

OTTOTAPE Duo 20

The double-sided adhesive tape for direct window glazing

Double-sided adhesive tape made from PE foam with liner

S 81/DUO 20

Characteristics

- ▶ Double-sided adhesion tape with closed-cell PE-Copolymer foam
- ▶ Good initial adhesion
- ▶ No pre-treatment of adherent surfaces necessary
- ▶ Pre-fabricated punchings for the application and dosage of liquid adhesive
- ▶ No further spacers necessary for the adhesion
- ▶ A separate masking to protect the adherent before impregnating and varnishing of wooden windows is not necessary

Fields of application

- ▶ Direct-glazing - Bonding of insulated glass units in the window casements made of PVC, wood and aluminium in combination with OTTOCOLL® S 81



Technical properties

Temperature resistance from/ - 40 / + 90
to [°C]

Processing temperature from/ + 18 / + 35
to [°C]

Thickness of the tape without
liner [mm] 3,2

Total width [mm] 15

Length of the blanking [mm] 50

Width of the blanking [mm] 7

Gap between the blankings
[mm] 10

Consumption of
OTTOCOLL® S 81 per
running meter of OTTOTAPE
Duo 20 [ml] ~ 30

Load capacity per running
meter OTTOTAPE Duo 20 in
combination with
OTTOCOLL® S 81 at +23 °C
[N] ~ 120

Shelf life at 23 °C/50 % RH 24
[months]

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

Pretreatment

The adherent surfaces have to be clean, free from fat, dry and sustainable.

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💡 **Application advice**
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SEALING & BONDING

The substrates must not have adhesive repellent characteristics.

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.

Only applicable in combination with a liquid adhesive. The constructional details have to be checked with our technical service department.

If the adhesion tape is used for bonding on position 1 (exterior side of the insulating glass) or position 4 (interior side of the insulating glass) we recommend to seal the glazing rebate above them with a silicone sealant (e.g. OTTOSEAL® S 110 or OTTOSEAL® S 120). Should the glazing rebate above not be sealed, a direct weathering or subsiding condensation may cause growth of moss or mould on the cutting edge of the tape, if water remains there. Besides a minor embrittlement of the cutting edge is possible because of UV-radiation.

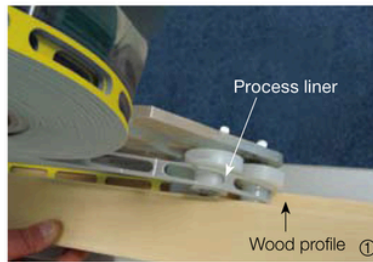
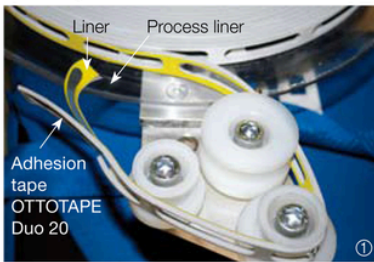
Application information

Precondition for the safe bonding with OTTOCOLL® S 81:

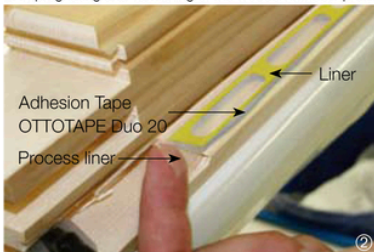
Wood: No pre-treatment, uncoated

PVC: Pre-treatment with OTTO Cleanprimer 1226

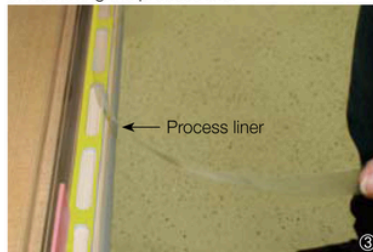
1. Applying the **OTTOTAPE Duo 20** together with the attached process liner from the reel onto the untreated wooden window profile. The full adhesive power of **OTTOTAPE Duo 20** is only reached after at least 24 hours. Our advice is to wait at least that long before you go on impregnating or painting the wooden profile.



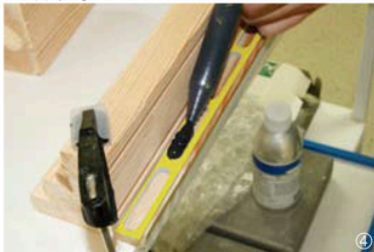
2. Impregnating and varnishing of the wooden window profile



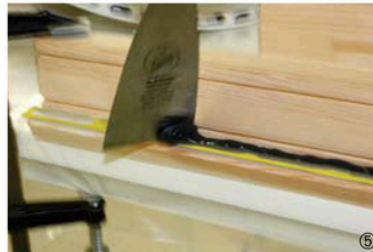
3. Removing the process liner



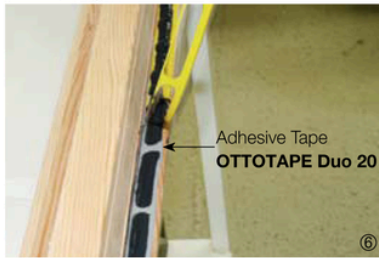
4. Applying the adhesive **OTTOCOLL® S 81**



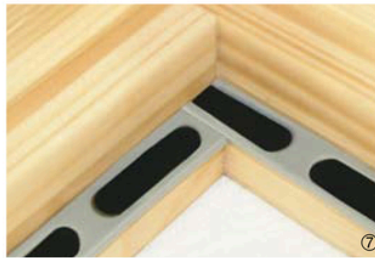
5. Removing excess adhesive with a spatula. Avoid compression of the tape when removing excess adhesive, so that the necessary adhesive layer in the blankings does not fall below the limit.



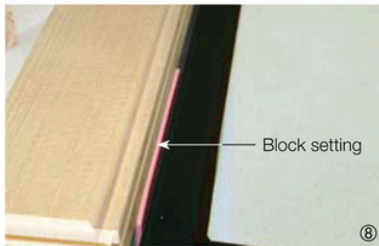
6. Removing the liner



7. Corner connections



8. Mounting the insulating glass pane.
Apply the insulating glass and fix it with a slight and even pressure on the tape in order to ensure a permanent contact between the glass pane and the adhesion tape respectively the adhesive.



Packaging

Glossy colors

	Roll at 25 m
● black	DUO20-C04
Pieces per packaging unit	6
Pieces per pallet	60

Disposal

Product residues can be disposed of along with industrial waste as mixed plastics. Packaging materials (cardboard boxes, foils) are recyclable and hence should be recycled.

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.