Körapur 689

Self-levelling 2-C polyurethane floor finish with a high relative movement, for use in commercial vehicle construction. Available in various versions, ranging from smooth/glossy to decorative and very coarse and non-slip. Can be applied to wood, steel, VA steel, zinc, aluminium, etc.



Benefits at a glance

- Low weight per m²
- Contains no solvents or plasticisers
- Easy to apply
- Self-levelling
- Customised designs possible
- Can be used in areas in close proximity to food (ISEGA)
- High chemical resistance
- Sound-absorbing
- No joints, waterproof but vapour diffusing
- Non-conductive
- Cargo control floor: coefficient of friction proven to be > 0,60 μ



Technical specifications

Base:	Polyurethane
Colour:	Grey, similar to RAL 7037
Viscosity:	Pourable
Density:	1.54 g/cm ³
Application temperature:	- 40 °C to +90 °C
Consumption:	per 1 mm layer thickness - 1.4 kg/m ²
Curing time:	Walkable after approx. 9 h
Pot life:	approx. 90 min.
Mixing ratio:	4/1 weight ratio, 3.3/1 volume ratio
Working temperature:	+1 °C to +30 °C
Storage temperature:	+5 °C to +25 °C

Delivery types

Product	Form of supply/Weight	Article No.
Körapur 689 A comp.	Tin 12 kg	830 135 000
Körapur 689 B comp. (TH240)	Tin 3 kg	830 136 000

Shelf life: 12 months after manufacture / Extended data sheet and safety data sheet available on request.

Primer

Product	Form of supply/Weight	Article No.
Primer BS 85 A+B comp.	Tin 5 kg	830 132 000

Items highlighted in the same colour refer to 'A' and 'B' components that are always required together.

Granules

Description	Form of supply/Weight	Article No.
Mandurax granules, fine 0.7 - 1.2 mm	Sack 25 kg	830 210 000
Mandurax granules, coarse 1.0 - 2.0 mm	Sack 25 kg	830 211 000
Coloured flakes for spreading, white	Bucket 0.5 kg	830 235 009
Coloured flakes for spreading, black	Bucket 0.5 kg	830 235 010
Coloured flakes for spreading, English red	Bucket 0.5 kg	830 235 003
Coloured flakes for spreading, royal blue	Bucket 0.5 kg	830 235 004
Coloured flakes for spreading, grass green	Bucket 0.5 kg	830 235 007
Coloured flakes for spreading, grey	Bucket 0.5 kg	830 235 008

Other colours available on request.

Sealer

Description	Form of supply/Weight	Article No.
UV protective sealer, gloss	Canister 4 kg	830 297 000
Körapur 690, silica sand sealer A+B comp.	Tin 6 kg	830 151 000
Körapox BS 85, epoxy sealer, grey	Double tin 4+1 kg	830 132 000

Shelf life: 12 months after manufacture / Extended data sheet and safety data sheet available on request.

Detailed installation instructions for all listed versions available separately on request.

Antislip soft

Very hard-wearing natural rubber floor covering that elevates the coefficient of friction and cushions the sound of feet on loading areas. Also useable on areas where cattle or horses move around. Coats wood, steel, zinc, VA steel, aluminium and concrete.



Benefits at a glance

- Contains no solvents or plasticisers
- Easy to apply
- Sound-absorbing, footsure, elastic
- Easy to clean
- No joints, waterproof but vapour diffusing
- Non-conductive
- Cargo control floor: coefficient of friction proven to be > 0.60 μ
- Non-slip, cannot disappear as it is firmly attached to the floor
- Easy to repair

Technical specifications

Base:	3 components (natural rubber, rubber granulate, hardener)
Colour:	Anthracite, dark brown
Viscosity:	Firm
Application temp.:	- 20 °C to +35 °C
Consumption:	per set with 12 - 15 mm thick coat, for approx. 3.0 - 3.75 m ²
Curing time:	Fully resilient after approx. 5 days
Pot life:	approx. 30 min.
Mixing ratio:	20/20/8 weight ratio
Working temperature:	+10 °C to +25 °C
Storage temperature:	+5 °C to +25 °C



Delivery types

Description	Form of supply/Weight	Article No.
Antislip soft, black	Set 48 kg	830 620 000
Antislip soft, brown	Set 48 kg	830 600 000

Shelf life: 6 months after manufacture / Extended data sheet and safety data sheet available on request.

Primer

Description	Form of supply/Weight	Article No.
Sika Trocal C705 (metal primer)	Tin 2.2 kg	830 168 000
Sika Trocal C705 (metal primer)	Hobbock 21 kg	830 167 000
Körsolv WL (surface degreaser)	Tin 1 litre	870 810 000
Körsolv GL (surface degreaser)	Tin 1 litre	870 815 000

Detailed installation instructions for all listed versions available separately on request.

Pre-treatment table 1-C PUR

Pre-treatment table for constructive bonding using Körapur 1-C adhesives

Substrate	Pre-treatment	Remarks
ABS	Körabond HG 77 Plus	
Alum., blank	Körabond HG 81 (2x)	and finely sand ¹
Alum., anodised	Körabond HG 81	and finely sand ¹
Alum., powder-coated	Körasolv WL then Körabond HG 81	
Stainless steel	Körabond HG 81 (2x)	and finely sand ¹
FRP, smooth side	Körasolv WL then Körabond HG 81	
FRP, coarse side	Körasolv WL then Körabond HG 81	
Glass, clear	Körabond HG 81	guard against UV back radiation
Glass, with ceramic coating	Körabond HG 81	
Wood, untreated		Primer HG 74 E2
Wood, with phenolic resin coating	Körabond HG 81 (2x)	sanding required
PMMA (Plexiglas)	Körabond HG 92	finely sand ¹ , pre-testing required
Steel, bare	Körabond HG 81	
Steel, painted/lacquered	Körabond HG 81	or Körabond HG 77 Plus, where applicable
Steel, zinc-plated	Körabond HG 81	sanding required ¹
	Flash-off times (min/max)³	Application amount
Körabond HG 92	5 minutes / 24 hours	approx. 80-100 g/m ²
Körabond HG 81	5 minutes / 7 hours	approx. 50 g/m ²
Körasolv WL	5 minutes / 7 hours	approx. 50 g/m ²
Körabond HG 77 Plus	10 minutes / 3 days	approx. 80 g/m ²
Körabond HG 74 E	1 hour / 1 day	approx. 100 g/m ²

¹ Pre-treatment: clean, sand, clean. We recommend using a K 1000 emery cloth for sanding.

² This requires no more than wiping down the wood with a slightly damp cloth if it is certain that the wood moisture content is no higher than 13%.

³ In all other cases where this cannot be guaranteed, we recommend that you generally use HG 74 E primer. As a rule, HG 74 E primer enhances the adhesive properties of wood.

³ Should the flash-off time be exceeded, the surface will need to be pre-treated again before applying the adhesive.

Before commencing any work, always read the detailed data sheets for the various pre-treatment products!

Fundamental principle: To ensure trouble-free bonding, the substrates must always be clean, free from oil and grease, and also free from any stripping agents. With this in mind, we nevertheless wish to point out that the statements provided above are based on our practical experience and that you should carry out a test each time to ensure the right results. No liability or warranties may be derived from these guidelines. Please always read our data sheets and the paint/lacquer manufacturer's recommendations prior to performing the subsequent painting/lacquering tasks.

Körabond HG 81, 1000 ml tin:	Article No. 870 820 000
Körasolv WL, 1000 ml tin:	Article No. 870 810 000
Primer HG 77 Plus, 1000 ml tin:	Article No. 870 822 000
Primer HG 74 E, 1000 ml tin:	Article No. 870 821 000

Körabond HG 81 / Körasolv WL

Körabond HG 81

For pre-treating non-absorbent substrates such as metals (aluminium, steel, VA steel, brass, zinc, tinplate) or plastics (ABS, rigid PVC, PA 6.6, FRP, SMC, PUR)

Benefits at a glance

- Cleans
- Leaves behind actively adhesive synthetic resins

Technical specifications

Base:	Solvent, water-soluble synthetic resins
Colour:	Yellowish to brownish
Viscosity:	Very low ¹
Density:	0.8 kg/dm ³
Consumption:	20 – 50 g/m ²

¹ Normal climate 23/50-2 DIN 50014

Delivery types

Product / Packaging	Article No.
Körabond HG 81 1-litre tin	870 820 000

Shelf life: 12 months after manufacture

Extended data sheet and safety data sheet available on request.

Körasolv WL

Cleans greasy and wax-covered surfaces and acts as a pre-treatment before applying Körapur, Körapox and Köratac adhesives.

Benefits at a glance

- Cleans bonded parts
- Cleans tools
- Smoothens PUR seal welds

Technical specifications

Base:	Blend of organic solvents, toluol-free
Colour:	Clear
Viscosity:	Very low ¹
Density:	0.76 kg/dm ³
Consumption:	20 – 50 g/m ²

¹ Normal climate 23/50-2 DIN 50014

Delivery types

Product / Packaging	Article No.
Körasolv WL 1-litre tin	870 810 000

Shelf life: 12 months after manufacture

Extended data sheet and safety data sheet available on request.

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Körabond HG 92 / Körabond HG 74 E

Körabond HG 92

Primer for pre-treating rigid and soft PVC, ABS and PMMA for bonding with polyurethanes (Körapur) and silyl modified polymers (Körapop)

Benefits at a glance

- Leaves behind actively adhesive substances
- Bonding agent for cured Körapop prior to painting/lacquering

Technical specifications

Base:	Solvent, water-soluble synthetic resins
Colour:	Clear
Viscosity:	Very low ¹
Density:	0.91 kg/dm ³
Consumption:	20 – 50 g/m ²

¹ Normal climate 23/50-2 DIN 50014

Delivery types

Product / Packaging	Article No.
Körabond HG 92 1-litre tin	870 824 000

Shelf life: 12 months after manufacture

Extended data sheet and safety data sheet available on request.

Körabond HG 74 E Red

Pre-treats absorbent substrates e.g. wood and concrete.

Benefits at a glance

- Stands out due to its transparent red colour.

Technical specifications

Base:	Synthetic resin compound, contains solvents
Colour:	Clear
Viscosity:	Very low, spreadable/rollable ¹
Density:	1.0 kg/dm ³
Consumption:	approx. 100 – 200 g/m ² depending on coarseness of substrate

¹ Normal climate 23/50-2 DIN 50014

Delivery types

Product / Packaging	Article No.
Körabond HG 74 E 1-litre tin	870 821 000

Shelf life: 12 months after manufacture

Extended data sheet and safety data sheet available on request.

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Pre-treatment table 2-C PUR

Pre-treatment table for constructive bonding using Körapur 2-C and Körapur 2-C adhesives

Substrate	Pre-treatment
Aluminium	
– Bare ¹	Degrease with Körasolv WL ⁴ , roughly sand, clean with Körabond HG 79 ³
– Chromated	Degrease with Körasolv WL ⁴
– Anodised	Clean with Körasolv WL ⁴ , bond using Körapur 842
– Powder-coated	Clean with Körasolv WL ⁴ (buff with a scotch pad if necessary)
– Primed	Clean with Körasolv WL ⁴ or Körasolv CR (buff with a scotch pad if necessary)
– Painted/lacquered	Clean with Körasolv WL ⁴ or Körasolv CR (buff with a scotch pad if necessary)
Duromers	
– FRP sheeting	Roughly sand, remove dust
– FRP hand lay-up laminate	Clean with Körasolv WL ⁴ , sand roughly, remove dust
– Plywood	Roughly sand, remove dust
Iron	
– Bare	Degrease with Körasolv WL ⁴ , sand
– Chromated	Degrease with Körasolv WL ⁴
– Galvanised	Degrease with Körasolv WL ⁴ , buff with scotch pad
– Primed	Degrease with Körasolv WL ⁴ , buff with scotch pad
– Painted/lacquered	Degrease with Körasolv WL ⁴ , buff with scotch pad
– Laminated	Clean with Körasolv PR
Hard foam	
– PS (polystyrene)	No pre-treatment required
– PUR/PIR	No pre-treatment required
– PVC	No pre-treatment required
Wood	
– Untreated	Wood moisture must not exceed 13%, no pre-treatment
– Phenolic resin coating	Sand completely, then proceed as with untreated wood
Thermoplastics	
– ABS	Pre-coat with Körabond HG 77 Plus ⁵ / HG 92
– PVC	Pre-coat with Körabond HG 77 Plus ⁵ / HG 92
– PS, impact-resistant	Will not bond with 2-C PU
– PP/PE	Will not bond with 2-C PU
– PMMA (Plexiglas)	Will not bond with 2-C PU
– PA (nylon)	Sand ²
VA steel¹	Degrease with GETO PUR Cleaner 24 and roughly sand, then prime with HG 793 or have the product primed at cost (Grey epoxy primer, see below) Use Körapur 842 for bonding wherever possible

¹ In ideal cases, have the items primed using an oven-baked epoxy primer (Pechiney method)

² Carry out preliminary tests first as PA does not always bond

³ Consumption: 20 - 80 g/m². Flash-off time: 30 minutes to a maximum 24 hours (500 g, Art. No. 870 825 000)

⁴ Körasolv WL, 1000 ml, Art. No. 870 810 000

⁵ Körabond HG 77 Plus, 1000 ml, Art. Nr. 870 822 000

Fundamental principle: To ensure trouble-free bonding, the substrates must always be clean, free from oil and grease, and also free from any stripping agents. With this in mind, we nevertheless wish to point out that the statements provided above are based on our practical experience and that you should carry out a test each time to ensure the right results. No liability or warranties may be derived from these guidelines. Please always read our data sheets and the paint/lacquer manufacturer's recommendations prior to performing the subsequent painting/lacquering tasks.

Before commencing any work, always read the detailed data sheets for the various pre-treatment products!

Körabond HG 79 / Körapox BS 85

Körabond HG 79

Primer for pre-treating painted/lacquered surfaces, enamels, ceramics and coated glass prior to bonding with Körapur 1-C. Also works with the Körapur 2-C series when combined with bare metals, such as aluminium or iron.

Benefits at a glance

- For pre-treating non-absorbent substrates, such as metals (aluminium, steel, VA steel, brass, copper, zinc, tinplate) and plastics (ABS, rigid PVC, PA 6.6, FRP, SMC, PUR)

Technical specifications

Base:	Solvent, water-soluble synthetic resins
Colour:	Slightly yellow, clear
Viscosity:	Very low ¹
Density:	0.88 kg/dm ³
Consumption:	20 - 80 g/m ²

¹ Normal climate 23/50-2 DIN 50014

Delivery types

Product / Packaging	Article No.
Körabond HG 79 0.5 litre tin	870 825 000

Shelf life: 12 months after manufacture

Extended data sheet and safety data sheet available on request.

Körapox BS 85

Primer and sealer

Benefits at a glance

- For priming stainless steel and bare steel
- Exceptionally resistant, clear sealer for soft PU flooring Körapur 689
- Blocks out rising water

Technical specifications

Base:	Epoxy resin, contains solvent
Colour:	Grey, RAL 7037
Viscosity:	Low, spreadable/rollable ¹
Density:	1.14 kg/dm ³
Consumption:	250 - 400 g/m ²
Mixing ratio:	4/1 parts by weight
Pot life:	8 h ¹

¹ Normal climate 23/50-2 DIN 50014

Delivery types

Product / Packaging	Article No.
Körapox BS 85 Double tin 4+1 kg	830 132 000

Shelf life: 12 months after manufacture

Extended data sheet and safety data sheet available on request.

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Pre-treatment table 1-C SMP

Pre-treatment table for constructive bonding using Bostik SMP

Substrate	Pre-treatment	Remarks
ABS	Supergrip 5001HR	Please inquire, preliminary tests required
Alum., blank	Supergrip 5001HR or Bostik Prep M	and finely sand ¹
Alum., anodised	Supergrip 5001HR or Bostik Prep M	
Alum., powder-coated	Bostik Prep M	
Stainless steel	Bostik Prep M	and finely sand ¹
FRP, smooth side	Bostik Prep M	and finely sand ¹
FRP, coarse side	Supergrip 5001HR or Bostik Prep M	and finely sand ¹
Glass, clear	Supergrip 5001HR or Bostik Prep M	guard against UV back radiation
Glass, with ceramic coating	Supergrip 5001HR or Bostik Prep M	
Wood, untreated		Wipe with damp cloth
Wood, with phenolic resin coating	Bostik Prep M	Sanding required, then proceed as with untreated wood
PMMA (Plexiglas)	Supergrip 5001HR or Bostik Prep M	Finely sand ¹ , pre-testing required
Steel, bare	Supergrip 5001HR or Bostik Prep M	Should the product require an anti-corrosion coating under the adhesive, primer will need to be applied first. Then proceed as with painted/lacquered steel.
Steel, painted/lacquered	Supergrip 5001HR or Bostik Prep M	Ensure that the paint/varnish on the steel is sufficiently adhesive
Steel, zinc-plated	Supergrip 5001HR or Bostik Prep M	

	Flash-off times (min/max) ²	Application amount
Supergrip 5001HR	10 minutes / 6 hours	approx. 50 g/m ²
Bostik Prep M	10 minutes / 6 hours	approx. 50 g/m ²

¹ Pre-treatment: clean, sand, clean. We recommend using a K 1000 emery cloth for sanding.

² Should the flash-off time be exceeded, the surface will need to be pre-treated again before applying the adhesive.

Before commencing any work, always read the detailed data sheets for the various pre-treatment products!

Fundamental principle: To ensure trouble-free bonding, the substrates must always be clean, free from oil and grease, and also free from any stripping agents. With this in mind, we nevertheless wish to point out that the statements provided above are based on our practical experience and that you should carry out a test each time to ensure the right results. No liability or warranties may be derived from these guidelines. Please always read our data sheets and the paint/lacquer manufacturer's recommendations prior to performing the subsequent painting/lacquering tasks.

Supergrip 5001HR, 1000 ml tin: **Article No. 816 896 000**
 Bostik Prep M, 500 ml tin: **Article No. 816 890 000**
 Prep PP/PE, 500 ml tin: **Article No. 850 498 000**

Supergrip 5001HR / Bostik Prep M

Supergrip 5001HR

For pre-treating non-absorbent substrates such as metals (aluminium, steel, VA steel, brass, zinc, tinplate) or plastics (ABS, rigid PVC, PA 6.6, FRP, SMC, PUR)



Benefits at a glance

- Cleans
- Leaves behind actively adhesive synthetic resins

Technical specifications

Base:	Solvent, water-soluble synthetic resins
Colour:	Clear/transparent
Viscosity:	Very low ¹
Density:	0.8 kg/dm ³
Consumption:	20 - 50 g/m ²

¹ Normal climate 23/50-2 DIN 50014



Delivery types

Product / Packaging	Article No.
Supergrip 5001HR 1-litre tin	816 896 000

Shelf life: 12 months after manufacture

Extended data sheet and safety data sheet available on request.

Bostik Prep M

Cleans and pre-treats tough, waxed surfaces. For pre-treating very weathered surfaces that have been subjected to water.

Benefits at a glance

- Cleans bonded surfaces
- Leaves behind active silanes to induce adhesion

Technical specifications

Base:	Solvent, silanes
Colour:	Clear
Viscosity:	Very low ¹
Density:	0.76 kg/dm ³
Consumption:	20 - 50 g/m ²

¹ Normal climate 23/50-2 DIN 50014

Delivery types

Product / Packaging	Article No.
Bostik Prep M 0.5 litre tin	816 890 000

Shelf life: 12 months after manufacture

Extended data sheet and safety data sheet available on request.



Bostik Prep PP/PE / Bostik Prep G

Prep PE/PP

For pre-treating polypropylene and polyethylene surfaces before bonding / sealing with Bostik MSPs.

Benefits at a glance

- Activates the surface of thermoplastics, including PP and PE

Technical specifications

Base:	Solvent, synthetic resin compound
Colour:	Clear/transparent
Viscosity:	Very low ¹
Density:	0.87 kg/dm ³
Consumption:	20 – 50 g/m ²

¹ Normal climate 23/50-2 DIN 50014

Delivery types

Product / Packaging	Article No.
Bostik Prep PP/PE 0.5 litre tin	850 498 000

Shelf life: 12 months after manufacture

Extended data sheet and safety data sheet available on request.



Bostik Prep G

Black primer for pre-treating / protecting bonded surfaces, especially glass.

Benefits at a glance

- Shields the adhesive from UV rays, dyes surfaces black

Technical specifications

Base:	Solvent, synthetic resin compound
Colour:	Black
Viscosity:	Very low ¹
Density:	0.99 kg/dm ³
Consumption:	20 g/m ²

¹ Normal climate 23/50-2 DIN 50014

Delivery types

Product / Packaging	Article No.
Bostik Prep G 30 ml tin	816 889 000
Bostik Prep G 250 ml tin	816 894 000

Shelf life: 12 months after manufacture

Extended data sheet and safety data sheet available on request.



Solvents for adhesive systems

Brief description	Thinners and cleaners
Bostik® Solvent 270 Form of delivery	Thinner and cleaner for nitrile rubber adhesives, silicones 1-litre tin: Article No. 830 422 000 6-litre tin Article No. 830 424 000
Bostik® Solvent 280 Form of delivery	Thinner and cleaner for water-soluble petroleum-based adhesives; also cleans away butyl residue 6-litre tin: Article No. 830 427 000
Bostik® Solvent 300 Form of delivery	Thinner and cleaner for polychloroprene adhesives 1-litre tin: Article No. 830 429 000
Körasolv PU Form of delivery	Thinner and cleaner for Körapur used on soft flooring 1-litre tin: Article No. 870 812 000
Körasolv GL Form of delivery	Cleans and degreases smooth surfaces. Prepares the surface for subsequent bonding with adhesive tape and screw locking adhesives. 1-litre tin Article No. 870 815 000



Applicator guns

Hand tool 1

Manual cartridge gun (standard)

Benefits at a glance

- Lightweight and sturdy
- Patented clamping disc

Article No. 845 101 000



Hand tool 2

Manual cartridge gun (comfort)

Benefits at a glance

- Very good trigger ratio 1:18
- Very high thrust
- Especially suitable for very viscous materials

Article No. 845 162 000



Hand tool 3

Combined applicator gun 300 ml

Benefits at a glance

- Lightweight and sturdy
- Patented clamping disc

Article No. 845 103 000



Spare parts

Front end cap:	Article No. 845 120 000
Cartridge holder 300 ml:	Article No. 845 137 000
Piston disc, blue:	Article No. 845 128 000
Piston disc, steel, for cartridges:	Article No. 845 129 000

Hand tool 4

Manual foil pack applicator gun 600 ml

Benefits at a glance

- Lightweight and sturdy
- Patented clamping disc

Article No. 845 104 000



Spare parts

Front end cap:	Article No. 845 120 000
Cartridge holder 600 ml:	Article No. 845 138 000
Piston disc, blue:	Article No. 845 128 000
Piston disc, steel, for cartridges:	Article No. 845 129 000

Hand tool 5

Dual cartridge applicator gun (1:10)

e.g. for Körapur 840

Article No. 845 110 000



Sealing and deaeration

Paint roller

For sealer versions V2-V4 or
applying primer coats

Article No. 840 088 000

Spare parts

Replacement roller, velour, 4 mm/25 cm:

Article No. 840 088 001

Spiked roller

Width: 24 cm

Deaerates and smooths out freshly applied
coatings

Article No. 840 096 000

Spiked shoes (1 pair)

For walking on freshly laid coatings

Article No. 840 092 000



Pneumatic applicator guns

Air tool 1

Pneumatic cartridge gun (closed)

Benefits at a glance

- Lightweight and sturdy
- Easy to use
- Very good weight distribution

Article No. 845 168 000



Spare parts

Front end cap: Article No. 845 120 000

Pneumatic applicator gun

with telescopic piston for 290-310 ml cartridges

Article No. 845 172 000



Spray gun

Pneumatic cartridge gun for sprayable seam sealers

Benefits at a glance

- No cleaning required after use
- Clean application

Article No. 845 143 000



Pneumatic applicator guns

Air tool 5

Pneumatic foil pack applicator gun 600 ml

Benefits at a glance

- Lightweight and sturdy
- Easy to use
- Special piston for ideal residue evacuation

Article No. 845 170 000



Spare parts

Front end cap: Article No. 845 120 000

Air tool 6

for dual cartridges (1:10)

Article No. 845 111 000



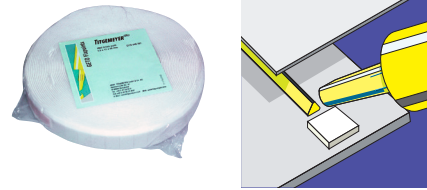
Aids

Fixpoints

Double-sided adhesive points

Benefits at a glance

- 250 adhesive points per roll
- Fast, exact bonding of parts
- Uniform adhesive layer thickness
- No cutting or trimming required



Thickness [mm]	Width [mm]	Length [mm]	Colour	Article No.
1.5	12	20	White	860 201 000
2.0	12	20	Black	860 202 000
3.0	12	20	Black	860 203 000

Smoothing agents

Köratool AM 10

Benefits at a glance

- Aqueous solution that cleanly smoothens freshly applied PU and MSP sealants
- Can be applied by finger or smoothing tool (e.g. GETO-Fugenboy)
- If the seal weld is to be subsequently painted, always ensure that the weld surface is washed first
- Residue from the smoothing agent may affect the adhesive qualities of the paint.

1000 ml bottle: **Article No. 850 188 000** (not shown)

Aids

Adapter

for foil packs on standard nozzle



Benefits at a glance

- Fits very snugly on tubular bags
- Only the standard nozzles need to be replaced
- Fine thread

1 per pack: Article No. 840 170 000

Cartridge nozzle

Standard



Benefits at a glance

- Length 90 mm
- Fine thread

Article No. 840 116 000

Cartridge nozzle

Standard



Benefits at a glance

- Length 110 mm
- Coarse thread

Article No. 860 105 000

Cartridge nozzle

Special



Benefits at a glance

- Length 175 mm
- Coarse thread

Article No. 860 103 000

Cartridge nozzle

V bead



Benefits at a glance

- Opening width 7 mm
- Opening width 10 mm
- Coarse thread

Article No. 860 101 000

Aids

Foil pack nozzle

Standard

Benefits at a glance

– Length 120 mm

Article No. 860 102 000



Foil pack nozzle

Special

Benefits at a glance

– Length 150 mm

Article No. 860 106 000



Adhesive consumption

Dimensioning the geometry of sealants and adhesives

Elastic sealants/adhesives can only realise their full potential (movement compensation, peel strength, impact resistance) if the geometry of the sealant/adhesive has been correctly determined.

This primarily means observing a minimum layer thickness. This, in turn, must be individually adapted to the bonding application. A layer thickness of between two and three millimetres has proven suitable for many applications. Greater movement requires greater layer thicknesses.

Layer thicknesses >20 mm should be avoided, since these would greatly extend the sealant/adhesive curing time, whilst also reducing the elasticity of the sealant/adhesive bond.

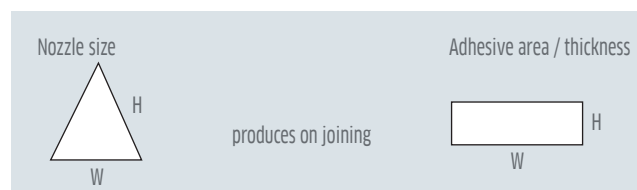
2-C adhesive consumption

The consumption varies and depends on the area of use, substrate and layer thickness.

The following rule of thumb can be applied:

Layer thickness x density of adhesive = consumption in kg/m²

Table showing nozzle sizes (approx. reference values)



W [mm]	H [mm]		W [mm]	H [mm]
5	4	→	10	1
8	8	→	10 - 15	1 - 2
8	10	→	15 - 20	2
10	12	→	20	2 - 3
8	12	→	10	5
10	15	→	15	5

Adhesive and sealant consumption

Linear metre of adhesive/sealant per packaging unit

Bead ϕ [mm]	Cartridge 310 ml	Foil pack 600 ml
4	24	47
6	11	21
8	6	12
10	4	7

Bead Δ [Width x height]	Cartridge 310 ml	Foil pack 600 ml
5 x 5	24	48
8 x 10	8	15
10 x 10	6	12
10 x 15	4	8

Terms and Conditions of Delivery and Payment

1. Applicability of the Terms and Conditions

- a) All deliveries, performances, sales and offers between. Titgemeyer GmbH & Co. KG and all our Customers are provided exclusively on the basis of these Terms and Conditions of Delivery and Payment. These apply to Companies and thus also to all future business relationships, even if they are not expressly agreed upon again. Where these General Terms and Conditions of Business refer to "Consumers", this is to be understood as meaning all natural persons who conclude a contract with us and who cannot be allocated to a commercial or self-employed professional activity. "Companies" are natural, juridical or legally responsible partnerships that conclude a contract with us for commercial or self-employed purposes. "Customers" are both "Consumers" as well as "Companies".
- b) Contract partner is Titgemeyer GmbH & Co. KG Hannoversche Straße 97, 49084 Osnabrück, (Amtsgericht Osnabrück (Osnabrück Local Court), HRA 2329), represented by GTO Beteiligungs- GmbH, in turn represented by the Director Joachim Sommer Dr. (University of Nebraska-Lincoln), (Osnabrück Local Court, HRB 208590).
- c) We herewith expressly reject any general terms and conditions of business of the Customer that contradict our Terms and Conditions of Delivery and Payment. Commercial letters of confirmation from the Customer shall not legally bind us, even if we do not expressly object to said letters.
- d) The ineffectiveness of any individual contractual provision shall not affect the validity of the Contract as a whole.

2. Offer and conclusion of contract

- a) Our offers are subject to change without notice and are non-binding. Letters of acceptance and all orders require our written confirmation to become legally valid.
- b) Drawings, illustrations, dimensions, weights or other performance data shall only be binding if this is expressly agreed.
- c) We retain all ownership and copyright to all our technical documentation. Such documents may not be made available to any third parties without our prior consent.

3. Prices and shipping costs

The following applies to orders from Consumers or to contracts with Consumers:

- a) The prices are shown in euros including statutory value added tax and excluding settlement discounts and other allowances. The prices as at the time of the respective order shall apply.
- b) The shipping costs shown at the time of conclusion

of the order are payable in addition to the value of the goods. We expressly reserve the right to demand higher shipping costs in consultation with the customer if this is necessary due to the particular nature of the order.

The following provisions shall apply to all other contracts:

- a) The prices in our Confirmation of Order plus the applicable statutory value added tax shall apply. Prices shall be calculated on the basis of the weights, numbers of units and square metre figures determined by the Vendor. Additional deliveries and performances not contained in our Confirmation of Order shall be calculated separately.
- b) The prices quoted shall apply ex-works without packaging and freight. These will be invoiced separately. Packaging will not be taken back unless a statutory obligation to do so applies.
- c) If substantial increases in the prices of raw materials or energy occur within the space of contracts with an agreed delivery period of more than four months, the parties to the Contract undertake to renegotiate the purchase price. If no agreement can be reached, the parties to the Contract shall be entitled to withdraw from the Contract. No further claims shall then be entertained (e.g. for damages or repayment of expenses).

4. Period of delivery and performance

The following shall apply in the case of Customers who are not Consumers:

- a) Delivery periods and deadlines shall be subject to alteration without notice and are non-binding, unless an express agreement to the contrary is made.
- b) Delivery periods and deadlines shall be postponed appropriately for the duration of the disturbance in cases of force majeure, industrial disputes, riots, official intervention, failure to deliver on the part of our suppliers and other unforeseeable, unavoidable and significant events. We shall be obliged, to a reasonable extent, to immediately provide the Customer with the requisite information, and - in good faith - to adapt the Customer's obligations to the changed situation.
- c) If the hindrance lasts longer than three months, the Customer shall be entitled, after setting an appropriate grace period, to withdraw from the Contract in respect of the unfulfilled part of the said Contract. If it should be or become impossible to dispatch the goods due to extraordinary circumstances for which we are not responsible, we shall be authorised, without prejudice to immediate billing, to store the said goods elsewhere for the account and at the risk of the Customer, should our storage facilities not suffice.
- d) We shall be entitled to make partial deliveries and performances.

- e) Should a Customer wish to withdraw from the Contract or demand damages in lieu of performance, the passing of specified delivery periods and deadlines will not exempt the Customer from the obligation to set a reasonable grace period for performance (as a rule two weeks).

5. Purchase agreements with call-off

Should we have concluded a purchase agreement with the Customer, who is not a Consumer, involving calloffs, the following terms and conditions shall additionally apply failing agreement to the contrary:

- a) Upon expiry of a period of three months following confirmation of order, we shall be entitled to request a binding schedule from the Customer for the outstanding call-offs. Should the Customer fail to meet this request within a three-week period, we shall be entitled to set a subsequent deadline of two weeks during which the binding schedule must be furnished. Failure on the part of the Customer to adhere to this deadline shall entitle us to withdraw from the Contract and to demand damages in lieu of performance.
- b) Should the goods not be called off or not called off entirely by the agreed dates and/or by the aforementioned deadlines, we shall be entitled to store the goods elsewhere at the cost and risk of the Customer. Should some or all of the goods not have been called off at the time the Contract expires, i.e. by the time the last opportunity for calloff has passed, we shall - following expiry of a reasonable additional period during which the goods must be accepted by the Customer - be entitled to withdraw from the Contract and to demand damages in lieu of performance to the extent that the Contract has not already been fulfilled by us.
- c) In lieu of performance, we shall - by way of recouping lump-sum damages - be entitled to charge the purchase price owed for the goods belonging to the outstanding call-offs, whereby our Customer shall have the express right to furnish proof that no such damage has been incurred or that the amount of damage is far lower than the stated lump sum. All further claims for damages shall remain unaffected by the foregoing.

6. Passing of risk

The following rulings shall apply to contracts with Customers that are not Consumers.

When delivering objects, the risk shall pass to the Customer as soon as the object being delivered is transferred to the person effecting the transport, or leaves our warehouses for shipping. We shall choose the shipping route and means. The freight will be invoiced at the freight rates valid on the day of billing. Any increase in the freight costs caused by a subsequent alteration to the type of packaging, transport route, destination or similar factors pertaining to the freight costs shall be borne by the Customer, to the extent that the Customer has initiated these changes. In the case of

Customers who collect the goods themselves, the risk shall pass to the Customer at the agreed place of delivery and upon the Customer being advised that the goods have been made ready for collection. Should the Customer request shipping by overnight express, i.e. a delivery of the consignment outside normal trading hours and in the absence of the recipient, and hence without a consignment receipt, then he shall name a lockable warehouse that is not accessible to third parties or a store box of the same nature at the Customer's premises vis-à-vis the company performing transportation, and shall grant this company the possibility to access it, e.g. by leaving a key or an access code. If the Customer fails to nominate such storage and to grant the possibility of access, then the delivery by the company performing transportation by overnight express shall be executed by dropping off the consignment at a location to be designated by the Customer or, in the absence of such a nomination, at a location that appears to be suitable to the haulier at its discretion. We point out to the customer that there is an increased risk of loss in the case of shipping by overnight express compared to other modes of dispatch, which may lead to the Customer incurring losses.

7. Warranties

The statutory warranty provisions and material defect rights shall apply to contracts with Customers that are Consumers.

The following rulings shall apply to contracts with all other Customers.

- a) For defects as provided for by Section 434 BGB (German Civil Code) we shall be liable provided that the following conditions have been met: the Customer undertakes to inspect the goods received immediately with regard to defects and quality. Obvious defects are to be reported to us in writing within a period of 14 days. In the case of mutual commercial acts between businessmen, Section 377 HGB (German Commercial Code) shall remain unaffected.
- b) If the Customer finds a defect in the goods, he/she shall not be authorised to dispose of the goods, i.e. he/she may not split, resell or further process the goods until agreement has been reached as to how to deal with the complaint, or until an independent evidence process has been carried out.
- c) The Customer undertakes to inform us immediately of any damage incurred during transport. The Customer shall take care of the required formalities with the Carrier.
- d) In the case of a justified complaint, we shall be entitled to choose whether to rectify the defective goods or to provide substitute delivery. Multiple rectifications shall be permitted.
- e) The warranty does not include damage caused by false information from the Customer, storage that breaches

instructions or defective processing or use of the goods.

- f) If it is impossible to eliminate the defect or effect the substitute delivery within the appropriate grace period provided by the Customer, the Customer shall, excluding any further claims, only have the right to either withdraw from the Contract or reduce the purchase price.
- g) If the Customer does not afford us the opportunity and reasonable time required to verify the defect and carry out any required subsequent performance (rectification or replacement delivery), any claims arising from the deficiency shall be voided. This shall not apply in cases of consequential damage caused by defects which shall be subject to the conditions stated under Article 7.

8. Limitation of liability

- a) We shall be liable for damages in case of intent, gross negligence or violation of substantial contractual obligations, and in the absence of assured features. Any other claims not expressly conceded in these Terms and Conditions shall be excluded with Customers that are not Consumers and, in any case with these Customers that are not Consumers, shall not exceed the damage foreseeable at the time the Contract was concluded, or the value of the delivered goods.
- b) In as much as our liability is excluded or restricted, this shall also apply to the personal liability of our employees, legal representatives and vicarious agents. In all cases of gross negligence on the part of ordinary vicarious agents, we shall be liable to Customers who are not Consumers for typical, foreseeable damages.
- c) The legal provisions regarding burden of proof shall remain unaffected by this.
- d) The above limitations of liability shall not apply to claims under the product liability law for damage to life, limb or health, or damage to privately used property.

9. Limitation periods

All claims of Customers who are not Consumers – for whatever legal reasons – shall be time-barred in 12 months. The statutory periods shall apply to intentional or fraudulent behaviour and claims stemming from the product liability law. The beginning of the statutory limitation period shall be that as prescribed under the statutory provisions.

10. Payment

- a) In the case of contracts concluded by Companies via telecommunication means, the purchasing price, including all costs, in particular shipping costs, shall be due upon invoicing. Payments under these contracts must be made strictly net, without settlement discounts or other deductions, by advance payment, cash on delivery or via PayPal, unless another form of payment has been agreed. In these cases, invoicing will be exclusively in electronic form. In cases of purchase against invoice, the purchasing price will be payable on

the date of receipt of the delivery by the Customer.

- b) With all other contracts, all payments must be made net within 30 days of the date of invoice if no agreement to the contrary has been made. We shall grant a settlement discount of 2% for cash and transfer payments made within 10 days of the date of invoice.
- c) The following shall apply in addition in dealings with Customers who are not Consumers. We expressly reserve the right to refuse cheques and bills of exchange. Acceptance is always on account of performance. Discount and bill charges shall be borne by the Customer and are due immediately. Excluding Sections 366, 367 BGB, and despite stipulations by the Customer to the contrary, we shall, at the time the contract is concluded, determine which claims are settled by the Customer's payments. Upon delay of performance, we shall be entitled to demand the usual bank interest rate, but not less than eight percentage points above the base interest rate in accordance with Section 247 BGB.
- d) The Customer shall only be entitled to offset payments against claims which are undisputed and have been established by declaratory judgment.

11. Retention of ownership

We shall retain ownership of the delivered goods until full payment of the purchase price has been received. Up until this time, Customers who are Consumers are not entitled to pledge the goods, transfer ownership of them by way of security or encumber them with other rights. The following shall apply in extension to Customers who are not Consumers:

- a) In the case of goods that the Buyer receives from us within the scope of an ongoing business relationship, we shall retain ownership until all claims against the Buyer stemming from this business relationship have been satisfied. This shall also apply when individual or all claims have been recorded in a current account and the balance drawn and confirmed by the Customer. If a bill of exchange liability is incurred by the Buyer in the context of the payment of the purchase price (cheque, bill of exchange), the retention of ownership shall not expire before the Customer honours the bill of exchange as drawee. If the Customer is in payment arrears, we shall be entitled to repossess the goods subsequent to a reminder, and the Buyer will be obliged to surrender possession.
- b) If the conditional commodity is processed into a new piece of movable property, the further processing shall be done on our behalf, without any obligations accruing to us: the new commodity shall become our property. In the case of processing together with goods not belonging to us, we shall acquire co-ownership of the new object to a degree in relation to the value of the conditional commodity to the other goods at the time of processing. If the conditional commodity is joined,

Terms and Conditions of Delivery and Payment

commingled or mixed with goods not belonging to us, as stipulated in Sections 947, 948 BGB, we shall become co-owners in accordance with the legal provisions. If the Customer acquires sole ownership on the basis of the joining, commingling or mixing, co-ownership to the extent of the value of the conditional commodity in relation to the other goods at the time of joining, commingling or mixing transfers to us now, in advance. In such cases, the Customer shall be obliged to store the object of which we are owner or co-owner, which is also a conditional commodity in the sense of the above stipulations, at no cost.

- c) If the Customer sells the conditional commodity alone or in connection with goods not belonging to us, the Customer assigns to us now, in advance, the value of the conditional commodity as generated from the sale, together with all secondary rights and ranked before all others. We accept this assignment. The value of the conditional commodity is the sum resulting from our invoice, which, however, shall not be included in the account if there is a conflict with third-party rights. If the resold conditional commodity is in our co-ownership, the assignment of the claims shall include the sum that corresponds to the value of the share of the co-ownership.
- d) The Customer shall only be entitled and authorised to resell, use or process the conditional commodity within the scope of ordinary business activities and only on the condition that the claims as stipulated in the paragraphs above are in actual fact assigned to us. The Customer is not authorised to dispose otherwise of the conditional commodity, in particular to pledge it or assign it as security.
- e) We herewith issue a revocable authorisation to the Customer to collect the claims assigned to us in accordance with paragraphs c) and d). We will not avail of our own right of collection as long as the Customer meets its payment obligations, including towards third parties. In the event that the Customer fails to meet his payment obligations, the Customer shall, if requested by us, name the debtors of the assigned claim and notify them of the assignment. We shall then also be authorised to notify the debtors of the assignment. The Customer undertakes to inform us immediately, also providing us with the documents required for an objection, as to any forced execution measures upon the conditional commodity by third parties.
- f) The right of resale, the right to use or process the conditional commodity or the authorisation to collect the assigned claims shall lapse with stoppage of payments and/or the opening of insolvency proceedings. In the case of a cheque or bill protest, the authorisation to collect shall also lapse.
This does not apply to the rights of the insolvency

administrator.

- g) If the value of the securities offered exceeds the claims (where applicable reduced by deposits and part payments) by more than 20%, we shall be obliged to reassign or release the securities as we choose. Once all claims from the business relationship have been settled, the ownership of the conditional commodity and the assigned claims shall transfer to the Buyer.

12. Data protection

The customer has read and understood our company's privacy notice. On the basis of the above, the customer consents to any personal data concerning them, which are collected and/or saved/stored in the course of the business relationship, being processed in compliance with the Federal Data Protection Act (Bundesdatenschutzgesetz) and the EU General Data Protection Regulation. The customer has been informed of their rights, in particular as these pertain to their entitlement to have personal data erased and to the possibility of withdrawing their consent at any time.

13. Place of performance, place of jurisdiction and applicable law.

- a) Osnabrück is hereby agreed as place of performance for delivery, performance and payment for all rights and obligations arising under the Contract if the Customer is not a Consumer.
- b) The sole place of jurisdiction for all disputes arising directly or indirectly from the contractual relationship shall be Osnabrück (also for bills of exchange, cheques and other documentation processes), if the Customer is a businessman, a juridical person under public law or a public-law special fund.
- c) These Terms and Conditions of Business and all legal relationships between us and the Customer shall be subject solely to the laws of the Federal Republic of Germany. The UN Convention on Contracts for the International Sale of Goods dated 11 April 1980 shall in no case apply.

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Term of Delivery and Payment

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All technical data, performance descriptions, drawings, illustrations, measurements, weights or any other performance data, recommendations and guidelines contained in this catalogue and relating to the installation of parts that we supply are only binding if so expressly agreed. Moreover, the user is obliged at all times to check each individual use and decide whether the components that we supply can be used as needed.

We accept liability in the case of wilful intent, gross negligence and infringement of cardinal contractual duties as well as for errors in respect of express or implied representations. Notwithstanding this, any claims for compensation not explicitly agreed to in these terms and conditions are hereby excluded in the case of customers who are not consumers and, in the case of such customers, who are not consumers, at all events limited to the damage foreseeable at the time of concluding the contract as well as to the value of the delivered consignment. To the extent that our liability is excluded or limited, this shall extend accordingly to the personal liability of employees, legal representatives and vicarious agents. In all instances of gross negligence committed by vicarious agents, we shall solely be liable to customers, who are not consumers, to compensate for typically foreseeable damage. The statutory regulation governing the burden of proof shall remain unaffected. The aforementioned limitation of liability shall not apply to claims resulting from product liability, for damage resulting from injury to life, limb or health, or for damage to privately used property.

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About us

The Titgemeyer Group is a leading company for fastening technology and vehicle components at 15 locations in Europe.

The traditional company develops, manufactures and sells more than 30,000 fastening elements, tools and vehicle components – in series production and on request.

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