

# OTTOCOLL® P 520

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® P 520
- 2 OTTO Static mixing nozzle KWM 10 or OTTO Static mixing nozzle KWM 18K or OTTO Static mixing nozzle RWM 14G
- 3 OTTO Compressed Air Gun P2x310

For processing the double cartridge 2x 190 ml or 2x 310 ml (mixture ratio 1:1) the OTTO compressed air gun P2x310 is recommended. Maximum pressure: 5 bar for processing with compressed air guns.

If suitable **battery guns** are used for twin cartridges in the mixture ratio 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 chemicals.



## 1. Preparing to process the adhesive



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



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



Clean off material and screw on static mixing nozzle



Refill the static mixing nozzle with adhesive and check 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 – 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. The adhesive surfaces must be clean, non-greasy, dry and load-bearing.

## 3. Bonding

The open time of the adhesive must be respected during bonding. If the static mixing nozzle is to be left standing for a longer period of time, it must be replaced in order to prevent hardening.