

Technomelt Q 3650

Hotmelt Adhesive for the Graphic Industry

Characteristics

- Hotmelt on synthetic basis with a highly elastic film
- Excellent adhesion and processing properties

Fields of application Graphic Industry:

- Perfect binding as well as book spine glueing and manufacture of rounded books with very good lay-flat properties.

Technical data

Color:	white
Softening point (Ring & Ball):	88 – 98 °C
Viscosity (Brookfield):	6.000 – 8.000 mPa.s at 160 °C
Setting time:	medium
Open time:	long

Instructions for use

Application method:	by means of roller
Recommended working temperature: (measured on roller)	160 – 180 °C

Due to the variety of substrates available, gluability of materials can be very different. Therefore pre-tests should be carried out. See also "General Instructions for the Application of Hotmelts". The optimum working temperature and consequently the viscosity of the hotmelt have to be adjusted to the working conditions, specially machine speed, application thickness and required open time.

Bonding properties and processing advice

Technomelt Q 3650 is suitable for perfect binding of most of the common papers. The adhesive can be applied without primer with an application thickness of 0,5 – 1.0 mm on a dust free 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.

If only a small quantity of hotmelt is required, and there are long machine standstills during the 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. The melting tank shall be filled to the upper level. If the adhesive level in the melting tank drops the adhesive residues remaining on the walls of the tank could char due to overheating. The start-up heating temperature should not exceed the maximum working temperature.

Cleaning

For the cleaning of melting tanks and application systems, we recommend the use of our Cleaning Agent Purmelt ME Cleaner . During use, please follow the safety instructions. 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 facilitates manual cleaning even in case of pronounced charring. Before using Melt-O-Clean, its suitability for lacquered and synthetic coated surfaces should be tested.

Delivery form

Granules in 25 kg PE-bags

Shelf life and Storage conditions

In closed original packaging and under normal dry storage conditions, at least 2 years without negative impact on quality.

Disposal

see Material Safety Data Sheet

Safety advice

see Material Safety Data Sheet

The information provided herein, especially recommendations for the use and the application of our products, is based upon our knowledge and experience. Due to different materials used and to varying working conditions beyond our control, we strongly recommend to carry out extensive trials to test the suitability of our products for the intended processes and applications. We do not accept any liability arising from either the above statements or any oral advice unless attributable to intention or gross negligence on our part.
Düsseldorf, October 2008