

# Technical Information

## Technomelt Q 3118



**Type of adhesive** hotmelt on synthetic basis.

**Field of application** Bookbinding:  
Q 3118 is suitable for single shot binding on automatic binding machines at high speeds with little formation of foam (e.g. manufacture of catalogues for mail order firms, timetables, magazines, etc.).

### Product specification

**Viscosity** 2.700 - 3.600 mPa.s  
at 160 °C

**Softening Point** 76 - 86 °C

### Properties

**Colour** yellowish

**Setting Time** medium

**Open Time** medium

### Processing

Working Temperature 160 - 180 °C, measured on roller

**Application** by means of roller

### Bonding properties and processing advice

Technomelt Q 3118 is suitable for perfect binding of most of the common papers. Q 3118 can be applied without primer with an application thickness of 0,5 - 1,0 mm. It has to be applied on a dustfree book cover. You can optimize the bonding strength of difficult-to-bond papers by an appropriate spine preparation (notches of 0,5 - 1,5 mm depth and distance of 5 - 10 mm). The grinding depth of long fibrous papers may be less. The ideal coating and spine preparation depend to a great extent on the paper quality, size and weight of the specimen fibre, direction and cover respectively back lining material.

The optimum working temperature has to be adjusted to the working conditions, specially machine speed, distance and time from point of adhesive application to cover casing in and room temperature.

### Test Method

Brookfield, Thermosel, spindle 27

R&B

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If only a small quantity of the hotmelt is required, the temperature in the pre-melt tank should be 30 - 40 °C below the working temperature. The heating in the pre-melt tank should be adjusted to the adhesive usage in such a way that the temperature does not drop and the refill quantity corresponds with the usage. The coating tank has to be filled up to the top. In case the adhesive level drops the temperature difference between the hotmelt in the tank and on the roller surface increases. Residues remaining on the walls of the tank could char due to overheating. The heating up temperature should not exceed the working temperature.

Also see "General Recommendations for the Processing of Hotmelts".

**Cleaning**

We recommend to use our cleaning agent V 1940 to clean the applicators and adhesive tanks. While working with the cleaning agent, please strictly observe the safety regulations.

For the cold cleaning of surface soiling on application equipment, conveyor belts or other machine parts Melt-O-Clean can be applied. Melt-O-Clean is based on natural resources and supplies the manual cleaning also in case of strong carbonisations. Before using Melt-O-Clean its suitability for lacquered or synthetic coated surfaces should be tested.

**Disposal**

see Safety Data Sheet

**Protective Measures**

see Safety Data Sheet

**Packaging**

granules

**Storage Conditions/  
Shelf Life**

In closed original packaging and under normal, dry storage conditions for at least 2 years from date of production without negative impact on quality.

The information provided herein, especially recommendations for the usage and the application of our products, is based upon our knowledge and experience. Due to different materials used as well as to varying working conditions beyond our control we strictly recommend to carry out intensive trials to test the suitability of our products with regard to the required processes and applications. We do not accept any liability with regard to the above information or with regard to any verbal recommendation, except for cases where we are liable of gross negligence or false intention.  
Düsseldorf, July 2006

