



# COSMO® SP-780.110

\*\*\* COSMOFEN BF 780

## Bending fluid

### Examples for Application

- Plastic window construction: Reshaping and bending of PVC-hard window and door profiles laminated with decorative film and PMMA co-extruded in the immersion bath

### Special Properties

- Does not cause cracks on the formed materials during and after bending
- Excellent oxidation-resistant and thermostable properties
- Also after longer use it will keep its neutral smell
- Can be mixed with water in every desired ratio, therefore the materials can be cleaned easily after bending without environmental stress for the workplace.

### Technical Data

<b>Basis</b>	Modified low-molecular-weight triol
<b>Colour</b>	yellowish-colourless
<b>pH value</b> as per EN 1245	approx. pH 7
<b>Viscosity</b> as per Brookfield (06/50 min <sup>-1</sup> ) at +20 °C	approx. 1 400 mPa.s
<b>Density</b> as per EN 542 at +20 °C	approx. 1.26 g/cm <sup>3</sup>
<b>Processing temperature</b> minimum	approx. +110 °C
<b>Processing temperature</b> maximum	approx. +135 °C
<b>Processing temperature</b> short-term	approx. +140 °C

### Instructions for use

Acclimatise the product before the application.

For this purpose, the bending fluid in the immersion tank is heated up to a bending temperature of +110 °C to +135 °C by means of an electrical heating. A continuous temperature of +140 °C should not be exceeded, if possible. To achieve a homogeneous heating distribution in the bending fluid, we recommend a slight circulation in the immersion tank. To maintain the properties of the bending fluid as long as possible, the profiles/materials to be bent should be de-dusted before submerging. If their surfaces are dirty, they should even be cleaned with COSMO® CL-360.110. The profiles are submerged into the bending fluid until they have reached the required bending temperature. The bending aids/stabilizers are inserted in the hollow space. The profile is clamped in the new mould and cools down / solidifies here. The stabilizers are removed from the profile. The bending fluid which is on the surfaces and the profile is washed away with water or flushed through.

Due to the temperature of +135 °C, the acryl surfaces could become shining!

The immersion time, as well as the necessary immersion temperature can only be determined accurately by self-tests because they are strongly influenced by material characteristics, material thickness and other criterions.

### 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

Surfaces/profiles with residues of bending fluid are cleaned with water.



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**Bending fluid**

Depending on the pollution, the bending fluid in the immersion tank is sieved and circulated with mechanically acting fine-screen pumps at a bath temperature of approx. +60 °C to +70 °C. The immersion tank is cleaned with water.

**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**

PE-hobbock, net weight: 35 kg

Bung hole drum, net weight: 250 kg

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