

SERVICE PRODUCTS. PRODUCT HIGHLIGHTS.

Bodywork Adhesives.

- 83 19 0 413 015 K1, 195mL/6.59 fl oz
- 83 19 2 156 847 K2, 250mL/8.45 fl oz
- 83 19 0 417 144 SF-7888L, 600mL/20.3 fl oz
- 83 19 2 149 520 K4, 50mL /1.69 fl oz
- 83 19 2 158 654 K5a, 50mL/1.69 fl oz
- 83 19 2 157 298 K5b, 195mL/6.59 fl oz



K1

K2

SF-7888L

Product Description

K1: 2-component bodywork adhesive.

K2: 2-component adhesive for bonding the outer skin of the roof in the case of the F01/F02.

SF-7888L: 2-component adhesive for repairing the outer skin of the roof of the M6 (CFRP roof).

K4: Viscoplastic two-component adhesive on a methacrylic acid basis.

K5a&b: Impact modified 2-component cartridge adhesive on an epoxy resin basis, which is mixed using a static mixing tube.



K4

K5a

K5b

Application

K1:

- Remove both adhesive components from the cartridge and mix in a ratio of 2:1 with a static mixer.
- The processing time of about one hour is long enough to permit the manual repair process in the workshop to run safely.
- Degrease or clean the surfaces to be bonded.

K5a&b:

- Apply the mixed product to the previously cleaned metal surfaces.
- The parts must be fixed within 4 hours at 73.4°F.
- Screws, rivets or spot welding are suitable fixing measures during the curing.
- The adhesive is fully resilient after 24 hours at 73.4°F.

Area of Application

K1: Repair of the weight-reduced aluminium front end / bonding of bodywork components made of aluminium (e.g. in the case of the E60).

K2: After appropriate pretreatment, plastics, composite materials and painted parts can be bonded in any combination.

SF-7888L: Bonding of plastics, metals, metal primers and colour coatings (2-component systems), SMC and other glass-fibre reinforced materials, wood and ceramics.

K4: Repair materials for repairing the clips of the roof drip moulding - PV 06033.

PRODUCT HIGHLIGHTS.

Bodywork Adhesives.

Information / Safety

K1:

- Improves the structural durability, rigidity and crash stability of the vehicle.
- It has been specially developed for use in the event of a repair to restore the original properties of the bonded components.
- For optimum wetting, the components to be bonded should have a minimum temperature of 59°F.
- The mixing tube must be replaced if the application is interrupted for more than one hour.

Advantages

K1:

- Comes very close to the properties of the original structural adhesive, does not necessarily have to be warmed up for curing.
- Processing in a cold condition, prior warming is not necessary.
- Adheres extremely well to the steel grades used in the automobile industry, including coated steels (EDP or organic coatings) and to pretreated aluminium.
- It is also suitable for sealing and protects both metal components and weld points against corrosion. It thus helps to ensure the durability of a repaired vehicle.

K2:

- Same mechanical properties as those of the original components.

SF-7888L:

- Very high strength.
- High impact strength.
- Non-ageing.
- Fast curing.
- Cures at room temperature.
- Does not form long threads.
- Thixotropic.
- Adheres to a large number of materials.
- Free from PVC and solvents.

K4:

- Cures at room temperature.
- High peel strength.
- Excellent adhesion to a large number of materials.
- Can be used at temperatures of up to 212°F.

K5a&b:

- Can be applied using a standard pistol.
- Does not run, can be used on vertical surfaces.
- Offers corrosion protection and is weldable.
- Can be painted over and can be grinded when cured.
- Excellent thermal and chemical resistance, impact resistant, highly durable.

K5a&b:

- For the user there is the least possible exposure to ingredients hazardous to health.
- The adhesive system contains neither heavy metals nor halogens.

Competitive Comparison

- Very good mechanical properties to ensure the original adhesive properties and familiar bonding behaviour on BMW materials.
- These are the only products approved by BMW.