



# COSMO® CA-500.130

\*\*\*COSMOPLAST 515

## Special Cyanoacrylate - Fast Setting Adhesive

### Examples for Application

- EPDM seals in window, façade, and vitrine construction
- Vehicle / shipbuilding
- Leather / shoe industry
- Medical / dental technology, orthopaedics
- Metal construction / technical industrial supplies
- Advertising techniques / advertising industry
- Additional strips in window and door construction
- Internal finishing of caravan / camper van
- Exhibition stand construction
- Model making / furniture industry
- Worktops of natural stone
- Bonding of end caps of PS-, ABS, ASA, or SAN in rigid PVC sections

### Special Properties

- Good adhesion characteristics to different surfaces
- Solvent-free
- Good wetting of the substrate
- hard adhesive joint
- Good UV-stability
- Highly frost- and heat-resisting
- Long open time: Material handling up to 180 s possible

### Technical Data

<b>Basis</b>	Modified cyanoacrylates
<b>Viscosity</b> as per cone and plate (300 s <sup>-1</sup> ) at +25 °C	approx. 900 mPa.s
<b>Density</b> as per EN 542 at +20 °C	approx. 1.05 g/m <sup>3</sup>
<b>Functional strength</b> EPDM/EPDM - profile sealing	approx. 15 s
<b>Gap bridging</b>	max 0.1 mm
<b>Curing time</b> at +20 °C, 50 % r. H.	approx. 16 h
<b>Softening range</b>	from +80 °C
<b>Applied quantity</b> for bonding of battens (20 mm wide)	approx. 1 g/running metre
<b>Applied quantity</b> for bonding of battens (40 mm wide)	approx. 2 g/running metre
<b>Processing temperatures</b> adhesive and substrates	from +5 °C to +30 °C

### General Information

In principle, CA-adhesives cure by means of air and material humidity. This means that ambient conditions, material and condensation humidity on the surfaces to be glued, thickness of applied adhesive layer and press power, as well as surface roughness of the materials to be glued significantly influence the process.

The chemical characteristics of the surfaces to be glued, e.g. pH-value, variations of raw material characteristics, surface coatings, as well as corrosion and contamination have a significant effect on the desired bonding strength.

Pressing times strongly depend on material and adhesive temperature.

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

Please, consider the relevant Technical Data Sheets of the recommended products mentioned above.

Open time, as well as the necessary pressing time, 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.





# COSMO® CA-500.130

\*\*\*COSMOPLAST 515

## Special Cyanoacrylate - Fast Setting Adhesive

### Preparation

Acclimatise the product before the application.

The surfaces to be glued are cleaned with COSMO® CL-300.150 immediately before bonding.

If silicon, TPE sections and polyolefins are bonded, they are to be pretreated with primer COSMO® SP-840.110. The variety of materials requires to carry out some preliminary tests yourself.

### Bonding

#### I. Bonding of rigid PVC strips on decorative surfaces

The adhesive is applied directly from the dosing bottle on one side, usually on the additional profile strip. Within the open time, approx. 3 min, the additional profile strip is fixed on the carrying section until it reaches its functional strength, depending on the thickness of its adhesive joint, approx. 120 s.

The surfaces to be glued have to rest flat on the carrying section. If the bonded joints are thicker than >0,1 mm, the curing time/functional strength will be considerably longer. To reach the functional strength earlier, COSMO® SP-860.110 is applied by means of a sponge tube, or COSMO® SP-860.120 is sprayed, on the second surface to be glued, i. e. the carrying section. If the accelerator is used, consider that the laying time (adhesive and accelerator come together without pressing power) will be reduced to a few seconds because spontaneous curing will occur when the two surfaces come together.

#### II. Bonding of end caps

If end caps are glued onto rigid PVC sections, a bead of adhesive is to be applied directly from the dosing bottle into the cavity of the section and the end cap must be adapted and fixed within 3 min until the functional strength has been reached.

### Bonding of metals

Bonding of aluminium, copper, brass: only on chemically pretreated or varnished surfaces; these materials cannot be durably bonded to be age-resistant without appropriate pre-treatment of the surfaces to be glued.

Due to their variety, age and, if necessary, additional treatment with oil or wax, anodized surfaces do not allow any general statement about wettability or bonding characteristics of these bonding surfaces.

### Important instructions

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

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 the hermetically closed original trading units, in a dry place at temperatures of +15 °C to +25 °C no direct sun radiation.

While transported within the usual transport times, the product may be exposed to temperatures from -15 °C to +35 °C.

Storage life in unopened original packaging: 6 Months.

Optimum storage at temperatures from +2 °C to +8 °C.

During the storage time, viscosity is increasing, reactivity is decreasing.





# COSMO® CA-500.130

\*\*\*COSMOPLAST 515

## Special Cyanoacrylate - Fast Setting Adhesive

### Packaging

PE-bottle, net weight: 20 g

PE-bottle, net weight: 50 g

PE-bottle, net weight: 500 g

Other trading units on request.

### Accessories

COSMO® SP-810.160 – CA-capillaries

COSMO® SP-840.110 – CA-primer for polyolefins

COSMO® SP-860.110 – CA-accelerator in tube with sponge attachment

COSMO® SP-860.120 – CA-accelerator in aerosol can



Industrieverband  
Klebstoffe e.V.



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](mailto:ks@weiss-chemie.de)  
Web: [www.weiss-chemie.de](http://www.weiss-chemie.de)

made by weiss