



COSMO® SL-660.210

*** COSMOFEN PLUS-S HV

PVC adhesive

Examples for Application

- Fast structural bonding of rigid PVC parts
- Plastic window construction Bonding of additional profiles, like sill drips, drain bars, blow bars and shutter bars
- Plastic window construction Bonding of cover caps and shutter guides in PVC profiles
- Sanitary area: Bonding of tubes, gutter pipes and others
- Construction of trade fair and promotional signs: constructive bonding of integrated rigid foam slab, e.g. FOREX® made of PVC hard

Special Properties

- semi-hard adhesive joint
- Thixotropic, does not drip off
- Good temperature resistance
- Good UV-radiation resistance

Technical Data

Basis	Vinyl chloride polymers in solvent
Colour hard-dry	colourless
Viscosity as per cone and plate (60 s ⁻¹) at +25 °C	approx. 4 000 mPa.s
Density as per EN 542 at +20 °C	approx. 0.97 g/cm ³
Open time at +20 °C, 50 % r.H., application quantity 150 µm-glass	approx. 60 s
Functional strength for bonding of stress-free battens	approx. 2-4 min
Curing time at +20 °C, 50 % r. H. to ca. 90 %	ca. 24 h
Applied quantity for bonding of battens (20 mm wide)	approx. 8 g/running metre
Applied quantity for bonding of battens (40 mm wide)	approx. 16 g/running metre
Processing temperatures adhesive and substrates	from +5 °C to +30 °C

General Information

Diffusion adhesives can only bridge over bonded gaps of <0.1 mm in a tensionally locked way.

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.

For this purpose we recommend COSMO® CL-300.150.

The cleaning cloths must be lint-free and may not stain.

Bonding

The adhesive is applied on one side of the bonding surfaces as a bead (serpentinous).

Select the adhesive quantity to be applied depending on the material thickness; the adhesive can "penetrate"!

The workpieces must be fit together and pressed within the open time.

After they have been fit together, the parts must be fixed and pressed until functional strength has been reached.





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The bonded joint is loadable after 16 h, the remaining hardening time of the bonded joint can last up to 8 weeks depending on the conditions.

If additional profiles are bonded (bonded surface: PVC-hard) on surfaces with decor film, make sure that the additional profiles rest flat on the window profile. Dose the applied quantity in a way that no adhesive gets out of the bonded joint during bonding. The so bonded additional profiles may not be exposed to increased temperature/ sun radiation (>+25 °C) for about one week. If this is not observed, bubbles can occur in the acryl layer! Alternatively, a solvent-free system is also available for this application, COSMO® CA-500.130.

Important instructions

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

Not suitable for bonding pressure tubes!

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 COSMO® CL-300.120.

Metallic surfaces are cleaned by easy pulling off of the hardened adhesive film, because it does not adhere to metal.

From PVC hard profiles, the cured adhesive is removed after the adhesive has flashed using a scraper and, if necessary, it is further treated with COSMO® CL-300.110.

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: 24 Months

During the storage time, viscosity is increasing.

Packaging

Aluminium membrane tube, net weight: 200 g

Other trading units on request.

