Technical Information
Purmelt® QR 3315 T

Type of adhesive	reactive prepolymere, moisture curing
Field of application	Graphic Industry, Bookbinding: perfect binding, binding of thread stitched and thread sealed books, sideglueing, endsheet glueing

Product specification

		Test Method
Viscosity	1.800 - 4.200 mPa.s at 130 °C	Brookfield, Thermosel, spindle 27

Properties

Colour	transparent
Open time	medium

Processing

Working Temperature

Processing of Purmelt ® QR 3315 T with bulk melter should be effected at the following temperatures:

	Temperatures
premelting area	90 – 100 °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 and the hose may be increased by 10 °C in order to secure a continuous and sufficient flow of premelt into the glue applicator. 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 ® QR 3315 T 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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The cured Purmelt ® QR 3315 T 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 ® QR 3315 T 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 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 drums of 20 kg and 180kg and candles of 2kg

**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, expect for cases where we are liable of gross negligence or false intention.
Düsseldorf, April 2009