COSMOFEN 345
Assembly Sealing Substance

APPLICATION

COSMOFEN 345 is mainly used in the PVC-window manufacturing, to seal additional profiles during the assembling of the elements. COSMOFEN 345 is used by specialised companies for a quick constructional bonding of PVC-hard-materials, e.g. in the window manufacturing to bond additional profiles like weather-boarding, water bars, blind components, etc., and also to bond cover caps, drainage, protection stripes for shutters into PVC-profiles, as well as for the sealing of cross-bar (in T) connections. Also to bond cover-/end caps onto PVC-hard profiles, e.g. stakes.

In the exhibition and label production, for the constructional bonding of PVC-hard integral foam plates with diverse materials.

COSMOFEN 345 has a wide adhesion spectrum on a lot of materials, e.g. PVC-hard, powder-coated aluminium, building materials.

COSMOFEN 345 possesses long-lasting, non-aging, tough elastic film properties as well as a good weathering resistance and UV-stability.

COSMOFEN 345 is thixotropic (does not drop); compared with PVC-diffusion adhesives, it has a lower shrinkage behaviour and therefore can be used for joint sealing up to 7mm (275.6mil), e.g. between window sill and window profile (not suitable for expansion joints according to DIN 18540, etc.).

TECHNICAL DATA

BASIS
diffusion adhesive, thermoplastic polymers in solvents

COLOR
of hardened up film

COSMOFEN 345 white white
COSMOFEN 345 transparent transparent-opaque

FILM PROPERTY
of hardened up film elastic

VISCOOSITY
+20°C (+68°F) medium viscosity - paste-like

DENSITY
EN 542 at +20°C (+68°F) approx. 1.01 g/cm³ (8.43 lb/gal)

OPEN TIME
at +20°C (+68°F), 50% r.h. application quantity 150µm (5.9mil)-glass approx. 45-60 s

FUNCTIONAL HARDNESS
bonding of tension-free strips approx. 8-10 min

FINAL SETTING TIME
at +20°C (+68°F), 50% r.h. approx. 24 h (~80 %)

MINIMUM TEMPERATURE FOR APPLICATION
from +5 °C (+41°F)

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Quality Certificate Registration No.: 302640 QM
WORKING INSTRUCTIONS

Before starting to bond, dirt, grease, humidity and other possible impurities have to be removed from the surfaces to be bonded, preferentially with COSMOFEN 60. Use only non-staining and lint-free cleaning clothes.

COSMOFEN 345 is applied one-sided bead-like (wave-shaped) onto the surface to be bonded. The parts to be bonded are joined together within the OPEN TIME and fixed/pressed until functional hardness has been achieved.

When used as joint compound, COSMOFEN 345 doesn’t need to be polished.

Loading capacity of the glued joint: after 16 hours; the final setting of the glued joint can last, depending on given factors, up to 8 weeks.

* In order to optimise the compound strength, we recommend to principally pre-clean non-absorbent surfaces with solvent cleaners of our COSMOFEN product range, before you start to bond.
* The adhesive can only withstand a tension <0.2mm (7.9mil) on the adhesive gap!
* The quantity of applied adhesive should be chosen depending on the material thickness; the adhesive can penetrate into the material!
* COSMOFEN 345 white has an excellent UV- and weathering resistance; COSMOFEN 345 transparent can discolour more or less depending on the intensity of weathering.
* For the bonding of foil laminated profiles, a solvent-free system, is available, COSMOPLAST 515.
* Not suitable for the bonding of pressures tubes.

Please find further details in our technical information „COSMO PVC-adhesives”

APPLICATION QUANTITY

at bonding strips:
20mm (0.79in) wide bonding surface approx. 8 g/running metre (0.28 oz/running metre)
40mm (1.57in) wide bonding surface approx.16 g/running metre (0.56 oz/running metre)

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

CLEANING

For the cleaning of the working devices from non-hardened up COSMOFEN 345, COSMOFEN 20 is suitable.
The cleaning of COSMOFEN 345 from PVC-hard profiles takes place after the air has been exhausted from around the product; then, a a draw blade is used and, if necessary, a subsequent treatment is made with COSMOFEN 5.

STORAGE

Store in tightly closed original casks, in a dry place, at a temperature between +15°C (+59°F) and +25°C (+77°F), without direct solar irradiation.
Can be stored in unopened original casks:
COSMOFEN 345 white 18 months
COSMOFEN 345 transparent 12 months
During the storage time, the viscosity rises.

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CASK SIZE

305g (10.8oz) cartridge, dispatch unit of 20 cartridges per box.

CLASSIFICATION

The classification of the product is described in the material safety data sheet.

FLAMMABLE LIQUID AND VAPOR.
HARMFUL IF SWALLOWED. OVEREXPOSURE MAY CAUSE DIZZINESS, DROWSINESS, LIVER, KIDNEY AND CENTRAL NERVOUS SYSTEM.
MAY CAUSE HARM TO UNBORN CHILD
MAY CAUSE LUNG DAMAGE IF SWALLOWED.
IRRITANT TO SKIN, EYES AND RESPIRATORY PASSAGES.
MAY CAUSE EYE DAMAGE

Consult MSDS for additional information.
Keep away from heat, sparks, flames or hot surfaces.
Use only with adequate ventilation
Avoid breathing vapor.
Avoid contact with eyes, skin or clothing.
Wash thoroughly after handling.
Do not ingest.

FOR PROFESSIONAL USE ONLY ! KEEP OUT OF REACH OF CHILDREN !
KEEP HOBBOCK, DRUM, CONTAINER, e.g. TIGHTLY CLOSED !
USE ONLY FOR APPLICATIONS MENTIONED IN THE TECHNICAL DATA SHEET !
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This document replaces former issues

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