

# Technical Information

## Technomelt Q 3635



**Type of adhesive** hotmelt on synthetic basis

**Field of application** Graphic Industry:  
One-shot perfect binding on automatic binding machines, book spine glueing of thread stitched books.

Product specification	Test Method
<b>Viscosity</b> 4.750 - 6.450 mPa.s at 160 °C	Brookfield, Thermosel, spindle 27
<b>Softening Point</b> 77 - 87 °C	R&B

**Properties**  
**Colour** white

**Open Time** medium

**Setting Time** medium

**Processing**  
**Working Temperature** 160 - 180 °C, measured on roller

**Application** by means of roller

**Bonding properties and processing advice** Technomelt Q 3635 is suitable for perfect binding of most of the common papers and provides an excellent bonding strength. We recommend to test coated papers before starting production.

Technomelt Q 3635 usually is applied without primer with an application thickness of 0,5 - 1 mm on a dust free paper surface.

You can optimize the bonding strength of difficult-to-bond papers by an appropriate spine preparation (notches of 0,5 - 1,5 mm depth and distance of 5 - 10 mm) . The grinding depth of long fibrous papers may be less. The ideal coating and spine preparation depend to a great extent on the paper quality, size and weight of the specimen fibre, direction and cover respectively back lining material.

If only a small quantity of the hotmelt is required, and there are long machine standstills during a shift, the temperature in the pre-melt tank should be 30 - 40 °C below the working temperature in order to avoid charring.

.../2



# Technomelt Q 3635

For the same reason it is recommended not to pre-melt more adhesive than being used during a working day. Avoid overheating above the maximum working temperatures, since quality will suffer and the adhesive may char.

The addition of hotmelt in the melting tank has to be dosed in such a way that the temperature does not drop and the refill quantity corresponds with the usage. If the adhesive level in the melting tank drops the adhesive residues remaining on the walls of the tank could char due to overheating.

Also see "General Recommendations for the Processing of Hotmelts".

## Cleaning

We recommend to use our cleaning agent V 1941-21 to clean the applicators and adhesive tanks. While working with the cleaning agent, please strictly observe the safety regulations.

For the cold cleaning of surface soiling on application equipment, conveyor belts or other machine parts Melt-O-Clean can be applied. Melt-O-Clean is based on natural resources and supplies the manual cleaning also in case of strong carbonisations. Before using Melt-O-Clean its suitability for lacquered or synthetic coated surfaces should be tested.

## Disposal

see Safety Data Sheet

## Protective Measures

see Safety Data Sheet

## Packaging

granules

## Storage Conditions/ Shelf Life

In closed original packaging and under normal storage conditions for at least 2 years 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, January 2009

