

COSMOPUR 814 **1-component-polyurethane-adhesive**

APPLICATION

COSMOPUR 814, an adhesive with hard-viscous joint and very short press times, is used as constructional adhesive in the wood processing and other industrial fields.

COSMOPUR 814 is processed as surface adhesive for different kinds of applications in the industry, e. g. front door production - Only suitable for professional use by instructed personnel.

COSMOPUR 814 is suitable for the bonding of different material surfaces, such as PVC-hard, glass-fiber reinforced plastics (grinded), aluminium, high pressure laminate (HPL), etc. onto diverse insulating materials like PUR, PS-foam and mineral wool.

COSMOPUR 814 obtains, during the wood/wood bonding, the strain group D4 according to EN 204, as well as a heat bonding strength of approx. 10N/mm², according to WATT 91.

COSMOPUR 814 can be overpainted, when hardened up.

TECHNICAL DATA

| | | | |
|-------------------------------------|---|--------------------|------------------------|
| BASIS | 1-component moisture cross-linked polyurethane, solvent-free (free from easy volatile organic compounds, boiling point <+200°C) | | |
| FILM PROPERTY | of hardened up film | | hard-viscous, foaming |
| VISCOSITY | Brookfield Sp06/50, +20°C | approx. | 3.650 mPa.s |
| DENSITY | according to EN 542 at +20°C | approx. | 1,14 g/cm ³ |
| FILM FORMATION TIME - dry | at +20°C, 50%rel. air humidity, application quantity 500 µm-PE/PVC | approx. | 10 min |
| FILM FORMATION TIME - wet | at +20°C, 50%rel. air humidity, application quantity 500µm-PE/PVC | approx. | 5 min |
| PRESS TIME | wood-/wood-bonding at +20°C | approx. | 20 min |
| FINAL SETTING TIME | at +20°C, 50%rel. air humidity at ~75% Until total strength has been achieved | approx. approx. | 16 h 3 d |
| HEAT BONDING STRENGTH | according to WATT 91 at +80°C | approx. | 10 N/mm ² |
| STRESS SHEARING STRENGTH | DIN/EN 205 beech/beech at +20°C | approx. | 13 N/mm ² |
| MINIMUM TEMPERATURE FOR APPLICATION | | from | +7 °C |

WORKING INSTRUCTIONS

COSMOPUR 814 is applied with a spatula or a caterpillar-shape moulding device onto only one surface of the workpieces, which must be dry and free of grease and dust.

* The processing viscosity of 1-component-polyurethane-adhesives is, when processing at +15°C, approximately twice as high as at +25°C. In order to guarantee a controlled hardening, when bonding non-absorbent materials or materials with <8% humidity, the adhesive film is sprayed with water (approx. 10g Water/m² for 150g adhesive/m²). In this case, the workpieces should be joined within the film formation time and pressed together with 0,015N/mm² (~1.500 kp/m²), until the functional hardness has been obtained. **COSMOPUR 814** swells (foams) during the setting process!

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