COSMOCOLL 204
2-component-D4-glue

APPLICATION
COSMOCOLL 204 is used for the assembly-, surface-, board gap- and block bonding, when higher demands on the water resistance have to be fulfilled. Only for professional use by instructed personnel.
COSMOCOLL 204 is suitable for the bonding of soft-, hard- and exotic wood, for cold-bonding and heat sealing as well as for high-frequency bonding.
COSMOCOLL 204 is mainly used in the window- and door manufacturing, especially for the lamination of window square sections.
COSMOCOLL 204 obtains, when adding 5% of the transparent hardener COSMOCOLL 231, for wood/wood bondings, the strain group D4 according to EN 204, as well as heat adhesive strengths according to WATT 91; also the criteria mentioned in the ift-directives „Bondings on wood windows“ are fulfilled.

TECHNICAL DATA

BASIS
dispersion glue on PVAc (polyvinylacetate)

FILM PROPERTY
of the hardened up film

MIXING RATIO
parts by weight 204 : hardener= 100 : 5 g
parts by volume 204 : hardener= 100 : 4 ml

VISCOSITY
Brookfield Sp06/20, +20°C
COSMOCOLL 204 approx. 17,000 mPa.s
after mixture with 5% hardener approx. 8,500 mPa.s

DENSITY
according to EN 542 at +20°C approx. 1,1 g/cm³

PH-VALUE
according to EN 1245 approx. pH 4-5

OPEN TIME
of the glue liquor at +20°C,
50% rel. air humidity,
application quantity 150µm-beech approx. 8 min

POT TIME
of a 100 g preparation at +20°C
at 5% COSMOCOLL 231 (transparent) until 7 days

HEAT ADHESIVE STRENGTH
according to WATT 91 at +80°C approx. 7,5 N/mm²

MINIMUM TEMPERATURE
FOR APPLICATION from +5 °C

WORKING INSTRUCTIONS
COSMOCOLL 204 obtains, by adding 5% hardener COSMOCOLL 231 (transparent), the strain group D4 (DIN 68602-B4) according to EN 204; the pot time of the mixed glue will last for approx. 7 days.
* A high temperature influence on the mixed adhesive reduces the pot time!
* Please pay attention to our advices in the technical information „Wood/wood bonding in the outside area“ as well as in the ift-directive: “Bondings of wood windows“!
WORKING INSTRUCTIONS

Without the addition of hardener, COSMOCOLL 204 obtains the strain group D2 according to EN 204. COSMOCOLL 204 is usually applied onto one side of the supporting material, with a tooth spatula, a glue roller or a gluing machine. Lay and press together the parts to be bonded within the OPEN TIME, until the necessary functional hardness has been reached.

* Contact with metals, e.g. iron, may result in discolorations!
* Because of the contained materials, discoloration may exceptionally happen on different wood varieties.

APPLICATION QUANTITY

depending on supporting material approx. 150 g/m²

PRESS TIME

<table>
<thead>
<tr>
<th>bonding technique</th>
<th>press temperature [°C]</th>
<th>press time [min]</th>
</tr>
</thead>
<tbody>
<tr>
<td>gap bonding</td>
<td>+20</td>
<td>22</td>
</tr>
<tr>
<td>high frequency bonding</td>
<td>+20</td>
<td>0.5-4</td>
</tr>
<tr>
<td>surface bonding</td>
<td>+20</td>
<td>15</td>
</tr>
<tr>
<td>surface bonding</td>
<td>+60</td>
<td>10</td>
</tr>
</tbody>
</table>

PRESSURE

0,2-0,4 N/mm²

POT TIME/OPEN TIME, 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 COSMOCOLL 204 is removed from the tools with water.
Hardened up COSMOCOLL 204 can be removed from the tools with COSMOFEN 10.

STORAGE

Store in tightly closed original casks, in a dry place, at a temperature between +15°C and +25°C, without direct solar irradiation. Can be stored in unopened original casks for approx. 12 months.
Agitate before use!

CASK SIZE

12 kg-PE-bucket, 30 kg-PE-drum; other cask sizes: available on demand.
Accessories:
600 g- and 1500 g- PE-bottles COSMOCOLL 231-hardener, transparent.

CLASSIFICATION

COSMOCOLL 204 is not subject to classification, according to the Ordinance on Hazardous Materials ( GefStoffV ).

Further information for the process can be taken from the safety data sheet.