

**COSMOFEN DUO.200**  
2-part polyurethane adhesive

APPLICATION

**COSMOFEN DUO.200** is suitable for the constructional bonding of aluminium corner angles into anodised or powder-coated cover- and wing-frame profiles, only suitable for professional use by instructed personnel in the aluminium-window-, door- and façade manufacturing.

**COSMOFEN DUO beige** with a pot time of 60 min has been tested by the **ift-Rosenheim** (institute for window technique), **test report no. 50924109/1** of 25th June 2001 „**Examination of the resistance to tensile strength of bonded frame corners of aluminium compound profiles at different temperatures and after diverse conditions of storage**“.

**COSMOFEN DUO.200** is also suitable for the bonding of further materials, e.g. aluminium, HPL.

**COSMOFEN DUO.200** is thixotrope, does not drop, does not contain any solvent and can be overpainted after the hardening up.

**COSMOFEN DUO.200** has a good weather resistance.

TECHNICAL DATA

BASIS	2-part polyurethane reaction adhesive, solvent-free*		
COLOUR	of hardened up film binder hardener		ivory beige-white beige
FILM PROPERTY	of hardened up film		semi-hard
SHORE - HARDNESS	of hardened up film according to DIN 53505		85 Shore-D
MIXING RATIO	parts by volume	A:B	= 1,0:1,0 ml
VISCOSITY	at +20°C mixture binder hardener		low viscosity – paste-like low viscosity – paste-like low viscosity – paste-like
DENSITY	according to EN 542 at +20°C, binder hardener mixture	approx. approx. approx.	1.43 g/cm <sup>3</sup> 1.60 g/cm <sup>3</sup> 1.52 g/cm <sup>3</sup>
POT TIME	of a 100 g preparation at +20°C	approx.	200 min
PROCESSING TIME	with static mixing tube at +20°C (The application times are reduced to approx. half of the time at +30°C, at +10°C they are prolonged to approx. twice as much time.)	approx.	100 min
FUNCTIONAL HARDNESS	e.g. corner angle bondings at +20°C	approx.	18 h
FINAL SETTING TIME	at+20°C, 60% rel. air humidity up to ~75% until functional hardness is achieved	approx. approx.	48 h 7 d
MINIMUM TEMPERATURE FOR APPLICATION		from	+7 °C

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STRESS SHEARING STRENGTH	DIN/EN 1465 Alu/Alu (0.2 mm gap) Alu / Alu at +20°C	approx.	18.0 N/mm <sup>2</sup>
	Alu / Alu at +80°C	approx.	9.0 N/mm <sup>2</sup>

\*according to directive 94/9/EG

WORKING INSTRUCTIONS

The opened adhesive cartridges are inserted into the dosing device.

**\* Attention: Do not interchange binder and hardener!**

By operating the dosing device, both parts are dosed and mixed homogeneously in the static mixing tube „N“. The adhesive is applied by means of a spatula within the pot time onto the dry, dust- and grease-free surface to be bonded are the parts are joined together and fixed/pressed until functional hardness has been achieved.

**\* Aluminium bonding:** Only on chemically pretreated or lacquered surfaces; durable and non-aging bondings of aluminium blank cannot be achieved without the corresponding pretreatment 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 adhesive changes its colour if it is exposed to the sun, but its bonding strength does not change!**Please take notice of the technical information  
“Metal bondings“**

APPLICATION QUANTITY      average      approx. 20 g/corner angle

POT 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.

CLEANINGNot hardened up **COSMOFEN DUO.200** is cleaned with **COSMOFEN 60**.The cleaning of hardened up **COSMOFEN DUO.200** is usually only mechanically possible.STORAGE

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

Can be stored in unopened original cask for approx. 12 months.

CASK SIZE

1,000 ml aluminum cartridge (unit 3,030 g), 3 units per box

**Accessories:**  
**static mixing tube N**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.*

This document replaces former issues