



Icema™ R 141/40

General Properties	Technology/Base	polyurethane
	Type of Product	adhesive
	Curing	polyaddition curing
	Mechanical Properties	semi-structural
	Parts	two part system
	Part A (Resin)	Icema™ R 141/40
	Part B (Hardener)	Köracur TH 650
	Color	cream
	Product Benefits	easy to apply with a notched trowel pourable

Technical Data

Part A Icema™ R 141/40

Physical Properties		
Density	1.50 g/cm ³	DIN EN 542
Color	white	
Processing Guidelines and Parameters		
Storage Temperature	-25 °C to 35 °C	
Viscosity	11,000 mPa·s	Kö-test method 100000

Part B Köracur TH 650

Physical Properties		
Density	1.23 g/cm ³	DIN EN 542
NCO content	31%	
Color	brown	
Processing Guidelines and Parameters		
Storage Temperature	10 °C to 25 °C	
Viscosity	300 mPa·s	Kö-test method 100000

General

Processing Guidelines and Parameters		
Mixing Ratio (Part A : Part B) by Weight	100 : 20	
Mixing Ratio (Part A : Part B) by Volume	100 : 24.4	
Processing Temperature	15 °C to 25 °C	
Curing		
Potlife	15 min, 9 min	Kö-test method 100207
Curing Time	min. 24 h	23 °C / 50 % r.H.
Cured Material Characteristics		
Shore Hardness (Type D)	50	ISO 868



Product Properties

Applications	Special Applications	filter industry
Processing	Preparation of adhesive	Adhesive must be stirred to homogeneity before use!
	Suitable Substrates	various plastic substrates
	Surface Requirements	dry clean free of grease free of dust polyolefin plastics have to be corona or flame treated other plastics and metals should be primed
	Application Method	via two part mixing and metering systems with notched trowel
	Product is free of	solvents plasticizers
Cleaning	Cleaner for Tools	Körasolv PU
Hints	Moisture Sensitivity	The adhesive must not be exposed to moisture before and during application. Moisture causes foaming leading to lower mechanical properties.
	Processing	the adhesive connection has to be fixed or pressed until the adhesive is cured adhesive must not be diluted adhesive has to be applied to one bonding surface the joint between the bonding surfaces must be completely filled Icema™ R 141/40 and materials to be bonded must not be processed at temperatures below the given processing temperature. Low temperature adhesive should be warmed and stirred well before use.
	Curing conditions	The cured material properties are reached only when material is cured at the minimum curing conditions specified in the Technical Data section.



Additional Information

Storage

Icema™ R 141/40 should be used within the shelf life specified on the packaging. The storage stability only applies to material stored under appropriate conditions (original unopened containers, recommended storage temperature).

Safety

Please read our Safety Data Sheet (SDS) and the labels of each product before use. The valid safety regulations must be considered.

Preparation

For some substrates the use of mechanical pre-treatment and/or cleaner or primer is necessary to achieve good adhesion. Refer to the product properties section of this data sheet for special surface requirements and suitable adhesion promoters.

Processing

Refer to the technical data table regarding processing parameters. Low temperatures can cause a temporary increase in viscosity resulting in reduced extrusion and slower curing rates.

Cleaning

Clean tools immediately after use. Once cured, the material can only be removed mechanically. Appropriate cleaners are listed in the product properties table. For further information please contact your local sales office.

Disposal

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

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