Technical Information

Technomelt Q 3680

Type of adhesive	Hotmelt on synthetic basis with a highly elastic film.	
Field of application	Graphic Industry: Perfect binding as well as book spine glueing and manufacture of rounded books with very good lay-flat properties.	
Product specification		**Test Method**
Viscosity	8.600 – 10.750 mPa.s at 160 °C	Brookfield, Thermosel, spindle 27
Softening Point	83 - 93 °C	R&B

Properties

Colour	white
Open Time	medium

Processing

Working Temperature 160 - 180 °C, measured on roller

Application	by means of roller

Bonding properties and processing advice

Technomelt Q 3680 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 3680 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.

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.

.../2

Van Asperen Kleefstoffen B.V. Vaartweg 106 8243 PP Lelystad
Tel: +31 (0) 320-260261 Fax: +31 (0) 320-260050
Email: info@van-asperen.nl Web: www.van-asperen.nl

Henkel Technologies Industrial Adhesives

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.

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 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 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, February 2009

Van Asperen Kleefstoffen B.V. Vaartweg 106 8243 PP Lelystad
Tel: +31 (0) 320-260261 Fax: +31 (0) 320-260050
Email: info@van-asperen.nl Web: www.van-asperen.nl