Technical Information

Technomelt Cool 3715

Hotmelt Adhesive for the Graphic Industry

Characteristics

Hotmelt on synthetic basis
High quality EVA-based hotmelt adhesive with excellent processing and bonding characteristics

Fields of application

single shot binding on automatic binding machines at low and medium speeds and low application temperature (e.g. manufacture mail order catalogues, telephone directories, timetables, magazines, etc.).

two-shot binding

Technical data

Color:	white solid
Softening point (Ring & Ball):	77 - 87°C
Viscosity (Brookfield):	4.900 – 6.700 mPa.s at 130°C
Setting time:	medium
Open time:	medium

Processing

Application method:	Roller
Application temperature	120 – 140°C

Due to variety of substrates available, gluability of materials can be very different. Therefore the pre-tests should be carried out.

Bonding properties and processing advice

Technomelt Cool 3715 is suitable for perfect binding of most of common papers. It can be applied without primer with an application thickness of 0,5 – 1,0 mm. It has to be applied 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 paper may be less. The ideal coating and spine preparation depend to a great extent on the paper quality, size, weight and direction of the specimen fiber, cover and back lining material.

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

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Henkel Technologies Industrial Adhesives

For the same reason it is recommended not to pre-melt more adhesive than being used during 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 using our cleaning agent Purmelt ME Cleaner to clean the applicators and adhesive tanks. While working with the cleaning agent, strictly apply the safety regulations.

For the cold cleaning surface soiling on application equipment, conveyor belts or other machine parts Melt-O-Clean can be applied. It is based on natural resources. Melt-O-Clean is also applicable in the manual cleaning of strong carbonizations. 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

Consult local sales office

Storing Conditions/ Shelf Life

In closed original packaging and under normal, dry storage conditions for at least 2 years from the date of production without negative impact on quality.

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