COSMO® DS-420.140

*** MP 2030

Dispersion Assembly Adhesive

Examples for Application

- For universal use
- For assembly bonding
- Skirting, laying of laminate and cable ducts
- Stair construction and building trade
- Fixation of signs
- Diverse industrial fields

Special Properties

- High Tack
- tough-elastic adhesive joint
- Solvent-free
- freeze-resistant
- Thixotropic, does not drip off
- Fills gaps up to 10 mm
- Not foaming
- Fast touch force for assembly works
- Wide range of application possibilities on different materials and substrates
- Good condensate-resistance

Technical Data

Basis	Modified acrylate polymer dispersions
Colour in hard-dry condition	grey-white
Density as per EN 542 at +20 °C	approx. 1.42 g/cm^3
Viscosity at +20 °C	highly viscous-pasty
Open time at +20 °C, 50 % rel. humidity, applied quantity 500 µm-PE/PVC	approx. 25 min
Curing time depending on the absorbency of the materials and bead thickness	from 24 h
Frost resistance	to -30 °C
Operation temperature range	from -30 °C to +80 °C
Processing temperatures adhesive and substrates	from +5 °C to +30 °C
Tensile shear strength as per DIN EN 1465, beech at +20 °C	approx. 10 N/mm^2

General Information

One of the material substrates must be absorbent.

Cured dispersion adhesives have a good water resistance, however applications with continuously high air humidity, e.g. swimming pool or other wet room areas (among others, also because of the aggressive chloric and humid air) are to be avoided.

Dispersion adhesives cure because moisture is released (physical drying); the building material must be sufficiently absorbent to ensure the hardening of the dispersion adhesive.

Examples for material moisture for orientation:

Building materials	Vol. %
Roof-tiles	≤2.5
Plaster	≤5
Dry lining boards	≤5
Concrete	≤5
Cellular concrete	≤8

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

Wood	≤12

In the individual case, the material has to be prepared (e.g. heating , pre-drying of the surfaces to be bonded /adhesive) in a sufficient way; provide for sufficient room ventilation.

The curing time (drying process) varies depending on temperature, adhesive film thickness, and air humidity.

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

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.

Preparation

Acclimatise the product before the application.

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

Depending on the material surface, check if the bonding result can be improved by grinding or applying of primer.

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.

Bonding

The adhesive is applied one-sided as bead on one of the parts to be bonded.

Within the open time until short before skin formation, the workpieces must be fit together and pressed.

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.

Bonding of metals

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.

If metals are bonded with absorbent materials (e.g. wood, building materials, etc.), humidity can be transported slowly through the absorbent material, through the bonded joint, to the metallic surface and here, it can cause corrosion damages on the metal. Therefore, the metallic bonding surface must be equipped with an appropriate corrosion protection, e. g. varnish, powder coating!

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

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

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

Tools with fresh, not-cured adhesive can be cleaned with water.

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Cover the cured adhesive with a cloth soaked with COSMO® CL-300.150 and let it act. After the adhesive has been softened, it can be removed. Depending on the thickness of the adhesive film, this process is to be repeated.

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 -30 °C to +35 °C.

Storage life in unopened original packaging: 12 Months

Packaging

310 ml PE-Euro cartridge, net weight: 435 g

Other trading units on request.

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