



## Cyanoacrylate - Fast-Setting Adhesive

### Examples for Application

- Sewage technique
- Sealing technique
- Vehicle / shipbuilding
- Plastics / elastomer / rubber processing
- Leather / shoe industry
- Toy industry
- Advertising techniques / advertising industry
- Model making / furniture industry
- Bonding of diverse rubber and plastic surfaces on absorbent materials

### Special Properties

- Good adhesion characteristics to different surfaces
- Solvent-free
- Good wetting of the substrate
- hard adhesive joint
- Good UV-stability

### Technical Data

|  |   |
|--|---|
| <b>Basis</b>   | Modified cyanoacrylates                     |
| <b>Viscosity</b> as per cone and plate (1 000 s <sup>-1</sup> ) at +25 °C (+77 °F) | approx. 280 mPa.s (280 cP)                  |
| <b>Density</b> as per EN 542 at +20 °C (+68 °F)                                    | approx. 1.05 g/m <sup>3</sup> (8.76 lb/gal) |
| <b>Functional strength</b> EPDM/EPDM - profile sealing                             | approx. 20 s                                |
| <b>Functional strength</b> PS rigid/wood   | from 60 s                                   |
| <b>Functional strength</b> wood/wood   | from 360 s                                  |
| <b>Gap bridging</b>  | max 0.15 mm (5.9 mil)                       |
| <b>Curing time</b> at +20 °C (+68 °F), 50 % r. H.                                  | approx. 16 h                                |
| <b>Softening range</b>   | from +80 °C (+176 °F)                       |
| <b>Processing temperatures</b> adhesive and substrates                             | from +5 °C (+41 °F) to +30 °C (+86 °F)      |

### 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.

### Preparation

Acclimatise the product before the application.

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





# COSMO® CA-500.170

\*\*\* COSMOPLAST 564

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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

Apply the adhesive from the trading unit or by means of a CA-dosing unit onto one side.

Immediately after application, the workpieces must be fit together and pressed until they reach the required functional strength.

To reduce the pressing times, or to accelerate curing of cyanoacrylate adhesives in thicker bonded joints >0.10 mm (3.9 mil), the accelerator COSMO® SP-860.120 is to be used.

### 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!

KEEP OUT OF REACH OF CHILDREN !

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

USE ONLY FOR APPLICATIONS MENTIONED IN THE TECHNICAL DATA SHEET !

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*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 (+59 °F) to +25 °C (+77 °F) no direct sun radiation.

While transported within the usual transport times, the product may be exposed to temperatures from -15 °C (-22 °F) to +35 °C (+95 °F).

Storage life in unopened original packaging: 6 Months.

Optimum storage at temperatures from +2 °C (+36 °F) to +8 °C (+46 °F).

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

### Packaging

PE-bottle, net weight: 20 g (0.71 oz)

### Accessories

COSMO® SP-810.160 – CA-capillaries





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PE-bottle, net weight: 50 g (1.76 oz)

PE-bottle, net weight: 500 g (17.6 oz)

Other trading units on request.

COSMO® SP-840.110 – CA-primer for polyolefins

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



Industrieverband  
Klebstoffe e.V.



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