



1-C-MS-sealant

Examples for Application

- Bonding of EPDM films and profiles on each other or on different materials
- Apparatus and plant construction
- Automotive and vehicle body manufacturing
- Used for bonding and sealing in diverse industrial fields

Special Properties

- Very low emission*
- Excellent adhesion on EPDM
- elastic adhesive joint
- Thixotropic, does not drip off
- Solvent-free
- Compatible with natural stone
- Not foaming
- Joint filling
- Low shrinkage
- Long open time
- Compensates the expansion of different materials
- Good weather resistance outdoors
- Good UV-stability
- Can be over-coated with many paint systems
- Can subsequently be powder-coated

Certificates / Test reports

GEV

*Classified in the EMICODE class EC1^{PLUS} in compliance with the criteria of the GEV.

Licence No.: 11747



French VOC-Emission class A+

Technical Data

Basis	1-C-humidity-cross-linking silane-terminated polymer
Colour hard-dry	grey
Density as per EN 542 at +20 °C	approx. 1.44 g/cm ³
Shore hardness as per DIN 53505	approx. 30 Shore A
Viscosity as per plate-plate (2 s ⁻¹) at +25 °C	approx. 230 000 mPa.s
Breaking elongation as per DIN 53504	approx. 500 %
Skin formation time - dry at +20 °C, 50 % r. H., applied quantity 500 µm-PE/PVC	approx. 15 min
Watertightness after dynamic load (SS 818141) and after alternating climatic storage	water column 140 mm
Curing speed at +20 °C, 50 % r. H.	approx. 4 mm in 24 h
Curing time at +20 °C, 50 % r. H. until it reaches the final strength	approx. 7 d
Operation temperature range	from -40 °C to +100 °C



Industrieverband
Klebstoffe e.V.



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Subsequent powder coating after reaching the final strength	20 min/to +180 °C
Processing temperatures adhesive and substrates	from +5 °C to +30 °C
Tensile shear strength as per DIN EN 1465, Alu/Alu, 0.2 mm joint at +20 °C	ca. 2.0 N/mm ²

**After production, while it is stored, skinning time changes from approx. 15 min to approx. 30 min.

General Information

With increased air humidity or after the bonding compound has been sprayed with water, the skinning time will be clearly shorter. Usually, it can be easily coated over, but this should be checked before because of the variety of paint and lacquer systems.

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.

Preparation

Acclimatise the product before the application.

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 of PVC, ABS, PC, PET, GRP on the basis of polyester or polyamide and powder-coated surfaces should only be done after pre-treatment of the bonding surfaces with the activator COSMO® CL-310.110 by wiping.

Bonding of concrete, cellular concrete, sandstone and building brick should only be done after pre-treatment of the bonding surfaces with the activator COSMO® CL-310.110 by brush (up to 50 ml/m²).

Sealing

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

Apply sealant.

Screed the excess material away from the joint within the skinning time.

Remove excess sealant when it is fresh.

Important instructions

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

For PVC-bonding, also read our technical information "Testing and evaluation of PVC-bonding with STP/MS adhesives of the product series COSMO® HD".

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 material from the surfaces and the tools using COSMO® CL-300.150.

Cured material 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.





COSMO® HD-100.601

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While transported within the usual transport times, the product may be exposed to temperatures of -30 °C to +35 °C.

Storage life in unopened original packaging: 12 Months

During the storage time, viscosity is increasing.

Packaging

Sizes of trade units on request.

