

## The 2-component PU adhesive for bonding corners

2-component adhesive based on polyurethane

For indoor and outdoor application

P 520 SP 6319

### Characteristics

- ▶ Fast curing even in thick layers - Fast further processing
- ▶ Reliable curing in a defined period of time - Predictable handling and functional strength
- ▶ Non-shrink curing - No volume shrinkage

### Fields of application

- ▶ Weathering resistant bonding of corner joints on metal windows, doors and façades as well as conservatories
- ▶ General bonding in metal construction
- ▶ Also suitable for firm bonding of very different materials such as wood, metal, plastics, stone etc.

### Standards and tests

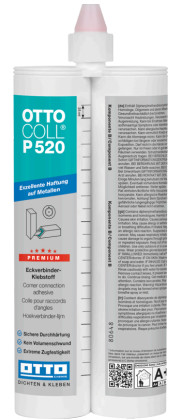
- ▶ According to the requirements of DIN EN 204-D4 to weathering resistant bondings of wood and derived wood products
- ▶ According to the requirements of DIN EN 14257 (WATT 91) to temperature-resistant bondings of wood and derived wood products
- ▶ French VOC-emission class A+
- ▶ Meets the requirements for fire behavior according to EN 13501: Class E
- ▶ Suitable for applications according to IVD instruction sheet no. 30+35 (IVD = German industry association sealants)

### Technical properties

|  |                          |
|--|--------------------------|
| Pot life at 100 g, 23 °C/50 % RH [minutes]   | ~ 20                     |
| Processing time (100 g, 23 °C/50 % RH) [minutes]   | ~ 15                     |
| Mixing ratio according to volume (base A : curing agent B)   | 1 : 1                    |
| Processing temperature from/to [°C]  | + 5 / + 35               |
| Viscosity at 23 °C   | pasty, stable            |
| Density component A at 23 °C according to ISO 1183-1 [g/cm <sup>3</sup> ]                          | ~ 1,44                   |
| Density component B at 23 °C according to ISO 1183-1 [g/cm <sup>3</sup> ]                          | ~ 1,55                   |
| Temperature resistance from/to [°C]  | - 30 / + 80 <sup>1</sup> |
| Achievement of the functional strength of corner angle bonds at 23 °C/50 % rel. hum. after [hours] | ~ 5                      |
| Final strength at 23 °C/50 % RH after [days]   | ~ 3                      |
| Shelf life at 23 °C/50 % RH [months]   | 12 <sup>2</sup>          |

1) temporarily + 100 °C

2) from production



These data are not suitable for the issue of specifications. Please contact OTTO-CHEMIE before issuing specifications.

### Pretreatment

The adhesive surfaces must be 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 substrates: Clean with OTTO Cleaner T (no flash-off time required) and a clean, lint-free cloth. Cleaning porous substrates: Clean surfaces mechanically, e.g. with a steel brush or a grinding disc, to remove loose particles. The adherent surfaces have to be clean, free from fat, dry and sustainable.

### Important information

Before applying this product the user has to ensure that the materials in the area of contact (solid, liquid and gaseous) are compatible with it and also amongst each other and do not damage or alter (e. g. discolour) each other. As for the materials that will be used at a later stage in the surrounding area of the product the user has to clarify beforehand that the substances of content or evaporations do not lead to an impairment or alteration (e. g. discolouration) of the product. In case of doubt the user should consult the respective manufacturer of the material.

For bondings outside, influenced by humidity and/or UV-radiation we advise the use of our STP or hybrid adhesives. Excepted from this is the weather-stressed bonding of wood and wood materials with subsequent protective paint according to DIN EN 204 D4.

Paints, lacquers, plastics and any other coatings must be compatible to the adhesive/sealant.

Special application guns for twin-cartridges are available.

Clean the tools, e.g. spatula, with OTTO Cleaner MP before the adhesive has cured.

The cured adhesive can only be removed mechanically.

In case of UV-radiation stress discolourations may occur.

Not suitable for the bonding of glass, polyethylene (PE), polypropylene (PP), polyamide (PA), polyfluoroethylene (PTFE), bituminous, waxy or oily substrates or similar.

### Application information

Processing of 2-component adhesives and sealants out of side-by-side cartridges:

First of all remove the lids of both component's chambers. Place cartridge into the pistol. Squeeze out material, until material comes out of both chambers. Wipe off material and attach the static mixing nozzle. Check homogeneity of the mixture.

Apply adhesive and assemble parts immediately, if possible, at the latest however within the processing time.





Due to the many possible influences during and after application, the customer always has to carry out trials first.

Please observe the recommended shelf life which is printed on the packaging.

We recommend to store our products in unopened original packagings dry (< 60 % RH) at temperatures of +15 °C up to +25 °C. If the products are stored and / or transported at higher temperatures / air humidity for longer periods (some weeks), a diminution of durability or a change of material characteristics may arise.

Protective goggles must be worn when working with the product. Maximum working pressure 5 bar when working with the product using compressed air guns.

### Packaging

| <b>2x190 ml plastic twin cartridge</b>  |                |
|---|----------------|
|  <b>cream white</b>  | SP6319-15-C635 |
|  <b>dark brown</b>   | on request     |
|  <b>olive yellow</b> | on request     |
|  <b>RAL 7004</b>     | on request     |
| <b>Pieces per packaging unit</b>  | <b>10</b>      |
| <b>Pieces per pallet</b>  | <b>600</b>     |

#### 1 OTTO static mixing nozzle KWM 18K is supplied with each cartridge

Due to typographical reasons the colours shown below may differ from the original colours of the products.

### Safety precautions

Please observe the material safety data sheet.

Only for commercial users.

After curing, the product is odourless.

### Disposal

Information about disposal: Please refer to the material safety data sheet.

## Warranty information

The above information and our technical application advice, whether verbal, in writing or by means of tests, are provided to the best of our knowledge, but are non-binding, including with regard to any third-party property rights. The information in this publication does not exempt the processor from carrying out their own tests on our products with regard to their suitability for the intended processes and purposes. The application, use and processing of our products and the products manufactured on the basis of our technical application advice are beyond our control and are therefore the sole responsibility of the processor. If the application for which our products are used is subject to an official authorisation requirement, the user is responsible for obtaining these authorisations. We reserve the right to adapt the product to technical progress and new developments. For the rest, we refer to our General Terms and Conditions, in particular with regard to any liability for defects. You can find our GTC at [www.otto-chemie.de](http://www.otto-chemie.de).