

Product

Two-component adhesive based on polyurethane.

Application examples

- general bonding in metal construction
- weather-resistant bonding of corner joints on metal windows, doors and façades as well as conservatories
- Also suitable for powerful bonding of a wide variety of materials, such as wood, metal, plastic, stone, etc.

Colour

Standard : cream-white

On request : RAL 7004-RAL 9016-dark brown

Packaging

Tandem cartridges of 2 x 190 ml and 2 x 310 ml

Advantages/Properties

- ✓ excellent adhesion on metal
- ✓ safe handling due to the double cartridges
- ✓ Fast and shrink-free curing, even with thick layers
- ✓ Extremely high tensile strength after 24 hours : ~ 14,000 N (ift test report)
- ✓ tensile strength tested at the Institute for Window Technology D-83026 Rosenheim
- ✓ meets the requirements of DIN EN 204-D4 for weather-resistant bonding of wood and wooden materials
- ✓ meets the requirements of WATT 91 (80°C) for heat-resistant adhesives

Remarks

OTTOCOLL® P 520 is not suitable for bonding glass, polyethylene (PE), polypropylene (PP), polyamide (PA), polytetrafluoroethylene (PTFE), waxy and bituminous substrates, etc.

Also available in mono-component version:

Ottocoll® P86

Packaging: cartridges of 310 ml.

Colour: transparent or white



Technical properties

Property	Value + unit
Specific gravity at 23°C (ISO 1183-1)	Component A: 1,40 g/cm ³ Component B: 1,57 g/cm ³
Blending ratio	1/1 by volume
Temperature resistance	-30°C to +80°C (briefly +100°C)
Processing temperature	+5°C to +35°C
Processing time (100 g, 23°C, 50% RV)	± 45 minutes
Pressing time (100 g, 23°C, 50% RV)	± 60 minutes
Viscosity at 23°C (A and B)	pasty, stable
Functional for corner bonding (23°C, 50% RH)	after about 6 hours (faster curing possible with other formulations/on request)
Standards and inspections	- DIN EN 204-D4 - DIN EN 14257 (WATT91) - LEED® according to IEQ-credits 4.1 adhesives - French VOC emissions class A+
Ultimate stability (23°C, 50% RH)	at least 3 days
Shelf life (23°C, 50% RH)	12 months after production date, in the original, unopened packaging

A Product Safety Data Sheet (MSDS) is available on request.

OTTOCOLL® P520

Application guide

Tolerance

Paints, lacquers, plastics and other covering materials must be compatible with the adhesive/sealant.

Cleaning

The bonding surfaces must be cleaned and all contaminants such as solvents, preservatives, grease, oil, dust, water, residues of adhesives/sealants as well as other substances that may have a negative effect on adhesion must be removed.

Cleaning products for non-porous substrates

Cleaning should be done with OTTO Cleaner T, methylated spirit or other cleaning products based on acetone or isopropanol. Use a clean and lint-free cloth.

Cleaning products for porous substrates

Porous surfaces should be removed mechanically from loose particles, e.g. with a wire brush or a grinding wheel.

Adhesion and pre-treatment

Our Technical Department is at your disposal for practical tests. Please inform us of your application parameters and specific requirements. We will then give you the right recommendations for your applications and production systems.

Apply OTTOCOLL® P 520 and assemble the parts to be bonded, if possible directly or within the application time of 45 minutes.

Due to the many possible influences during processing and application, it is advisable to test the product first.

The expiry date is indicated on the packaging and must be observed.

Before using the adhesive/filler, the user must ensure that the building materials - in the contact area (solid, liquid or gaseous) - are compatible with the adhesive/filler and do not damage or alter it (e.g. colour change). In the case of building materials subsequently used in the area of the adhesive/filler, the user must first ensure that their components or emissions do not affect or alter the adhesive/filler (e.g. colour change). If necessary, the user must obtain information from the respective manufacturers of the building materials.

Storage

In the original, unopened packaging, dry (<60% RH) and at a temperature between +15°C and +25°C.

General information

The information contained in this document is provided in good faith and is believed to be correct. However, we have no influence on the conditions in which these products are used or the methods by which they are used. Therefore, this information is not a substitute for tests which the customer must perform himself/herself in order to ensure that the products are safe, effective and achieve the intended purposes. Suggestions regarding the use of the product must not be used as grounds for infringement of any patent whatsoever. The only guarantee Castelein Sealants offers is that this product complies with the Castelein Sealants terms and conditions of sale in force at the time of shipment. Your only remedy in the event of a breach of this guarantee is the refund of the purchase price or the replacement of the product that does not comply with the guarantee.

Technical data of supplier: 12 2014

The producer reserves the right to make changes. 2020 04 01