

PRODUCT INFORMATION

Körplast 199



PUR-based sole attachment adhesive

- For bonding soles of leather, halogenated TPR / rubber, PVC, PUR and polyamide to leather / synthetic uppers
- High initial bond strength
- High heat resistance
- Especially for athletic and trekking shoes

TECHNICAL DATA

Base	Polyurethane, solvent	
Colour	Transparent	
Density	0,86	g/cm ³
Viscosity at +20°C	3600	mPas
Activation temperature	70-80	°C
Hardener	Köracur TR 400, Köracur TR 250, Köracur TR 203	
Mixing ratio	5-10	%
Pot life	4-6	h with Köracur TR 400
	6-8	h with Köracur TR 250
	20-24	h with Köracur TR 203
Drying time	20	min to 3 weeks (depending on material)
	20-90	min
		without hardener
		with hardener

PROCESSING

Processing temperature

Do not process adhesive and materials to be bonded below +18°C. Undercooled adhesive should be warmed up for at least 3 days from +25°C up to +30 °C (not with open flame) and stirred well before use.

Preparation

Leather, rubber and PUR-soles as well as lasting margins have to be carefully roughened. For PUR-soles which cannot be roughened, we recommend priming with **Körabond PUR 50 / PUR 65**.

Soles of TPR and rubber difficult to bond must be halogenated with **Halosol W 5 FL / Halosol 6**.

For cleaning the surface wash PVC-soles with **Körasolv M**.

Polyamide-soles must be pretreated with **Körabond 5**.

Greasy and fibrous leathers must be primed with **Körplast 172 / Körplast 173**, extreme greasy leathers with **Körplast 154 LF**.

Bonding

Coat the bonding surface of the pretreated soles (pay attention to drying time of primers) with **Körplast 199**. When coating the lasting margins mix 5 % of Kö-hardener (**Köracur TR 400 / TR 250 / TR 203**).

Wait for drying minimum 20 minutes (if hardener is added wait no longer than 90 minutes). Activate the sole at +70°C to +80°C.

Fix sole against upper and press. The pressure to be applied depends on the hardness of the sole material; the usual pressing time is 8-15 seconds.

CLEANING

Körasolv CA, Körasolv M

SPECIAL NOTES**Tools**

Brush or machine

Storage

6 months at +18 °C.
Containers, tins and adhesive vessels are to be kept tightly closed in order to avoid thickening of the adhesive due to the evaporation of solvents.

SAFETY

Please read our Safety-Data-Sheet and the labels of each product before use.

Pay particular attention to the directions given in the Dangerous Substance Regulations.

Make sure the safety data sheet is readily available as it gives valuable information regarding the safe usage and disposal of the product and what to do in the event of an accident involving the product.

PACKAGING UNITS

15 kg tin

PRODUCT NUMBER

C28203/1

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

Please note: All given data are based on careful examination in our laboratories and our past practical experience. These are non-binding indications. Given the high number of materials appearing on the market and the different methods of use which are beyond our influence and control, we naturally cannot accept any responsibility for the results of your work, also with regard to third party patent rights. We recommend that sufficiently thorough tests be carried out to ascertain whether the product described will meet the requirements of your particular case. Please also note our Terms of Sale, Delivery and Payment. This Product information replaces all previous issues.



KÖMMERLING CHEMISCHE FABRIK GMBH

Zweibrücker Str. 200 D-66954 Pirmasens

Phone +49 6331 56-2000

Fax +49 6331 56-1999

P.O. Box 2162

eMail

Internet

D-66929 Pirmasens

info@koe-chemie.de

www.koe-chemie.de



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