

OTTOCOLL® S81

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. Preparing to process the adhesive

1.1 With BlueLine cartridges



- 1** OTTOCOLL® S81
- 2** OTTO Static mixing nozzle MBLTX 14-16V
- 3** OTTO Standard nozzle 107 mm
- 4** OTTO Flat fishtail nozzle
- 5** OTTO Compressed Air Gun P490 DP2X or OTTO Accumulator Gun 2K AP400



Insert the BlueLine cartridge into the gun



Unscrew the union nut and remove the plug



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



Wipe off the material and fit the static mixing nozzle



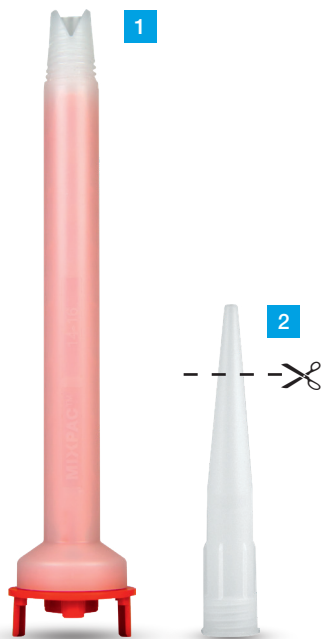
Fix the static mixing nozzle with the union nut



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

Technical details

For particularly narrow adhesive joints, a standard nozzle for cartridges can be screwed onto the static mixing nozzles for BlueLine cartridges. The nozzle can be adapted to the adhesive joint's respective geometry by shortening and flattening it at the tip.



1 OTTO Static mixing nozzle MBLTX 14-16V
2 OTTO Standard nozzle 107 mm



Shorten the standard nozzle as required before screwing it on



Screw the standard nozzle for cartridges onto the static mixing nozzle for BlueLine cartridges as far as it will go



Static mixing nozzle with the standard nozzle for cartridges screwed on



Standard nozzle flattened

Another option for working is attaching a flat fishtail nozzle as well. This is screwed directly onto the thread of the static mixer and is perfect for the rebate bonding with our OTTOCOLL® 2-component adhesives.

1.2 With side-by-side cartridges



- 1 OTTOCOLL® S81
- 2 OTTO Static mixing nozzle ACF ORBIS 12-24X 10:1
- 3 OTTO Compressed Air Gun P 490 DP2X or OTTO Accumulator Gun 2K AP 400



Insert the side-by-side cartridge into the gun



Unscrew and remove the plug



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



Wipe off the material and fit the OTTO static mixing nozzle ACF ORBIS 12-24X 10:1



Fix the static mixing nozzle by tightening the screw



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

1.3 With coaxial cartridges



1 OTTOCOLL® S81

2 OTTO Static mixing nozzle MGQ 10-16D

3 OTTO Hand-operated Gun H 245

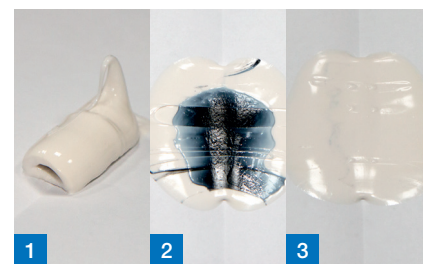
Attention:
Before inserting the coaxial cartridge, check whether the black peeling plungers in the cartridge base!



Insert the coaxial cartridge into the gun



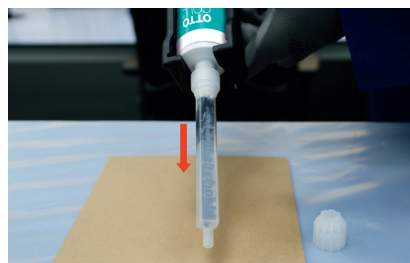
Press out the material **without** the static mixing nozzle until it escapes from **both** openings



- 1 Bead discharge **without** the static mixing nozzle
- 2 "Folding test": **OK** (white and black components are recognisable)
- 3 "Folding test": **Not OK** (only white components recognisable)



Wipe off the material and screw on the OTTO static mixing nozzle MGQ 10-16D as far as they will go



Fill the static mixing nozzle with adhesive



Check the bead discharge and 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



OTTO Cleanprimer (or Cleaner + Primer)¹⁾ and a clean cloth



Wet the cloth with OTTO Cleanprimer (or Cleaner + Primer)¹⁾



Pre-treat the profile's adhesive surface with OTTO Cleanprimer (or Cleaner + Primer)¹⁾



Remove stickers from the insulating glass



Clean the edge sealant with OTTO Cleanprimer (or Cleaner + Primer)¹⁾ and a fabric cloth

¹⁾ You will find the suitable OTTO Cleanprimer (or Cleaner + Primer) in the OTTOCOLL® S81 insulating glass edge sealant compatibility list on our website at www.otto-chemie.com.

3. Bonding of glass panes in wooden window casements



Insert the pane of glass



Pad



Fill the rebate base with adhesive



Insert the glazing bars



Withdraw the glazing gasket