

Icema™ R 101

General Properties	Technology/Base	Polyurethane
	Type of Product	Adhesive
	Curing	Polyaddition curing
	Parts	Two part system
	Part A (Resin)	Icema™ R 101
	Part B (Hardener)	Köracur TH 650
	Colour	White
	Product Benefits	Easy to apply with a notched trowel Long processing time

Technical Data

Part A Icema™ R 101

Physical Properties		
Density	1.95 g/cm ³	DIN EN 542
Colour	white	
Processing Guidelines and Parameters		
Storage Temperature	-25 °C to 35 °C	
Viscosity	1,200 Pa·s	Kö-test method 100001

Part B Köracur TH 650

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

General

Physical Properties		
Density	1.85 g/cm ³	DIN EN 542
Processing Guidelines and Parameters		
Mixing Ratio (Part A : Part B) by Weight	100 : 15	
Mixing Ratio (Part A : Part B) by Volume	100 : 24	
Processing Temperature	15 °C to 25 °C	
Curing		
Potlife	85 min	Kö-test method 100172
Curing Time	min. 24 h	
Cured Material Characteristics		
Shore Hardness (Type D)	70	DIN EN ISO 868

Product Properties

Applications	Typical Applications	Sandwich assemblies
Processing	Suitable Substrates	Plywood Cement fibre boards High pressure laminate (HPL) Pretreated plastics (PU, PMMA, PP, PC, ABS) Enamel Pretreated metals (aluminium, steel) Polystyrene (PS) Polyurethane (PUR) Polyvinyl chloride (PVC) Glass Concrete Wood
	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	Two part mixing and metering system With notched trowel
	Product is free of	Solvents
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	Adhesive has to be applied to one bonding surface The joint between the bonding surfaces must be completely filled

Additional Information

Storage

Icema™ R 101 should be used within the shelf life specified on the packaging. The storage stability applies to material stored under appropriate conditions only (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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