

**OTTOCOLL®****HiTack****Technical Datasheet****Characteristics:**

- 1-component adhesive based on hybrid polymer STP
- Extremely high initial adhesion
- Excellent primerless adhesion on numerous substrates - even when exposed to water
- Very high mechanical strength, resistance to notches, tension and tearing
- For stress-compensating bonding and dynamic stresses
- Low odour
- Free of isocyanates
- Silicone-free
- Good weathering and ageing resistance
- Compatible with coatings according to DIN 52452
- Can be painted and varnished – please observe application instruction in TDS

**Fields of application:**

- For application in interior and exterior areas
- Elastic bonding and mounting of various materials such as wood, derived wood products, glass, metals (e. g. aluminium, stainless steel, anodising aluminium, brass, copper), plastics (e. g. unplasticised PVC, plasticised PVC, fibre-reinforced plastics etc.), mineral substrates (e. g. brick, tile, ceramic), fireproof building panels (gypsum board etc.)
- For the bodywork and vehicle construction, wagon and container construction, metal construction and apparatus engineering, ship building
- Elastic bonding of mirrors on ceramic, glass, plastic, stainless steel, aluminium, wood, concrete etc.
- Bonding of stone, natural stone and ceramic
- Bonding of window sills, floor strips, decorative strips and stairs

**Standards and tests:**

- Suitable for applications according to IVD instruction sheet no. 12+19-1+24+30+31+35 (IVD = German industry association sealants)
- French VOC-emission class A+
- Tested according to UL-94 HB

**Important information:**

The initial adhesion can vary clearly depending on the material that is to be adhered and the method of application of the adhesive. According to experience a level application with a notched trowel (1,5 mm toothing) in horizontal lines is recommendable. The adhesive should be sprayed with water, using a spray bottle. When assembling the substrates the adherend should be wet evenly with adhesive by pressing down accordingly. We urgently recommend pre-tests before every application!

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.

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

For bonding or sealing of glass which is exposed to UV-radiation we recommend the use of our high quality silicone adhesives / sealants such as OTTOSEAL® S 110 / S 120 (for sealing of glazing rebate), OTTOSEAL® S 10 (e.g. for bonding), OTTOSEAL® S 7 (for weathersealing) or OTTOCOLL® S 81 (for bonded windows).

For bonding or sealing of transparent plastic material, such as acrylic glass, exposed to UV-radiation we recommend our silicone sealant OTTOSEAL® S 72.

Not suitable for sealing / bonding copper upon impact of UV-radiation and temperature.

The colours of the sealant may be affected by environmental influences (high temperature, chemicals, vapours, UV-radiation). This does not affect the characteristics of the product.

#### Technical properties:

|  |               |
|--|---------------|
| Skin-forming time at 23 °C/50 % RH [minutes]                       | ~ 40          |
| Curing in 24 hours at 23 °C/50 % RH [mm]                           | ~ 2 - 3       |
| Processing temperature from/to [°C]                                | + 5 / + 40    |
| Viscosity at 23 °C   | pasty, stable |
| Density at 23 °C according to ISO 1183-1 [g/cm³]                   | ~ 1,4         |
| Shore-A-hardness according to ISO 868                              | ~ 52          |
| Stress expansion modulus at 100 % according to ISO 37, S3A [N/mm²] | ~ 1,8         |
| Tensile expansion according to ISO 37, S3A [%]                     | ~ 230         |
| Tensile strength according to ISO 37, S3A [N/mm²]                  | ~ 3,1         |
| Temperature resistance from/to [°C]                                | - 40 / + 90   |
| Shelf life at 23 °C/50 % RH [months]                               | 9 (1)         |

1) 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 dust and grease as well as sustainable.

#### Primer Table:

The demands on elastic sealings and bondings depend on the respective exterior influences. Extreme fluctuations in temperature, tensile or shear forces, repeated contact with water etc. demand high requirements of a bonding. In such cases it is advisable to apply primer according to the recommendations of our technical department (e. g. +/OTTO Primer 1216) in order to achieve a resilient bonding.

|  |                   |
|--|-------------------|
| Acrylic bathroom surfaces (e. g. bath tubs)      | -                 |
| Aluminium  | + / 1216          |
| Aluminium anodized                               | +                 |
| Aluminium powder-coated                          | T                 |
| Concrete   | 1105 / 1215       |
| Concrete block                                   | 1105 / 1225       |
| Stainless steel                                  | + / 1216          |
| Iron   | T                 |
| Epoxid resin coating                             | + / 1216          |
| Fibre cement                                     | 1225 (1105) (1)   |
| Glass  | +                 |
| Wood, painted (solvent systems)                  | +                 |
| Wood, painted (aqueous systems)                  | T / 1216          |
| Wood, varnished (solvent systems)                | + / 1216          |
| Wood, varnished (aqueous systems)                | + / 1216          |
| Wood, untreated                                  | T / (1105) (1)    |
| Ceramic, glazed                                  | +                 |
| Ceramics, unglazed                               | + / 1215 / 1216   |
| Plastic profiles (unplasticized, e. g. Vinnolit) | T / 1227          |
| Copper   | + (2)             |
| Melamine formaldehyde resins (e. g. Resopal®)    | T                 |
| Natural stone                                    | 1216 (3)          |
| Polyester  | T                 |
| Cellular concrete                                | 1225 / (1105) (1) |
| Plaster  | 1105 / 1215       |

|                       |          |
|-----------------------|----------|
| PVC unplasticized     | T / 1227 |
| PVC-soft-foils        | T / 1217 |
| Tinplate              | T / 1216 |
| Zinc, galvanised iron | + / 1216 |

- 1) For the adhesion of mirrors OTTO Primer 1105 is to be used solely.
- 2) See "Important information"
- 3) Only suitable for bondings. For sealings we recommend our OTTOSEAL® S 70.

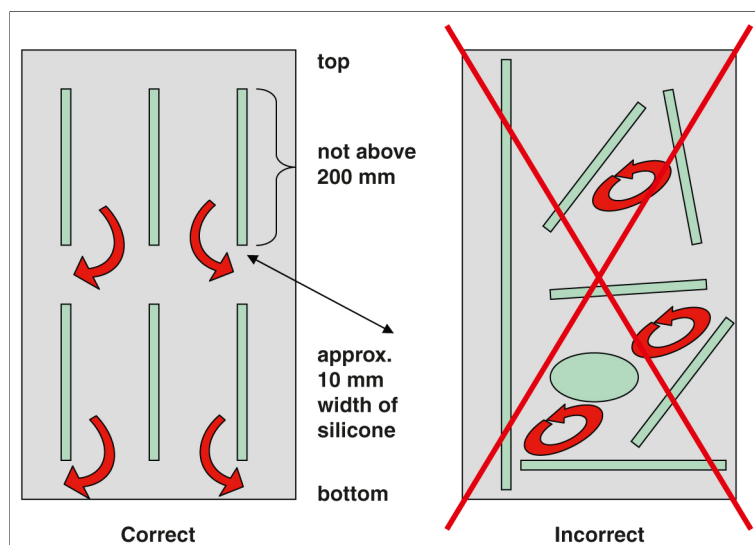
+ = good adherence without primer  
 - = not suitable  
 T = Test/pilot test advised

#### Application information:

In order to achieve good adhesion and good mechanical properties air entrapment must be avoided. Curing time can be reduced by humidification and increased temperatures. For the full-surface bonding of steam-tight substrates the adhesive should be moistened. Our product can be overcoated with paint or varnish. The compatibility between the coating and our product has to be checked before the application by the user/processor - possibly under production conditions. Our OTTO application technology will gladly support you non-committally. If, in exceptional cases, after successful compatibility test our product is coated over the entire surface, this coating must also be able to follow the elastic movement of the sealant. Otherwise crack formations in the coat of paint or optical impairments may occur. Due to the many possible influences during and after application, the customer always has to carry out trials first.

Processing as mirror adhesive:

Only mirrors should be bonded, which have a reflecting and protection layer according to DIN 1238 5.1 and DIN EN 1036. In case of doubt please contact the manufacturer of the mirror. Mineral substrates such as concrete, plaster, masonry, gypsum board, cellular concrete as well as untreated wood have to be primed with OTTO Primer 1105. This is essential. The use of this primer as barrier does not only improve the adhesion, but it is also a barrier to alkaline. Without a barrier the alkaline in combination with moisture can (amongst others) damage the back side of the mirror. When bonding mirrors do not apply the adhesive point-shaped or full-surface, but in vertical stripes (beads). The length of a bead should not exceed 200 mm. 3 beads are to be applied per m<sup>2</sup> in a way, that after pressing on the mirror the width of the bead does not exceed 10 mm and the space between the beads is of at least 200 mm. This will make the necessary air circulation for the vulcanization possible. For an ideal loading capacity an adhesion surface of minimum 10 cm<sup>2</sup> / kg of the mirror's weight is necessary.



In order to avoid the confinement of the splitting product, a minimum space of 1,6 mm between mirror and substrate has to be kept mandatory. This space can be avoided most purposefully by sticking spacers onto the mirror. The minimum space specified serves the outbreathing of the splitting product. It does however not overrule the minimum distances for ventilation given by the Institute of Glass Manufacturing in Hadamar.

The mechanical strength, necessary for the bonding, will be achieved after approx. 48 hours at the earliest (+23 °C, approx. 50 % RH). Until this point a mechanical fixation is necessary. This can be done with removable mechanical fixations, e.g. blocks of wood, wedges or single sided adhesive tapes used at the front of the mirror or with double sided adhesive tapes applied to the back of the mirror. OTTOSEAL® S 70 is recommended for sealing the edges of a mirror adjacent to natural stone. OTTOSEAL® S 120 and OTTOSEAL® S 121 is recommended for sealing the edges of a mirror adjacent to other materials such as ceramic, metal, glass etc.

Please note: The mirror must not be sealed before the mirror adhesive has not completely cured and splitting product has not discharged. Curing takes about 7 days. Concerning mirrors without a glass rear only the vertical mirror edges should be sealed, to avoid damaging of the mirror coating by condensation. Please observe the following drawing.

When mounting mirrors on ceilings or on walls, whose upper edge is more than 4 m above the floor must be secured additionally mechanically with screws or by placing them in frames.

**STORAGE:**

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.

If stored for a longer period at higher temperatures (≥ 30 °C) a diminishment of the initial adhesion may occur.

**Packaging:**

|                          |                  |
|--------------------------|------------------|
|                          | 310 ml cartridge |
| black                    | M550-04-C04      |
| grey                     | M550-04-C02      |
| white                    | M550-04-C01      |
| <b>Packaging unit</b>    | <b>20</b>        |
| <b>Pieces per pallet</b> | <b>1200</b>      |

**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>