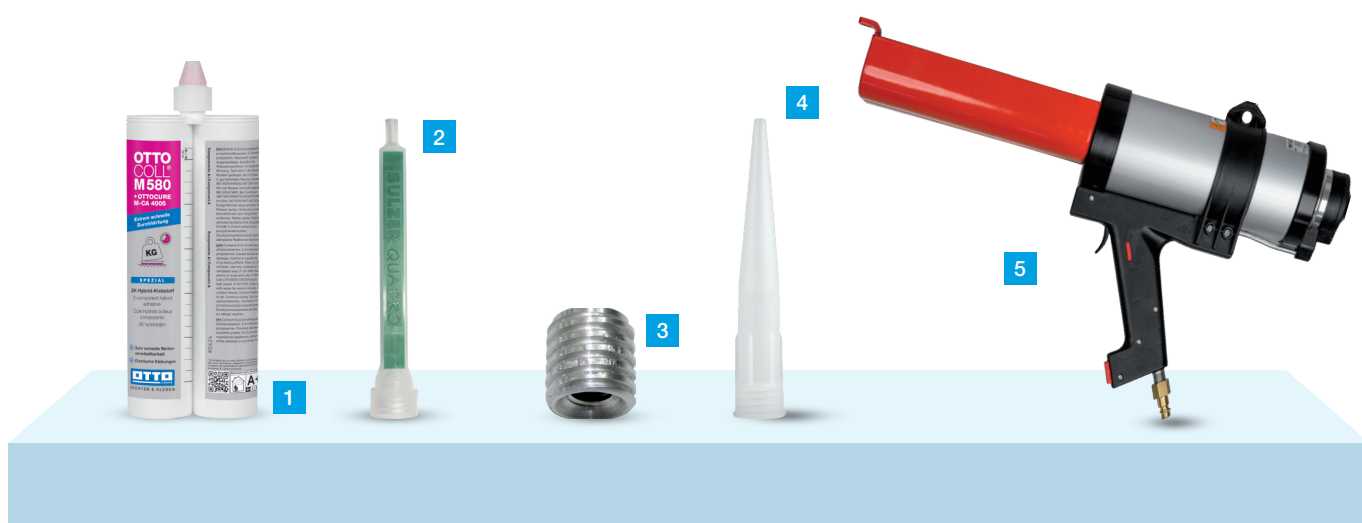


Processing instructions

OTTOCOLL® M 580

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® M 580 (2 x 310 ml)

2 Static mixer MGQ 10-19D

3 Thread attachment

4 Standard cartridge nozzle

5 OTTO compressed air gun P 2x310

For processing the double cartridge 2 x 190 ml or 2 x 310 ml (mixture ratio 1:1) the OTTO compressed air gun P 2x310 is recommended. Maximum pressure: 5 bar for processing with compressed air guns.

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

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



Use hand protection



Use eye protection



DICHTEN & KLEBEN

Processing instructions

chemicals



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



- 2 Squeeze material**
Press out the material without the static mixing nozzles until it escapes from both openings



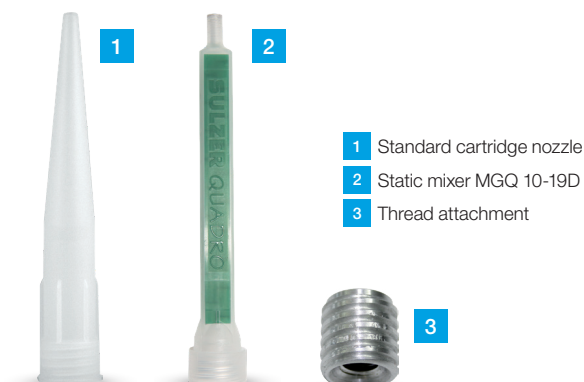
- 3 Screw on static mixer**
Clean off material and screw on the supplied static mixer MGQ 10-19D



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

1. Preparation for using the OTTOCOLL® M 580 adhesive

For particularly narrow adhesive joints, a standard nozzle for cartridges can be attached to the static mixing

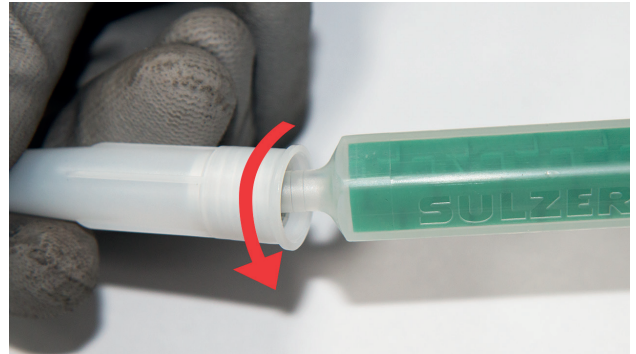


Screw the threaded attachment with the non-milled side first into the internal thread of the standard cartridge nozzle

Processing instructions



Screwed thread attachment inside the standard cartridge nozzle



Put the standard cartridge nozzle with threaded attachment onto the tip of the static mixer in a straight position and "screw it on" onto the smooth surface

nozzles using a special screw-on adapter designed to adapt nozzles. The nozzle can be adapted to the adhesive joint's respective geometry by shortening or flattening it at the tip.

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. Remove the grinding dust or loose particles with a Hoover (no compressed air!).

Priming:

The requirements for elastic sealing and adhesive bonding depend on the particular external factors. Extreme temperature variations, elongation and shear forces, repeated contact with water, etc. put high demands on adhesive bonding. In these cases, it is recommended to use a primer to achieve the strongest possible bond.

Please refer to the priming table provided in the technical data sheet.

3. Bonding

The open time must be respected during bonding.

In case of longer standing times, change the static mixer, if necessary.

Please refer to the information provided in the technical data sheet.