

# Purmelt ME 3320

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## PRODUCT DESCRIPTION

Purmelt ME 3320 provides the following product characteristics:

<b>Technology</b>	Hot Melt
<b>Product Type</b>	Reactive prepolymere
<b>Application</b>	Graphic Industry
<b>Cure</b>	Moisture cure
<b>Appearance</b>	white, transparent

## Application Areas

- Perfect binding
- Book spine glueing of thread stitched books

## Product Properties

Purmelt ME 3320 shows an excellent adhesion to a variety of papers and materials and is as well suitable for difficult-to-bond papers. Depending on external conditions, 50 - 80% of the final bonding strength can be achieved already after 12 to 24 hours. The adhesive cures to its final bond strength within 1 to 2 days - depending on the atmospheric humidity, the moisture content of the paper, the thickness of the adhesive film, the permeability of the material to be bonded and the storage temperature. After the physical curing process, however, the bonded product can already be processed. The storage temperature should not be below 18 °C as otherwise the reaction time of Purmelt ME 3320 will be significantly slower. Purmelt ME 3320 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).

## Film Properties

- white
- hard elastic

## Technical Data

### Purmelt ME 3320:

Viscosity, Brookfield - Thermosel, 130 °C, 3,000 to 7,500 mPa.s

Spindle 27

Open Time medium

Monomere Isocyanate Content, % <0.1

## Compliance with food packaging regulations

Under specific conditions (FDA, EC-guidelines and BfR recommendations) the adhesive is suitable for the manufacture of food packaging materials.

A conformity letter with further details is available on request. The responsibility for compliance with the specific conditions is with the converter and not with the adhesive supplier.

## DIRECTIONS OF USE

### Preliminary Statement

Prior to application it is necessary to read the Material **Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.

### Processing

Depending on size and weight of the book the thickness of the adhesive film should be 0,3 – 0,6mm.

### Application

Application method:

- roller
- nozzle

Recommended working temperature: 115 to 130 °C

### Working Temperature:

Processing of Purmelt ME 3320 with bulk melter should be effective at the following temperatures:

Bookspine < 1 cm	
Premelting Area, °C	80
Hose, °C	100
Glue Applicator / Roller, °C	115
Nozzle, °C	120
Spinner, °C	150
Machines with single temperature preset, °C	115
Bookspine > 1 cm	
Premelting Area, °C	90
Hose, °C	110
Glue Applicator / Roller, °C	125
Nozzle, °C	130
Spinner, °C	150
Machines with single temperature preset, °C	115

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

**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). During use, please follow the safety instructions.

**Handling Information**

Due to the variety of different materials available on the markets pre-tests should be carried out.

**STORAGE**

Rotate stock, using oldest material first. Keep containers upright and closed to prevent contamination. Do not mix with other adhesives. When stored in a dry and cool place in the original unopened containers shelf life is as follows.

**Shelf life**

Shelf-life (in unopened original packaging), 12 months

Frost-Sensitive

No

**Classification:**

Please refer to the corresponding safety data sheets for details on:

**Hazardous Information****Transport Regulations****Safety Regulations****ADDITIONAL INFORMATION****Disclaimer:**

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.

This datasheet replaces all former versions.

Reference 0.0