

When using cement BMW 51 0 032, observe the following procedure, also refer to SI 1 05 91 (386)..

Sourcing Reference for cement: Cartool GmbH,

1. Ambient and material temperature must not be below 18 °C during application and up to hardening.
2. Remove oxide layers, rust, paint or scale from cement surfaces.
3. Roughen cementing surfaces with a steel brush or sandpaper to improve adhesion.
4. Remove grease from cementing surfaces.

When degreasing, use universal thinner or acetone and ventilate treated surfaces for approx. 1-2 minutes until the cement surfaces are completely dry.

5. Install double cartridge 51 0 032 in double cartridge pistol 51 0 031, remove cover and fit mixer tube.
6. Eject about 2 cm of the mixed cement and then first apply the mixed cement one-sidedly on the cementing surface. Thickness of coat: about 2 mm; if necessary, spread mixed cement on the cementing surface with a spatula.

Potlife of mixed cement at 18 to 25 °C: about 1 to 2 hours.

7. Press parts together, hold and punctate.

Extract produced vapors!

8. Remove excessive cement with paper or cloths.

Hardening time of mixed cement at 20 °C: about 15 to 20 hours.

Hardening time can be reduced by applying heat, e.g. in a spraying booth.

Hardening time at:

40 °C : 3-6 hours

60 °C : 50-60 minutes

80 to 100 °C : 15-30 minutes

### Caution!

Select hardness temperatures which do not exceed 120 °C.

Do not apply load to cemented parts until they have hardened!

Protection measures:

Avoid direct contact with eyes and skin.

Do not eat, drink or smoke during this operation.

After completion of work, clean hands and rub in skin barrier cream.

### First Aid:

In the event of eye contact, flush immediately with running water for approx. 10-15 minutes and, if necessary, visit eye specialist.

In the event of skin contact, clean immediately with soap and water, then rub in skin cream.

In the event of allergic skin response, immediately clean affected areas with soap and water and rub in skin cream, visiting doctor if necessary.

If swallowed, thoroughly flush mouth/surrounding areas with running water and call on doctor.

After inhaling, obtain source of fresh air, remain still, keep airways clear and inform a doctor.

Change clothing contaminated with resin residue immediately and do not reuse until it has been cleaned.

### **Notes on toxicology**

Can act in sensitizing manner and cause allergic skin responses.

### **Disposal**

Small quantities of mixed and hardened resin residue can be disposed of as domestic waste.

### **Caution!**

These data apply to existing legislation in the Federal Republic of Germany.

For other countries, always follow the national legislation, which may differ from that in Germany