

# Technical Information

## Purmelt® DC 3222-21



**Type of adhesive** reactive prepolymer, UV-curing and moisture curing

**Field of application** Graphic Industry, Bookbinding  
perfect binding, binding of thread stitched and thread sealed books

### Product specification

### Test Method

**Viscosity** 4.000 - 7.000 mPa.s  
at 130 °C

Brookfield, Thermosel,  
spindle 27

Purmelt® DC 3222-21 is currently undergoing extensive practical tests and is still at an experimental stage. Technical data may change.

### Properties

**Colour** white

**Open time** short

### Processing

**Working Temperature** Processing of Purmelt® DC 3222-21 should be effected at the following temperatures:

	Temperatures
premelting area	75 – 90 °C
spinner	150 °C
hose	100 – 110 °C
glue applicator / nozzle	120 - 130 °C

For the production of very thick books the temperature of the melting plate may be increased by 10- 50°C  
and of the hose by 10-20°C in order to secure a continuous and sufficient flow of premelt into the glue applicator.

Attention: Do not forget to reduce the temperatures back to the a.m. levels afterwards.

Only specially coated devices can be used for premelting. When the machines are stopped for a longer period of time, the premelt - and application temperatures should be reduced to a minimum. Excessive exposure to higher temperatures leads to an increase of the viscosity.

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<b>Application</b>	by means of roller and nozzle
<b>Bonding properties and processing advice</b>	<p>Purmelt® DC 3222-21 shows an excellent adhesion to a variety of papers and materials and is as well suitable for difficult-to-bond papers. The cured adhesive film provides a good flexibility.</p> <p>The adhesive cures to its final strength within 1 - 3 days - depending on the atmospheric humidity, the moisture content of the paper, the thickness of the adhesive film and permeability of the material to be bonded. After the UV-curing, however, the bonded product can already be processed (in-line-rounding process).</p> <p>Also see "General Recommendations for the Processing of Hotmelts"</p> <p>The adhesive should be stored in a dry place and should be used immediately after the container has been opened.</p>
<b>Cleaning</b>	We recommend to use our cleaning agent Purmelt ME Cleaner to clean the applicators and adhesive tanks. While working with the cleaning agent, please strictly observe the safety regulations. Bulk melters can be cleared by means of reactive melt Purmelt®Cleaner 2 (light blue).
<b>Disposal</b>	see Safety Data Sheet
<b>Protective Measures</b>	see Safety Data Sheet
<b>Packaging</b>	steel drums of 20 kgs and 200 kgs
<b>Storage Conditions/ Shelf Life</b>	In closed original packaging and under normal storage conditions 6 months 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, March 2008