

# Technical Information

## Purmelt® DC 3222-23



**Type of adhesive:** Reactive prepolymer, UV-light- and moisture-curable

**Application:** Graphic industries / bookbinding:  
Perfect binding, spine gluing of thread stitched and thread sealed books,  
inline-rounding of books

**Product specification:** Purmelt® DC 3222-23 is undergoing extensive practical tests and is still in an experimental stage. Technical data may change.

Viscosity: 3.000 – 7.000 mPas at 130 °C  
Test method: Brookfield / Thermosel, Spindle 27

**Properties:** Colour: white  
Open time: short

**Processing:** Application by means of roller or nozzle.

Processing temperature of Purmelt DC 3222-23 should be effected at the following temperatures:

Area:	Temperature:
Premelter	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 the premelted glue into the glue applicator.

**Attention:** Do not forget to reduce the temperature 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 high temperatures leads to an increase of the adhesive viscosity.

**Bonding properties and processing advice:** Purmelt® DC 3222-23 shows an excellent adhesion to a variety of papers and materials and is well suitable for “difficult-to-bond”-papers.

The adhesive cures to its final strength within 1 - 3 days – depending on the 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 with the casing-in-line.

Also see “General Recommendations for Processing of Hotmelts”.

The adhesive should be used immediately after the container has been opened.

**Cleaning:**



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 cleaned by means of Purmelt® Cleaner 2 (light blue granuels).

**Disposal:**

See safety data sheet.

**Protective measures:**

See safety data sheet.

**Packaging:**

Steel drums of 20 kg and 200 kg

**Storage conditions  
and shelf live:**

In closed original packaging and under normal storage condition one year 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.

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