

**COSMOCOLL FL 37**  
1-part window glue

APPLICATION

**COSMOCOLL FL 37** is used for assembly-, surface-, board gap- and block bonding, when higher demands on the water resistance have to be fulfilled. - Only suitable for professional use by instructed personnel.

**COSMOCOLL FL 37** is suitable for the gluing of soft-, hard- and exotic wood and used in specialised companies for cold- and warm-setting and high-frequency bonding.

**COSMOCOLL FL 37** is especially used in the window- and door manufacturing for the gluing of corner angles.

**COSMOCOLL FL 37** obtains, at bonding wood/wood, without any addition of hardener, the strain group D3 according to EN 204; heat adhesive strength: approx. 7,1N/mm<sup>2</sup> according to WATT 91.

**COSMOCOLL FL 37** obtains, at bonding wood/wood, by adding 5% hardener **COSMOCOLL 234** the strain group D4 according to EN 204; heat adhesive strength: approx. 8N/mm<sup>2</sup> according to WATT 91.

**We recommend you to consult the ift-directive „Bonding on wood windows“!**

TECHNICAL DATA

BASIS	dispersion glue on PVAc-basis ( polyvinyl acetate )		
FILM PROPERTY	of hardened up film		tough elastic
VISCOSITY	Brookfield Sp06/20, +20°C	approx.	14.000 mPa.s
DENSITY	according to EN 542 at +20°C	approx.	1,1 g/cm <sup>3</sup>
PH- VALUE	pH-value according to EN 1245	approx.	pH 3
OPEN TIME	at +20°C, 50% rel. air humidity, application quantity 150µm-beech	approx.	12 min
HEAT ADHESIVE STRENGTH	according to WATT 91 at +80°C	approx.	7,1 N/mm <sup>2</sup>
MINIMUM TEMPERATURE FOR APPLICATION		from	+7 °C

WORKING INSTRUCTIONS

**COSMOCOLL FL 37** obtains, as one-part window glue, without any addition of hardener, the strain group D3 according to EN 204 and fulfils the requirements of the ift-directive.

**\* 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”!**

**COSMOCOLL FL 37** can be processed directly after the delivery cask has been stirred up.

**COSMOCOLL FL 37** can be mixed with 5% hardener **COSMOCOLL 234**, in order to obtain the strain group D4. After the glue has been mixed with the hardener, the D4-properties will last for approx. 8-10h, after this, you can continue to process **COSMOCOLL FL 37** as D3-glue, but it is not possible to add hardener once again.

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WORKING INSTRUCTIONS

**COSMOCOLL FL 37** is usually applied one-sided onto 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, for different wood varieties discolorations may exceptionally happen !

APPLICATION QUANTITY depending on supporting material approx. 150 g/m<sup>2</sup>

PRESS TIME

bonding technique	press temperature °C	press time min
gap bonding	+20	22
gap preheated to	+60	7
gap preheated to	+80	3,5
high frequency bonding		0,5-4
surface bonding	+20	15
surface bonding	+60	10

PRESSURE 0,2-0,4 N/mm<sup>2</sup>

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 FL 37** can be removed from the tools with water.

Hardened up **COSMOCOLL FL 37** 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. 12months.

Agitate before use!

CASK SIZE

- 12 kg PE-bucket,
  - 30 kg PE-drum,
  - 150 kg PE-drum with clamping ring;
- other cask sizes are available on request.

CLASSIFICATION

**Information 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.*

Replaces former issues

