

OTTOCOLL® P 520

This quick guide is intended as a supplement to the system description/general processing guidelines. The adhesive's processing temperature is between +5 °C and +40 °C. Processing is not recommended at temperatures above or below this range!



- 1 OTTOCOLL® P 520
- 2 OTTO Static mixing nozzle KWM 10 or OTTO Static mixing nozzle KWM 18K or OTTO Static mixing nozzle RWM 14G
- 3 OTTO Compressed Air Gun P2x310

For processing the double cartridge 2x 190ml or 2x 310ml (mixture ratio 1:1) the OTTO compressed air gun P2x310 is recommended. Maximum pressure: 5 bar for processing with compressed air guns.

If suitable **battery guns** are used for twin cartridges in the mixture ratio 1:1, the extrusion force must not exceed 5 kN and the feed speed of the printing plates must be < 200mm/min.

Wear suitable protective equipment (safety goggles, gloves etc.) when working with adhesives and chemicals.



1. Preparing to process the adhesive



Insert the cartridge into the gun tray, unscrew protective cap and remove plug



Press out the material **without** the static mixing nozzle until it escapes from **both** openings



Clean off material and screw on static mixing nozzle



Refill the static mixing nozzle with adhesive and check the homogeneity of the mixture (see the quality checks for 2-component products to be carried out during processing)

2. Pre-treating the adhesive surfaces – Cleaning

The adhesive areas must be thoroughly cleaned and any contamination such as release agents, preservatives, grease, oil, dust, water, old adhesives/sealants and other substances impairing adhesion must be removed.

Cleaning of non-porous surfaces: Cleaning with OTTO Cleaner T and a clean, lint-free cloth.

Cleaning of porous surfaces: Clean surfaces mechanically, e.g. with a steel brush or a grinding wheel, to eliminate loose particles. The adhesive surfaces must be clean, non-greasy, dry and load-bearing.

3. Bonding

The open time of the adhesive must be respected during bonding. If the static mixing nozzle is to be left standing for a longer period of time, it must be replaced in order to prevent hardening.