

COSMOPUR Constructive 1-part polyurethane Constructional adhesive

APPLICATION

COSMOPUR Constructive is only intended for professional use, in the wood window Construction for the slot-/tap-bonding, as well as in the field of wood front doors, e.g. for the joint board bonding of cassettes; here, you obtain a good compound bonding strength and a high heat resistance.

COSMOPUR Constructive is used for the bonding of corner angles in the aluminium-window-construction (tested by the **ift-Rosenheim, test report 50930583/1** of 24.11.2005 „**Examination of tensile strengths of bonded frame edges of aluminium-compound-profiles**“) - Only suitable for professional use by instructed personnel.

COSMOPUR Constructive has an excellent adhesion on different wood- and Construction materials, ceramics, metals, thermo- and duro-setting plastics, forwarded the surfaces have been pre-treated accordingly.

COSMOPUR Constructive obtains, for the bonding of wood/wood, without any addition of hardener, the strain group D4 according to EN 204 (**ift, Rosenheim, Prüfbericht 505 28900/1** of 12.10.2004) and also fulfils the requirements of the window Construction, according to WATT 91 (tested by **ift, Rosenheim, Prüfbericht 50528900/2** of 12.10.2004).

TECHNICAL DATA

BASIS	1-part moisture cross-linked polyurethane, solvent-free (Free from easy volatile organic compounds, boiling point <+200 °C)		
COLOUR	of hardened up film		transparent- opaque
FILM PROPERTY	of hardened up film		semi-hard
VISCOSITY	at +20°C		low viscosity - thixotrope
DENSITY	according to EN 542 at +20°C	approx.	1,12 g/cm³
FILM FORMATION TIME - dry	at +20°C, 50%rel. air humidity, application quantity 500µm-PE/PVC	approx.	10 min
FILM FORMATION TIME - wet	at +20°C, sprayed with water, application quantity 500µm-PE/PVC	approx.	5 min
FUNCTIONAL HARDNESS	e.g. bonding of solid timber at +20°C	from	30 min
FINAL SETTING TIME	at +20°C, 50% rel. air humidity up to ~75% until final setting has been achieved	approx. approx.	24 h 7 d
MINIMUM TEMPERATURE FOR APPLICATION		from	+7 °C

WORKING INSTRUCTIONS

The surfaces of the substrates to be bonded must be first dry and dust- and grease-free.

COSMOPUR Constructive is applied onto one of the parts to be bonded (caterpillar-shaped), directly from the cartridge. In order to obtain shorter/controlled reaction times, the applied adhesive is moistened. The parts to be bonded are joined within the FILM FORMATION TIME (after the moistening, max. 5min) and pressed together, until functional hardness has been achieved.

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WORKING INSTRUCTIONS

- * **Advice:** The viscosity of 1-part polyurethane adhesives is twice as high when processing at +15°C as at +25°C.
- * **Bonding of aluminium:** only on chemically pretreated or lacquered surfaces; durable and non-aging bondings of aluminium blank cannot be achieved without the corresponding pretreatment of the surfaces to be bonded – 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.
- * The adhesive changes its colour if it is exposed to the sun (ultraviolet radiation), but its bonding strength does not change !
- * Bonding of solid timber/solid timber: the pressure should be possibly >1N/mm².

APPLICATION QUANTITY depending on supporting material approx. 200 g/m²

FILM FORMATION TIMES, as well as the individual PRESS TIMES, can only be exactly found out through own tests, as they are strongly affected by material, temperature, application quantity, humidity, and other criteria. The user should provide adequate security additions to the given approximate values.

CLEANING

Not hardened up **COSMOPUR Constructive** is cleaned with **COSMOFEN 60**.

The cleaning of hardened up **COSMOPUR Constructive** is usually only mechanically possible, but for solvent-resistant surfaces, **COSMOPLAST 595** and **COSMOKLAR MR-cleaning set** are also available on demand.

STORAGE

Store in tightly closed original casks, in a dry place, at a temperature between +15 and +25°C, without direct solar irradiation.

Can be stored in original casks for 12months. During the storage time, the viscosity rises.

CASK SIZES

310 ml (345g)-PE-euro cartridge, dispatch unit: 20cartridges/box
600 ml (670g)-Alu/PE-tubular bags, dispatch unit: 20bags/box
1.000 ml (1.100g)-Alu-cartridges, dispatch unit: 6cartridges/box

CLASSIFICATION

COSMOPUR Constructive is **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/CEE.

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