

COSMOHYBRID 490 **1-part STP-Adhesive**

APPLICATION

COSMOHYBRID 490 is a new adhesive with particular product properties.

Thanks its wide adhesion spectrum, **COSMOHYBRID 490** is used for a lot of different kinds of applications, especially in the vehicle manufacturing and vehicle superstructures. - Only for professional use by instructed personnel.

COSMOHYBRID 490 is used in the wood-/aluminium window and door manufacturing for the bonding of the aluminium corner angles of the external frame (anodised or powder-coated), as well as for the bonding of strips in general and for the bonding of sandwich elements for facades. - Only for professional use by instructed personnel.

COSMOHYBRID 490 has an excellent adhesive strength on different metals, derived timber products, duro- and thermoplastics, building materials, ceramics and glass, forwarded the surfaces have been prepared accordingly; also at a low working temperature from 0°C on. **COSMOHYBRID 490** can be over-painted after it is hardened up. **COSMOHYBRID 490** has in hardened up state an elastic glued joint with good weathering resistance.

COSMOHYBRID 490 is free of silicone and isocyanates.

TECHNICAL DATA

BASIS	1-part moisture cross-linked STP-polymer		
COLOUR	of hardened up film		white
FILM PROPERTY	of hardened up film		elastic
SHORE-HARDNESS	of hardened up film according to DIN 5305 Shore-A	approx.	70-75 Shore-A
VISCOSITY	at +20°C		medium viscosity - paste-like
DENSITY	according to EN 542 at +20°C	approx.	1,60 g/cm ³
FILM FORMATION TIME - dry	at +20°C, 50 % rel. air humidity, application quantity 500µm-PE/PVC	approx.	9 min
FINAL SETTING TIME	at +20°C, 50 % rel. air humidity, 3 mm adhesive in caterpillar shape	approx.	24 h
MINIMUM TEMPERATURE FOR APPLICATION		from	0 °C

WORKING INSTRUCTIONS

COSMOHYBRID 490 is applied directly from the cartridge onto the surface to be bonded, which must be first dry and grease- and dust-free. At bonding non-absorbent materials with each other, it is recommended to additionally spray with water (finely disperse with water) the applied adhesive, in order to obtain a complete hardening; at bonding the workpieces, please pay attention that no reaction humidity is rubbed into the adhesive, e.g. when rubbing/positioning the workpieces against each other.

COSMOHYBRID 490
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page 2

WORKING INSTRUCTIONS

The workpieces are joined together and fixed/pressed, until functional hardness has been achieved.

Workpieces which have been bonded with **COSMOHYBRID 490** should be over-painted only after the complete hardening of the adhesive; otherwise a formation of blister may happen.

Temperature resistance after hardening up: from -30°C to +80°C; short-term up to +120°C.

COSMOHYBRID 490 does not swell (foam) during the setting process.

* **Bonding of aluminium:** only on chemically pre-treated or lacquered surfaces; durable and non-aging bonding of aluminium blank cannot be achieved without the corresponding pre-treatment of the surfaces to be bonded.

* 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 adhesion properties of the single colours can differ.

**Please observe the advices in the technical information:
“Metal bonding “**

FILM FORMATION 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, thickness of adhesive film, pressure, and other criteria. The user should provide adequate security additions to the given approximate values.

CLEANING

Non hardened up **COSMOHYBRID 490** is cleaned with **COSMOFEN 60**.

The cleaning of hardened up **COSMOHYBRID 490** is generally only mechanically possible.

STORAGE

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

Storability in unopened original casks: 12 months.

CASK SIZE

No stock standard.

290ml (460g) PE-euro-cartridge, dispatch unit of 12 pieces per box,
600ml (950g) Alu/PE-tubular bag, dispatch unit of 12 pieces per box,
other cask sizes are available on demand.

CLASSIFICATION

COSMOHYBRID 490 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.

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.

This document replaces former issues