

COSMO SL-660.241

*** COSMOFEN PLUS HV-U, almond

PVC adhesive

Examples for Application

- Fast structural bonding of rigid PVC parts.
- Plastic window construction Bonding of additional profiles, like sill drips, drain bars, blow bars and shutter bars.
- Plastic window construction Bonding of cover caps and shutter guides in PVC profiles.
- Sanitary area: Bonding of tubes, gutter pipes and others
- Construction of trade fair and promotional signs: constructive bonding of integrated rigid foam slab, e.g. Forex made of PVC hard.

Special Properties

- tough-hard adhesive joint
- Thixotropic, does not drop off
- Good temperature resistance
- Good UV-radiation resistance

Technical Data

Basis	vinyl chloride polymers in solvent
Color	
Hard-dry	almond
Viscosity	
measured by cone and plate (60 s ⁻¹) at +25 °C (+77 °F)	approx. 4 000 mPa.s (4 000 cP)
Density	
as per EN 542 at +20 °C (+68 °F)	approx. 0.99 g/cm ³ (8.26 lb/gal)
Open time:	
at +20 °C (+68 °F), 50 % r. H., Ordered quantity 150 µm (5.9 mil)-glass	approx. 60 s
Functional strength	
For bonding of stress-free battens	approx. 2-4 min
Curing time	
at +20 °C (+68 °F), 50 % r. H.	Until 90 % - approx. 24 h <i>Diffusion of the residual solvent can last up to 8 weeks.</i>
Applied quantity:	
For bonding of battens	
20 mm (0.79 in) wide bonding surface	approx. 8 g/running metre (0.28 oz/running meter)
40 mm (1.57 in) wide bonding surface	approx. 16 g/running metre (0.56 oz/running meter)
Minimum processing temperature	from +5 °C (+41 °F)



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Instructions for use

The surfaces of the workpieces to be bonded must be dry, and free from dust and grease.

For this purpose we recommend COSMO CL-300.150.

The cleaning cloths must be lint-free and may not stain.

The adhesive is applied on one side of the bonding surfaces as a bead (serpentinous).

Select the adhesive quantity to be applied depending on the material thickness; the adhesive can "penetrate"!

The workpieces must be fit together and pressed within the open time.

After they have been fit together, the parts must be fixed and pressed until functional strength has been reached.

The bonded joint is loadable after 16 h, the remaining hardening time of the bonded joint can last up to 8 weeks depending on the conditions.

For bonding oversized profiles or for bonding surfaces we recommend using COSMO SL-660.200 with an "extended open time".

If additional profiles are bonded (bonded surface: PVC-hard) on surfaces with decor film, make sure that the additional profiles rest flat on the window profile. Dose the applied quantity in a way that no adhesive gets out of the bonded joint during bonding. The so bonded additional profiles may not be exposed to increased temperature/ sun radiation (>+25 °C (>+77 °F)) for about one week. If this is not observed, bubbles can occur in the acryl layer! Alternatively, a solvent-free system is also available for this application, COSMO CA-500.130.

Diffusion adhesives can only bridge over bonded gaps of <0.1 mm (3.9 mil) in a tensionally locked way.

The here specified time parameters can only be determined accurately by self-tests because they are strongly influenced by material characteristics, temperature, applied quantity, air humidity, material humidity, thickness of adhesive film, press power, and other criterions. Usually, appropriate safety factors are considered for the guiding values.

Important instructions

Only instructed personnel in specialist firms are allowed to use the product!

KEEP OUT OF REACH OF CHILDREN !

KEEP HOBBOCK, DRUM, CONTAINER, e.g. TIGHTLY CLOSED !

USE ONLY FOR APPLICATIONS MENTIONED IN THE TECHNICAL DATA SHEET !

NO OTHER WARRANTIES EXPRESSED OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. WEISS USA LLC SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES.

Not suitable for bonding pressure tubes!

Our user instructions, processing guidelines, product- and performance data, and other technical statements are only general directives; they describe only the condition of our products (values, determination of values on the date of completion) and the performances do not represent a warranty in the sense of § 443 BGB. **Because of the wide variety of applications of the individual product and the relevant special conditions (e. g. processing parameters, material characteristics, etc.), it is up to the user to test it itself;** our free expert advice for application provided in speech, writing, and as test is nonbinding.

Please, also consider the Safety Data Sheet!

Cleaning

Tools with fresh, not-cured adhesive can be cleaned with COSMO CL-300.120.



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Metallic surfaces are cleaned by easy pulling off of the hardened adhesive film, because it does not adhere to metal. From PVC hard profiles, the cured adhesive is removed after the adhesive has flashed using a scraper and, if necessary, it is further treated with COSMO CL-300.110.

Storage

Store in the hermetically closed original packages, dry at temperatures of +15 °C (+59 °F) to +25 °C (+77 °F), no direct sun radiation.

Storage life in unopened original packagings: 24 Months.

During the storage time, viscosity is increasing.

Packaging

Aluminium membrane tube, net weight: 200 g (7.1 oz)

Other trading units on request.



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