

Technical Information

Technomelt Q 3640



Type of adhesive	hotmelt on synthetic basis
Field of application	Bookbinding: Technomelt Q 3640 is suitable for single shot binding on automatic binding machines at high speeds with little formation of foam (e.g. manufacture mail order catalogues , timetables, magazines, etc.).

Product specification	Test Method
Viscosity	3.000 - 4.100 mPa.s at 160 °C Brookfield,Thermosel,spindle 27
Softening Point	75 - 85 °C R&B

Properties	
Colour	white
Setting Time	medium
Open Time	medium

Processing

Application Temp.	160 - 180 °C
Application	by means of roller

Bonding properties and processing advice

Technomelt Q 3640 is suitable for perfect binding of most of the common papers. Technomelt Q 3640 can be applied without primer with an application thickness of 0,5 - 1,0 mm . It has to be applied on a dustfree book spine. 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 4 - 5 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.

The optimum application temperature has to be adjusted to the application conditions, specially machine speed, distance and time from point of adhesive application to cover casing in and room temperature.

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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 application temperature in order to avoid charring.

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 application temperatures, since quality will suffer and the adhesive may char.

The addition of hotmelt in the melting tanks 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 Purmelt ME Cleaner to clean the applicators and adhesive tanks. While working with the cleaning agent, strictly observe the safety regulations

For the cold cleaning of surface soilings 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, dry 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, May, 2007