



COSMO® PU-200.140

*** COSMOFEN VKD 874

2-C-PUR Assembly adhesive

Examples for Application

- Window and door construction
- Bonding of glazing bars in the glazing bar slot for the production of "burglar-resistant window- and door elements (RC 2, RC 3)" in the field of plastic window construction
- Filling of cavities for the following screw connection in the field of window and door construction

Special Properties

- tough-elastic adhesive joint
- Solvent-free
- Thixotropic, does not drip off
- Compatible with natural stone
- Expands (foams) during the curing process!
- Particularly fast reaction time
- Good adhesion characteristics to several types of wood, and building material, ceramics, metal, duroplast and thermoplastic after appropriate preparation of the surface
- Good weather-proofness
- Can be over-coated with many paint systems
- Features easy handling of tandem cartridge with static mixer

Certificates / Test reports

French VOC-Emission class A+

Technical Data

Mixture COSMO® PU-200.140 (Component A COSMO® PU-201.140 + Component B COSMO® PU-205.140)

Basis	2-Component PUR reaction adhesive
Colour hard-dry	beige
Density pursuant to EN 542 at +20 °C (+68 °F)	approx. 1.52 g/cm ³ (12.69 lb/gal)
Shore hardness as per DIN 53505	Approx. 55 Shore D
Viscosity at +20 °C (+68 °F)	medium viscous-pasty
Mixing ratio parts by volume	A: B = 1.0 : 1.0
Pot life of a 100 g (3.5 oz) batch at +20 °C (+68 °F)	approx. 5 min
Processing time of the tandem cartridge with the static mixer at +20 °C (+68 °F)	approx. 2-3 min
Functional strength depending on the application at +20°C (+68 °F)	approx. 20-30 min
Curing time at +20 °C (+68 °F), 50 % r. H. to approx. 75 %	approx. 3 h
Curing time at +20 °C (+68 °F), 50 % r. H. until it reaches the final strength	approx. 2 d
Processing temperatures adhesive and substrates	from +10 °C (+50 °F) until +30 °C (+86 °F)
Applied quantity	depending on application

Component A COSMO® PU-201.140

Colour	beige-white
Viscosity at +20 °C (+68 °F)	medium viscous-pasty



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Component B COSMO® PU-205.140

Colour	beige
Viscosity at +20 °C (+68 °F)	medium viscous-pasty

General Information

The processing times become shorter at +30 °C (+86 °F) to approximately half of the time, at +10 °C (+50 °F), they become longer to approx. double of the time.

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

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 cured mass changes its colour due to UV radiation but not its strength in the cured bonded joint.

Pot-life, processing time, as well as the necessary pressing time or fixing time, can only be determined accurately by self-tests because they are strongly influenced by material characteristics, temperature, mixed quantity, applied quantity, 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.

The cartridges must be checked for damage before processing. If there is any visible damage, they should no longer be used.

Safety glasses must be worn during processing.

At an operating pressure of max. 8.0 bar (116 psi), the air pressure guns COSMO® SP-750.112 and COSMO® SP-750.122, will achieve a working power of 3.3 kN (742 lbf).

Avoid overloading of the tandem cartridge due to too high forces >3.6 kN (810 lbf). If the air pressure guns type COSMO® SP-750.111 or COSMO® SP-750.121 and a connected pressure of 8.6 bar (124.7 psi) are used, max. 2.8 kN (629.5 lbf) can be reached, i.e. safety is ensured.

Depending on the type or brand of the air pressure gun, and when applying higher operating pressure, the cartridges can be damaged or become leaky due to the different forces caused by the pneumatic cylinders of the guns at usual application temperatures. For this reason, possibly the correct mixing ratios of the adhesive systems cannot be obtained; for instance Sulzer TS493X (Krøger), Schüco 296 704 allow max. 7.0 bar (101.5 psi) (max. 3.6 kN (810 lbf)).

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

If PS-hard surfaces are bonded, we recommend preliminary cleaning with COSMO® CL-300.120 or COSMO® CL-300.110; bonding is done after the PVC-hard surface has hardened again!

If powder-coated aluminium surfaces are bonded, we recommend preliminary cleaning with COSMO® CL-300.150!

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

Reactivity and dosing behaviour are considerably influenced by the material temperature; under warm conditions, masses become faster and can be dosed significantly faster. At low temperatures <+7 °C (+45 °F), **homogeneously** heat the cartridges up to **max. +35 °C (+95 °F)**.

The static mixing tube is screwed onto the open cartridge and the cartridge is inserted in the dosing gun.

The first approx. 20 g (0.71 oz) of the mixed adhesive (approx. walnut size) are not used for bonding for safety reasons (cartridge filling method)!

Within the processing time, apply the mixed adhesive directly from the static mixer into the section or onto the surface to be bonded and fit the parts together.



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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.

Open bonded joints, e.g. for bonding battens, are smoothed with COSMO® CL-300.150.

In case of short interruptions of work, within the processing time, if dosed once more, new, fresh adhesive is filled in the static mixer. In this way, one static mixer can be used for a whole work day.

After work stoppages, make sure to change the static mixer within the specified time.

After the end of work, the used static mixer remains on the cartridge unit; if work starts again, the static mixer is to be replaced. If necessary, remove hardened adhesive from the cartridge nozzle. Now the safety shot, approx. 20 g (0.71 oz) of adhesive, is required, before bonding can be continued!

Bonding of glazing bars:

Bonding of glazing bars is done after a preliminary cleaning of the glazing bar slot and the bonding surface of the glazing bar, please find cleaning agents above. Depending on the geometry of the glazing bar slots a pea- to nut-size dots are dosed in the slot with a distance of approx. 15-20 mm (0.6-0.8 in), then the glazing bars are pressed in within the processing time.

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 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.

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.

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 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).

Bonding of wood

If solid wood is bonded, the adhesive should preferably be applied on the two surfaces to be bonded. The press pressure shall be $>1 \text{ N/mm}^2$ ($>145 \text{ psi}$).

If solid wood is bonded for outdoor application, perform appropriate tests to achieve optimum bonding depending on wood type, weathering intensity, surface protection and dimensions of adhesive joints.

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 !

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Please, also consider the Safety Data Sheet!



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2-C-PUR Assembly adhesive**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 -30 °C (-22 °F) to +35 °C (+95 °F).

Storage life in unopened original packaging 9 Months.

Packaging

2 x 310 ml (2 x 10.48 fl oz) tandem PP-cartridge, net weight:
900 g (2.0 lb)

Other trading units on request.

Accessories

COSMO® SP-800.221 - Static mixer

COSMO® SP-800.120 - Static mixer

COSMO® SP-800.230 - Static mixer

COSMO® SP-750.121 - Air pressure gun

COSMO® SP-760.151 - Manual pressure gun



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