

1-component adhesive based on polyurethane

For indoor and outdoor application

Characteristic:

- **Excellent adhesion on metals**
- **Foaming**
Fills cavities
- **Long skin-formation**
Long processing time
- **Tensile strength after 7 days - approx. 14.000 N (ift-test certificate)**
- **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
- Bonding of modified wood

Standards and tests:

- Tensile strength tested by the ift Rosenheim, Germany (institute for window techniques)
- 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
- Expertise about the use of OTTOCOLL® P 86 translucent for bonding modified wood (Georg-August-University Göttingen, Germany)
- Suitable for applications according to IVD instruction sheet no. 30+35 (IVD = German industry association sealants)
- Conform to LEED® v3 IEQ-credits 4.1 adhesives and 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 bondings outside, influenced by humidity and/or UV-radiation we advise the use of our STP or hybrid adhesives. Excepted from this is the weather-stressed bonding of wood and wood materials with subsequent protective paint according to DIN EN 204 D4.

Paints, lacquers, plastics and any other coatings must be compatible to the adhesive/sealant.

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:

Open time at 23 °C/50 % RH [minutes]	~ 20
Processing temperature from/to [°C]	+ 5 / + 35
Viscosity at 23 °C	pasty, stable
Density at 23 °C according to ISO 1183-1, coloured [g/cm³]	~ 1,5
Density at 23 °C according to ISO 1183-1, translucent [g/cm³]	~ 1,1
Temperature resistance from/to [°C]	- 30 / + 80 (1)
Tensile strength of corner bonding after 24 hours [N]	~ 5 900 (2)
Tensile strength of corner bonding after 7 days [N]	~ 14 000 (2)
Shelf life at 23 °C/50 % RH [months]	12

1) temporarily + 100 °C

2) Test sample aluminium corner joints, System WICSTYLE 50 EN, Wicona

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 dust and grease as well as sustainable.

Application information:

The moisture necessary for curing can be achieved by slightly spraying with water. The adherent surfaces may be moist, but not wet. The parts should be assembled immediately if possible, at the latest however within the skin-forming time.

Curing time can be reduced by humidification and increased temperatures.

Fix the substrates, which are to be bonded, until the adhesive is completely cured.

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.

Packaging:

	310 ml cartridge	580 ml aluminium foil bag	1,000 ml aluminium cartridge
translucent	P86-04-C95	P86-08-C95	on request
white	P86-04-C01	P86-08-C01	P86-06-C01
Packaging unit	20	20	6
Pieces per pallet	1200	600	192

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>

