

Technical Information

Purmelt ME 3300



Type of adhesive reactive prepolymer, moisture curing, no marking necessary (monomer isocyanate content < 0,1 %)

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

Product specification
Viscosity

4.000 - 8.000 mPa.s
at 130 °C

Test Method

Brookfield, Thermosel,
spindle 27

Monomer Isocyanate Content

< 0,1 %

Properties

Colour

white

Open time

medium

Processing

Working Temperature

Processing of Purmelt ME 3300 with bulk melter should be effected at the following temperatures:

	Temperature Book spine < 1 cm	Temperature Book spine > 1 cm
Premelting area	80 °C	90 °C
Hose	100 °C	110 °C
Glue applicator / roller	115 °C	125 °C
Nozzle	120 °C	130 °C
Spinner	150 °C	150 °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 applied 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 temperature leads to an increase of the viscosity.

Application

by means of roller , nozzle.

Bonding properties and processing advice

Purmelt ME 3300 shows an excellent adhesion to a variety of papers and materials and is as well suitable for difficult-to-bond papers. Depending on size and weight of the book the thickness of the adhesive film should be 0,3 – 0,6 mm.

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Technologies
Industrial Adhesives

The cured Purmelt ME 3300 film provides a good flexibility at high and low temperatures. After 6 hours already 50 – 80 % of the final bonding strength can be reached depending on the external conditions.

The adhesive cures to its final bond strength within 1 - 2 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 physical curing process, however, the bonded product can already be processed.

Purmelt ME 3300 has a good adhesion to PVC- and Acetate-films. Bonding of PP- and PE-films is only possible after a recent Corona pretreatment with a surface tension of > 40 mN/m (old: dyn/cm).

Also see "General Recommendations for the Processing of Hotmelts"

Sundry Remarks

The adhesive should be stored in a dry place and should be processed 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 cleared by means of reactive melt Purmelt Reiniger 2 (light blue).

Disposal

see Safety Data Sheet

Protective Measures

see Safety Data Sheet

Packaging

steel hobbocks of 20 kgs, 2 kgs inliner, 180 kg drums

Storage Conditions/ Shelf Life

In closed original packaging and under normal storage conditions 12 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.

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