

Information* on the Characteristics and Material Combinations of Adhesives, Putties, Varnishes and Thinners

* This information only applies to the adhesives, putties, varnishes and thinners of Otto Bock HealthCare GmbH in Duderstadt, Germany. ** Depending on relative humidity and room temperature		Gene	ral Char	acteristi	ics				Special Characteristics/ Areas of Application	Possible Material Combinations																			
	Product description	Chemical basis	Area of application °C/°F	Pot life (2K products, depending on mixing ratio)	Drying time **	Handling strength **	Final strength **	Colour of the glue joint	Bonding process		Polyurethane	Polyethylene	Polypropylene	PPT .	GRP	Rubber	Textiles	Felt	Wood	Laminate	Leather	Cork	PU foams rigid	PU foams soft	PE foams	Metal	Hard PVC Soft PVC	Neoprene	Product description
Adhesi	Parchment Cold	Polyvinyl acetate						Trans-	Wet	also for low processing temperatures,		_				_									_				-
4	Adhesive 636W9 Universal Adhesive 636W1	Cellulose					approx. 8 h under pressure	parent Trans- parent	Contact and wet	water and perspiration-resistant, contact adhesion for closed-pore materials, suitable thinner 634A1							•	•	•	······································	•	•							
(E)	Contact Adhesive	Methyl acetate	up to approx.		15–20 min.			Yellowish	Contact	bonding flexible materials including plastics and metals,																			(2.20)
<u> </u>	Special Adhesive	Homopolymer polyvinyl	+100 °C/ +212 °F		30-60 min.		approx. 2 days	Transparent		good resistance to ageing, suitable thinner 634A6 very flexible adhesive film,																			
	for Bandages 636N10 Plastic Adhesive 636W17	acetate dispersion, approx. 63% in water Polyurethane			10-20 min.		2 days	Transparent	and wet Contact and wet	limited suitability for soft PVC or sole bonding, contact adhesion for closed-pore materials heat activation possible even after several days, suitable for bonding fatty leather and to solidify foam cosmetic covers							•	•	•		•	•	•	•			•		
	PU (Polyurethane) Adhesive 636W25	Polyurethane synthetic solution	from +80°C/ +176°F to	approx. 8 h	approx. 10 min.		approx. 24 h		Contact	contact adhesion for closed-pore materials, suitable thinner 634A20 for high-strength and flexible bonding, heat-resistant to 120 °C/248 °F in combination with 636W26 Cross-Linking Agent, heat activation possible (+80 °C/+176 °F),	•					•	···						•	•			•		*
	Contact Adhesive 636W45	Polychloroprene	+120 °C/ +248 °F 		10–15 min.		approx. 48 h	Yellowish transparent	Contact	for flexible bonding, suitable thinner 634A59	· · · · · · · · · · · · · · · · · · ·					•	•		•		•	•	•	•		• (•	•	**
	Neoprene Adhesive 636W65	Polychloroprene	+248°F		7–45 min.		1–2 h	Brown	Contact	especially for neoprene, suitable thinner 634A67				•		•	•				• •							•	
	CP Contact Adhesive 636W71	Polychloroprene, collophonium		with 5–10% hardener up to 8 h	10-60 min.		2–3 days		Contact	especially for orthopaedics technology, bonds are more flexible than with 636W72 CR Contact Adhesive, toluol-free, also suitable as a dual-component system to increase heat-resistance,	•	•	•	•		•					•			•	• (•		•	
	CR Contact Adhesive 636W72	Polychloroprene		with 5–10% hardener up to 8 h	15 – 120 min		3-5 days	Transparent	Contact	especially for orthopaedic footwear technology, toluol-free, also suitable as a dual-component system to increase heat-resistance, suitable universal thinner 634A71	•			•		•					•			•	• (•		•	I
	Orthocryl Sealing Resin Compact Adhesive 636K18	Solution of an acrylic polymer in methacrylic esters		depends on the mixing ratio			depends on the mixing ratio	Transparent		used with 617P14 Hardener Paste or 617P37 Powder									•	•									
HU hart	UHU Hard (dual- component system) 636W22	Cellulose nitrate	up to approx. +100°C/ +212°F				approx. 24 h	Transparent	Wet	fast-drying, soluble with 634A3 Acetone		•	•		•				•						(•			COMP AND
	Rubber Adhesive 636W34	Polychloroprene	from -30°C/ -86°F to +90°C/ +194°F		5–15 min.			Beige	Contact	for flexible and heat-resistant bonding, can be applied with a brush or spatula						•		•	•		•				•	• (•		
	UHU Plus, final strength 300 (dual- component system) 636W23	Bisphenol-A epoxy resin (A), polyaminoamide (B)	from -40 °C/ -104 °F to +80 °C/ +176 °F	approx. 90 min.		approx. 6 h	approx. 5 days	Opaque/ honey- coloured	Wet	the higher the setting temperature (up to approximately 180 °C/380 °F), the higher the strength of the bond; also hardens when not exposed to air						•			•	•					(•	•		
PA		Epoxy resin and pigments (A), polyaminoamide (B)		50-80 min.		approx. 12 h	approx. 7 days		Wet	for high-strength bonding	<u></u>				•	•			•	•			•			• (•		I AA
	Special Adhesive 636W18	Epoxy resin and pigments (A), polyaminoamide (B)		50–70 min.			approx. 10 h		Wet	especially for splint systems, highest strength when hardening between 40 – 120 °C/104 – 248 °F, used with 636W19 Hardener Paste									•						(•			(3)
	Cyamet Rapid Adhesive (Superglue) 636K11	Ethyl	from -30°C/ -22°F to +80°C/ +176°F			5-70 sec.	approx. 24 h	Transparent		setting is accelerated by humidity, suitable for almost all material combinations, high mechanical strength, patented twist-off dosage cap		•	•			•					•	•			(•			Ė
	Cyanacrylate Rapid Adhesive as Dosage Pen 636K36	Ethyl	from -30°C to -86°F to +80°C/ +176°F			3–50 sec.		Transparent	Wet	dosage pen with twist-off cap, precise gluing with accurate dosage, universal product of average viscosity, high tensile strength, quick-setting standard grade for various applications including ceramics		•	•			•	•	•	•	•	•	•				•			İ
To a	Spray Adhesive (removable) 636K40	Synthetic elastomers Synthetic elastomers	from -20 °C/-4 °F to +50 °C/ +122 °F		up to 5 minutes up to			Transparent Beige	Wet Contact	for joints that can be disassembled and repositioned, UV-resistant, fine and evenly distributed adhesive application, precise and clean during use for permanent bonding,							•	•	•			•	•	•		•			TO STATE OF
	Spray Adhesive (permanent) 636K41	Symmetic etastomers	-30°C/ -22°F to +60°C/ +140°F		10 seconds			Deige	Comaci	universal, long gluing time, does not penetrate porous materials nor sag, fine and evenly distributed adhesive application					•		•	•	•			•	•	•	(•	•		<u> </u>
utties	Orthocryl Putty	Polyester resin solution in	from	5-13 min.				Grey		for securing and filling various materials,																			420
	636K7	methyl methacrylate	+80 °C/ +176 °F to +130 °C/ +226 °F	2–6 min.			15–30 min.			used with 617P14 Hardener Paste	•	•	•						•	•				•		•	•		
	Akemi Fast-Curing Putty 636K9 Light Putty	Unsaturated polyester resins dissolved in styrene Unsaturated polyester	up to approx. +100 °C/ +212 °F	2–6 min. 3–7 min.			15–30 min.			fast-curing, good adhesion and elasticity, for securing and filling various materials, used with 617P14 Hardener Paste fast-curing,	•	•	•						•	•			•				•		
	636K17	resins with special light fillers dissolved in styrene								very low density, good adhesion, good grinding characteristics for securing and filling various materials, can be coloured with Ottobock colour pastes, used with 617P14 Hardener Paste	•	•	•		•				•	•					1		•		
	Plastic Wood 636K3	Acetone, nitrocellulose, camphor, titanium dioxide	from -10 °C/ -50 °F to +80 °C/ +176 °F			5–15 min.				for filling holes, cracks and irregularities in wood, can be sanded after approximately 15 min., desired viscosity can be restored using 634A1 Thinner									•										
arnish																													
	Special Varnish, transparent 635L2 Socket Interior Varnish,	Cellulose Acrylic						Transparent Transparent		socket interior and exterior varnish, varnishing pergamented prostheses and other wood and metal components, suitable thinner 635L2 interior socket varnish,																			
	transparent 635L8 Orthocryl	Synthetic binding agent						oparciil		physiologically neutral and suitable for sensitive skin for the isolation of wet plaster models,		vious - f	the re-	erous poss	hle en l'	cation	of adk	sivos	tties	arnich -	and #L.	nnoro	We co	only -	vido ==	eral is f	ormatica	n thic	
	Varnish, colourless 635L12 Orthocryl Spray Varnish, clear	and solvent Toluol-acetone-xylol solvent mixture						Transparent		and for varnishing sanded laminate surfaces for smoothing and repairing sanded laminate, CFC-free spray can	ov th	verview. ne materi apours a	The suite ials being and gase	bility of the bonded a	se prodund the su	icts for bseque he proc	your spe nt types essing a	ecific purports of strain and stora	pose – a on the o	also in re glue join dhesives	egards to nt – need s, which	to your ds to be may be	r processoe verified be hazard	sing tec d by you	hnique, t ur own pr health, m	he char ractical nust be e	acteristics tests. extracted	s of us-	
	Spray Varnish, skin-coloured	Pigment binding agent spray						Skin colour		for coating sanded laminates, CFC-free spray can	aı th P	nd suspene Ottobo	ended pa ock lami	ns. Ottoboo rticles are nation work re the notes	extracted stations of on proc	with the can be f essing a	e help of ound in t and stori	f a fan an the Planr ing adhes	nd the suning and	uspende d Equipp hich are	ed partic ping Ca found c	cles are atalogue on the c	e caught e (646K:	t with ar 10=GB)	integrati	ed filter.	. More ab	out	
	Spray Varnish, dark brown 635L16	Pigment binding agent spray varnish						Dark brown		for coating sanded laminates , CFC-free spray can	of S da	ffer suita afety dat ata shee	ble secuta sheets	re cabinets are availat or Materia ovide you	in order le for ma	to ensu terials t Data Sh	re hazar hat requ eets (MS	dous sub lire labell SDS) con	ostances ling acco	s are sto ording to portant s	ored pro o the Or safety in	operly. Ordinanc Instruction	ce on Ha	azardou handling	s Substa hazardo	nces. T	hese EU s	safety	
	Dipping Varnish 635L15	Polyurethane						Dark brown		for colouring Pedilan casting forms , e.g. feet	. O	occupation	onal safe	y and envi	onmenta equipme	I protec	tion fact	ors acco	rding to	the cur	rent sta	ate of kr	nowledg	ge have	been take				
leane	rs/Thinners										10	. and III [[watel	Jaiai0	, == (04 0	00)	ale F	. 5.661176	quipn	om se0	J.,.UII.								
-	Acetone 634A3	Acetone, dimethylketone						Transparent		very volatile, with extremely good solvent characteristics for nitrocellulose, polyester, polystyrene, PVC copolymers, alkyd resins, fats, oils and waxes,																			
P	Isopropyl Alcohol 634A58	Dimethylcarbinol, 2-hydroxypropan, 2-propanol						Transparent		alkyd resins, fats, oils and waxes, good degreasing characteristics for cleaning sensitive plastics such as PVC, PS, ABS, acrylic, PC																			