

COSMOPLAST 500, 500L, 507, 513 CA instant glues

APPLICATION

COSMOPLAST instant glues, quickly hardening one-component-adhesives, are suitable for the manual and industrial trade. They are used in different industry fields, e.g. the sealing technique, the sewage technique, the PVC- and metal-processing industry, first of all for the bonding of diverse rubber- and PVC-surfaces, and are only suitable for professional use by instructed personnel.

The types **COSMOPLAST 500, 500L** and **507** are mainly used in the window manufacturing for the bonding of APTK (EPDM) sealing profiles. They are suitable for the bonding of APTK (EPDM)-sealings with miter cuts and also for the bonding of APTK (EPDM) sealings with PVC-hard- and aluminium-profiles.

The types **COSMOPLAST 500** and **500L** can, in connection with the **primer COSMOPLAST 588***, be used for the bonding of silicone- and TPE-sealings.

The type **COSMOPLAST 513** is mainly used for very elastic joint- and miter cut bondings, especially for cellular rubber bondings, e.g. the switch cabinet production.

COSMOPLAST 500, 500L and **507** excel particularly with their short setting times. They have a good cold-, heat- and weather resistance.

TECHNICAL DATA

BASIS	Ethylcyanoacrylate		
FILM PROPERTY	of hardened up film COSMOPLAST 500, 500L, 507 COSMOPLAST 513		hard elastic
VISCOSITY	according to the cone and plate viscometer (3.000 s ⁻¹) COSMOPLAST 500 COSMOPLAST 500L COSMOPLAST 507 COSMOPLAST 513	approx. approx. approx. approx.	20 mPa.s 100 mPa.s 20 mPa.s 70 mPa.s
DENSITY	according to EN 542 at +20°C	approx.	1,05 g/cm ³
CURING TIME	APTK/APTK COSMOPLAST 500 COSMOPLAST 500L COSMOPLAST 507 COSMOPLAST 513	approx. approx. approx. approx.	3 sec 4 sec 4 sec 15 sec
FINAL SETTING TIME	at +20°C, 50% rel. air humidity	approx.	16 h
SOFTENING RANGE	COSMOPLAST 500, 500L, 507 COSMOPLAST 513	approx. approx.	+80 °C +65 °C

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CA instant gluesWORKING INSTRUCTIONS

COSMOPLAST 500, 500L, 507, 513 are applied directly from the dosing bottle, or with the CA-dosing device, onto one side of the surfaces to be bonded, which must be dry and free from grease and dust.

The cleaning of the surfaces to be bonded can be made with **COSMOFEN 60** or **COSMOFEN 10**, or, if necessary, with acetone, depending on the resistance of the surface.

The surfaces to be bonded are joined within the open time of the used type of adhesive and pressed together until the necessary functional hardness has been reached.

Cyanoacrylate instant glues harden up influenced by humidity and temperature.

Because of the relatively low viscosities of the described types, these adhesives cannot withstand a tension >0,1mm on the adhesive gap. For the bonding of bigger gaps, e.g. **COSMOPLAST 516** and **COSMOPLAST 564** are at your disposal.

In order to reduce the press time or to accelerate the hardening of cyanoacrylate adhesives in thicker adhesive gaps >0,1mm, the **accelerator COSMOPLAST 584** is used.

For the bonding of the outside lying glass bar seal in window construction, additionally to the bonding of the miter cuts with instant glues, the ift Rosenheim (institute for window technique) also recommends to bond the profile angle onto the window glass by means of a neoprene rubber filling or sealing compound in order to achieve a permanent tightness during driving rain.

- * **Bonding of aluminium:** Only possible on chemically pre-treated or lacquered surfaces. Bright aluminium can only be bonded with a long-lasting aging resistance with a suitable pre-treatment of the surfaces to be bonded - please, refer to our technical information.
- * Bondings of materials with different linear expansion must be evaluated regarding their long-time performance particularly when loading in application areas with changing temperatures.
- * For the bonding of silicone- and TPE-profiles, preliminary tests are absolutely necessary, because of the variety of materials.
- * Please consider the advices in the technical data sheets of the mentioned products.

APPLICATION QUANTITY depending on the kind of bonding, drop by drop

OPEN TIME, as well as the individual PRESS TIMES, can only be found out through own tests, as they are strongly affected by material, temperature, application quantity, air humidity, material humidity, thickness of the adhesive film, pressure, and other criteria. The user should provide adequate security additions to the given approximate values.

CLEANING

The cleaning of not hardened up **COSMOPLAST cyanoacrylate adhesives** is made with **COSMOPLAST 597**. The cleaning (rinsing out) of the **CA-dosing device** from not hardened up adhesive is effected with **COSMOPLAST 596**.

The cleaning of hardened up cyanoacrylate adhesives is usually made mechanically.

On particularly solvent-resistant surfaces, it is possible to remove completely, even hardened up adhesive, when proceeding as described in the technical data sheet of **COSMOPLAST 595**.

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STORAGE

Can be stored in tightly closed original casks, dry, at a temperature between +15°C and +25°C, without direct solar radiation, for approx. 6 months.

At a storage temperature of +6°C (refrigerator), storable for approx. 12 months.

CASK SIZE

20 g PE-bottle, dispatch unit: 20 bottles /box

50 g PE-bottle, dispatch unit: 10 bottles /box

500 g PE-bottle

5 kg PE-canister

10 kg PE-canister

Other cask sizes are available on request.

Accessories:

COSMOPLAST CA-capillaries (dosing cannulas)

COSMOPLAST 584 (accelerator)

COSMOPLAST 588 (primer-polyolefine)

COSMOPLAST 595 (cleaner)

COSMOPLAST 596 (cleaner)

COSMOPLAST 597 (cleaner)

CLASSIFICATION

COSMOPLAST CA-adhesives are **subject to classification**, according to the Ordinance on Hazardous Materials (GefStoffV).

Further information for the process can be taken from the safety data sheet, according to 91/155/EEC.

Our instructions for use, processing directives, product- or performance indications, as well as other technical statements are only general guidelines; they only describe the nature of our products (determined value at the production time) and their performance, but they give no guarantee in accordance with paragraph 443 of the BGB (Civil Code). Due to the variety of application purposes for each product, and due to a lot of different particular conditions (e. g. processing parameters, material properties, etc.), the user has to carry out his own individual qualifying tests. Our consultation in application technique, verbal and in writing, as well as with tests, is offered free of charge and is not legally binding.

These documents replace former issues