

OTTOCOLL®

P 520 SP 6319

Technical Datasheet

2-component adhesive based on polyurethane

For indoor and outdoor application

Characteristic:

- **Fast curing even in thick layers**
Fast further processing
- **Reliable curing in a defined period of time**
Predictable handling and functional strength
- **Non-shrink curing**
No volume shrinkage
- **Only for commercial users. Please observe the material safety data sheet.**

Fields of application:

- General bonding in metal construction
- Weathering resistant bonding of corner joints on metal windows, doors and façades as well as conservatories
- Also suitable for firm bonding of very different materials such as wood, metal, plastics, stone etc.

Standards and tests:

- According to the requirements of DIN EN 204-D4 to weathering resistant bondings of wood and derived wood products
- According to the requirements of DIN EN 14257 (WATT 91) to temperature-resistant bondings of wood and derived wood products
- Suitable for applications according to IVD instruction sheet no. 30+35 (IVD = German industry association sealants)
- French VOC-emission class A+

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.

For adhesion in external areas with impact of humidity and/or UV-radiation in external areas we recommend the use of hybrid-adhesives such as OTTOCOLL® M 500, OTTOCOLL® AllFlex, OTTOCOLL® HiTack, OTTOCOLL® M 590 or OTTOCOLL® M 570. This excludes weathering-stressed adhesion of wood and wood derived timber products with subsequent protective coating according to DIN EN 204 D 4.

Paints, lacquers, plastics and any other coatings must be compatible to the adhesive/sealant. Special application guns for twin-cartridges are available.

Clean the tools, e.g. spatula, with OTTO Cleaner MP before the adhesive has cured.

The cured adhesive can only be removed mechanically.

In case of UV-radiation stress discolourations may occur.

Not suitable for the bonding of glass, polyethylene (PE), polypropylene (PP), polyamide (PA), polyfluoroethylene (PTFE), bituminous, waxy or oily substrates or similar.

Technical properties:

Pot life at 100 g, 23 °C/50 % RH [minutes]	~ 20
Processing time (100 g, 23 °C/50 % RH) [minutes]	~ 15
Mixing ratio according to volume (base A : curing agent B)	1 : 1
Processing temperature from/to [°C]	+ 5 / + 35
Viscosity at 23 °C	pasty, stable
Density component A at 23 °C according to ISO 1183-1 [g/cm ³]	~ 1,44
Density component B at 23 °C according to ISO 1183-1 [g/cm ³]	~ 1,55
Temperature resistance from/to [°C]	- 30 / + 80 (1)
Functional stability for bonded corner joints at 23 °C/50 % RH after [hours]	~ 5
Final strength at 23 °C/50 % RH after [days]	~ 3
Shelf life at 23 °C/50 % RH [months]	12 (2)

- 1) temporarily + 100 °C
2) from date of manufacture

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

Pretreatment:

All adherent surfaces must be clean and any contaminant such as release agents, preserving agents, grease, oil, dust, water, old adhesives or sealants and other substances which could affect adhesion, should be removed. Cleaning of non-porous substrates: Apply OTTO Cleaner T (airing time approx. 1 minute) using a clean, lint-free cotton cloth. Cleaning porous substrates: Clean surfaces with steel-wire brush e. g. or a grinding disk to remove loose particles. The adherent surfaces have to be clean, free from fat, dry and sustainable.

Application information:

Processing of 2-component adhesives and sealants out of side-by-side cartridges:
First of all remove the lids of both component's chambers. Place cartridge into the pistol. Squeeze out material, until material comes out of both chambers. Wipe off material and attach the static mixing nozzle. Check homogeneity of the mixture.
Apply adhesive and assemble parts immediately, if possible, at the latest however within the processing time.
Due to the many possible influences during and after application, the customer always has to carry out trials first.
Please observe the recommended shelf life which is printed on the packaging.
We recommend to store our products in unopened original packagings dry (< 60 % RH) at temperatures of +15 °C up to +25 °C. If the products are stored and / or transported at higher temperatures / air humidity for longer periods (some weeks), a diminution of durability or a change of material characteristics may arise.
Protective goggles must be worn when working with the product. Maximum working pressure 5 bar when working with the product using compressed air guns.

Packaging:

	2x190 ml plastic twin cartridge
RAL 7004	on request
cream-white	SP6319-15-C635
dark brown	on request
olive yellow	on request
Packaging unit	10/Box incl. 10 static mixing nozzles*
Pieces per pallet	600

*OTTO Static mixing nozzle KWM 18K

Safety precautions:

Please observe the material safety data sheet.
After curing the product is completely odourless.

Disposal:

Information about disposal: Please refer to the material safety data sheet.

Warranty information:

All information in this publication is based on our current technical knowledge and experience. However,

since conditions and methods of use and application of our products are beyond our control, we suggest that you test the product before final use. Information given in this technical data sheet and explanations of OTTO-CHEMIE in connection with this technical data sheet (e.g. service description, reference to DIN regulations etc.) is not to be seen as a warranty. Warranties require a separate written declaration of OTTO-CHEMIE to prove their validity. The characteristics stated in this data sheet define the characteristics of the article broadly and conclusively. Suggestions of use are not to be taken as confirmation of the appropriateness for the recommended intended use. We reserve the right to alter the product, adjusting it according to technical progress and new developments. We are at your disposal both for inquiries as well as specific application problems. If a governmental approval or clearance is necessary for the application of our products, the user is responsible for the obtainment of such. Our recommendations do not excuse the user from the obligation to take into consideration the possibility of infringement of third parties' rights and - if necessary - resolving it. For the rest our general terms and conditions apply, in particular regarding a possible liability for defects. You can find our general terms and conditions on our homepage: <http://www.otto-chemie.de/en/terms-and-conditions>



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