

Leaf-covering door fillings



Required OTTO products

Optional

- | | | | |
|--|-----------------------------------|---|----------------------|
| 1 OTTOCOLL® M580 | 4 OTTOTAPE Fixing tape | 6 OTTOCORD PE-B2 back-up foam rod | 8 OTTO Dosing Gun X7 |
| 2 OTTO Static mixing nozzle MGQ 10-19D | 5 OTTO Compressed Air Gun P 2x310 | 7 OTTOPUR Dosing foams
OTTOPUR OP910, OTTOPUR OP915,
OTTOPUR OP950, OTTOPUR OP960 | |
| 3 OTTO Primer* according to the primer table | | | |

1. Preparing bonding surfaces

If the surface is unknown or cannot be defined, but especially for structure finish powders or wood/colour decors, intensively sand the smooth bonding surfaces with 100 grit sandpaper, sanding block or a delta, eccentric or belt sander.

Sand fluted profiles with a round or wire brush.



Remove the sanding dust as much as possible with a vacuum and do not blow off! The surface must then be matt.

2. Prepare the surfaces to be glued

To achieve ideal adhesion, use a microfibre cloth, clean lint-free rag or shop towels, which are slightly soaked for example with OTTO Cleanprimer 1101* on both bonding surfaces.

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!

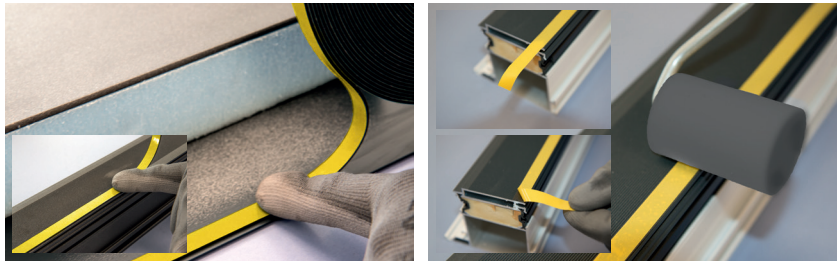


*Please note the priming table in the technical datasheet for OTTOCOLL® M580.

3. Apply the fixing tape

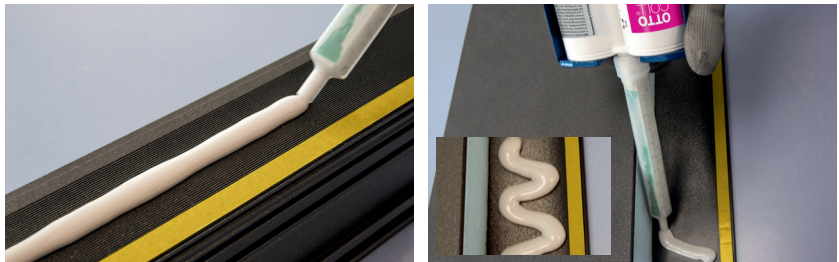
Depending upon the system that you are using, the 1 mm thick, incompressible, double-sided fixing tape is fixed about 1 to 2 mm back from the outer edge, either from the edge of the door panel **or** from the door's internal frame.

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® M580* 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 $\frac{3}{4}$ 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

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 OP910 foam. Then the holding strip can be fitted stress-free.

