COSMO HD-100.200

*** COSMOHYBRID 1847

1-C-Hybrid Assembly Adhesive

Examples for Application

- Joint / head joint bonding of dry lining boards (gypsum fibre boards).
- Dry lining and internal finishing.

Special Properties

- Very low emission*
- tough-elastic adhesive joint
- Solvent-free
- Not foaming
- Low shrinkage
- Long open time
- Surface can be smoothed well
- High strength of adhesive joints
- Compensates the expansion of different materials
- Good UV-stability
- Can be over-coated with many paint systems

Certificates / Test reports

GEV
*Classified in the EMICODE class EC1 PLUS in compliance with the criterions of the GEV.

Licence No.: 2984

French VOC-Emission class A+

Technical Data

Basis:	1-C-humidity cross-linking silane terminated polymer
Colour	
Hard-dry	Beige
Density	
as per EN 542 at +20 °C	approx. 1.60 g/cm^3
Shore hardness	
as per DIN 53505	approx. 90 Shore A
Viscosity	
at +20 °C	Medium viscous-pasty

Weiss Chemie + Technik GmbH & Co. KG
Hansastraße 2
D-35708 Haiger

Tel.: +49 (0) 2773 / 815 - 0
Fax: +49 (0) 2773 / 815 - 200
Email: ks@weiss-chemie.de
Web: www.weiss-chemie.de

COSMO HD-100.200

*** COSMOHYBRID 1847

1-C-Hybrid Assembly Adhesive

Skinning time - dry	
at +20 °C, 50% r. H.	approx. 20 min
Applied quantity 500 µm-PE/PVC	
	With increased air humidity or after the adhesive has been sprayed with water, the skinning time will be clearly shorter.
Setting speed	
at +20 °C, 50 % r. H.,	approx. 2 mm in 24 h
until it reaches the final strength	7 d
Temperature range	-40 °C to +90 °C, temporary to +120 °C
Minimum processing temperature	from +5 °C

Instructions for use

Apply adhesive on one side of the dry, grease- and dust-free surface to be glued.

Polyolefins (among others PE, PP) cannot be bonded without preparation, e.g. plasma- or corona treatment. If PS-hard surfaces are bonded, generally we recommend using a primer.

If non-absorbing materials are bonded (material humidity <8 %), water must be "sprayed very finely" onto the adhesive to achieve complete curing.

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

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

Remove oozing adhesive when it is fresh.

Paint the bonded workpieces only after the adhesive has cured completely; if they are painted too early, formation of paint bubbles cannot be excluded.

Bonding of materials with different longitudinal extension must be assessed regarding their long-term behaviour, especially when they are exposed to fluctuating temperature ranges.

Due to the difficult definition of aluminium surfaces and qualities, we generally recommend gathering sufficient information from the supplier to prepare the planned bonding process optimally; sufficient qualification tests are required.

If stainless steel is manufactured or processed, auxiliary aids, e.g. wax, oil, etc, are often used, that usually cannot be removed by simple wiping away; it turned out that after the cleaning with solvent-based cleaning agents a clearly better bonding result will be achieved after grinding, or better sand blasting, of the surface and following cleaning with solvent.

Galvanized sheet metals must generally be protected from humidity that is permanently acting on it "formation of white rust". In this case, it must be exclude that occurring humidity can get onto the bonding surface.

If permanent humidity impact is expected, the bonded joints/bonded surfaces must additionally be sealed/protected using a "suitable sealant".

Powder coatings with shares of PTFE cannot be bonded reliably without pre-treatment (e. g. plasma procedure).

Skinning, joining times, as well as the required press and following processing times can only be determined accurately by self-tests because they depend on material, temperature, applied quantity, air humidity, material humidity, thickness of adhesive film, press power, and other criterions. For processing, appropriate safety allowances shall be planned in addition to the specified guiding values.

weiss
Weiss Chemie + Technik GmbH & Co. KG
Hansastraße 2
D-35708 Haiger

Tel.: +49 (0) 2773 / 815 - 0
Fax: +49 (0) 2773 / 815 - 200
Email: ks@weiss-chemie.de
Web: www.weiss-chemie.de

COSMO HD-100.200

*** COSMOHYBRID 1847

1-C-Hybrid Assembly Adhesive

Important instructions

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

Follow the instructions provided by the manufacturer of the panels!

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

Remove the fresh, not cured adhesive from the surfaces and the tools using COSMO CL-300.150.

Cured adhesive can only be removed mechanically.

Storage

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

Storage life in unopened original packagings: 12 Months.

Packaging

310 ml PE-Euro cartridge, net weight: 490 g

Other trading units on request.

weiss
Weiss Chemie + Technik GmbH & Co. KG
Hansastraße 2
D-35708 Haiger

Tel.: +49 (0) 2773 / 815 - 0
Fax: +49 (0) 2773 / 815 - 200
Email: ks@weiss-chemie.de
Web: www.weiss-chemie.de