

# Processing instructions for door panels which fully cover the door's internal frame

## The required OTTO products:



OTTOCOLL®  
M 580



OTTO Static  
mixing nozzle  
MGQ 10-19D



OTTO Com-  
pressed Air Gun  
P 2x310



OTTO  
Cleanprimer  
1101



Fixing tape  
10x1 mm

## Optional:



OTTOCORD  
PE-B2 back-up  
foam rod



OTTOPUR  
OP 910



OTTO Applicator  
Gun X7

### 1. Sand the surfaces to be glued

Especially for structured powders or wood/coloured surfaces, vigorously sand the smooth surfaces to be glued using sandpaper, an abrasive sponge or a delta sander, a random orbit sander or a belt sander with grit size of 100.

For ribbed profiles, sand down with a brushing wheel or a wire brush.

If possible, collect the sanding dust with a vacuum cleaner.

The surface must then be matt.



### 2. Prepare the surfaces to be glued

For best adhesion, use a microfibre cloth on both surfaces to be glued, a clean, lint-free cloth or workshop cleaning towel slightly wet with OTTO Cleanprimer 1101\*. Please only wipe with manual pressure in **one** direction over the surfaces to be glued. Every 50 to 100 cm turn the cloth/paper towel, until no more dirt can be seen. Do not treat the surfaces more than once. Please, do not apply in areas which will can be seen as the primer will leave visible traces!

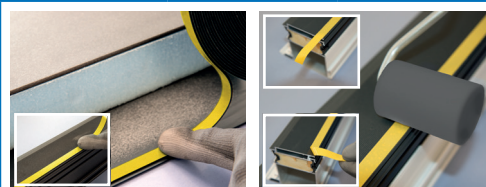
\*Please note the priming table in the technical datasheet for OTTOCOLL® M 580.



### 3. Apply the fixing tape

Depending upon the system that you are using, the 1 mm thick, incompressible, double-sided fixing tape is fixed about 1 to 2 mm back from the outer edge, either from the edge of the door panel **or** from the door's internal frame.

Leave the fixing tape protruding by about 5 cm on all ends and press it on with a rubber roller, then just peel back the liner (protective film) from the protruding part and then trim the fixing tape to length. Then leave the liner protruding again and do not completely pull it off.



### 4. Apply OTTOCOLL® M 580

Activate the 2-component mounting adhesive as specified in the processing instructions for OTTOCOLL® M 580\* and apply about an 8 mm bead of adhesive either on the edge of the door panel or on the door's internal frame so that when the two parts are brought together, at least ¾ of the surface to be glued is covered with a thickness of 1 mm.

The next step must be taken within 5 to 10 minutes.

\*See on the web site [www.otto-chemie.de/products/347](http://www.otto-chemie.de/products/347)



### 5. Join together

It is best if 2 persons work together to ensure that the door panel is aligned flat and straight on the door's internal frame.

Please do not touch the glued surfaces.

Then peel off the liner from the fixing tape all of the way around.



### 6. Press on

Manually press on the door panel from the centre outwards, so that it contacts the preformed tape strip.

The pressure must be chosen so that the fixing tape is **not** compressed, while ensuring that it is sufficient to make good fixing contact.

If a double-sided fixing tape is used then it will not be necessary to use a press or clamps.



### 7. Close the gap around the panel

Wait at least 60 to 90 minutes before turning the door over and if necessary first press in OTTOCORD PE backer rod into the gap between panel and frame up to the covering layer and then use a gun to fill with OTTOPUR OP 910 foam.

Then the holding strip can be fitted stress-free.

