

Technical Information

Purmelt® QR 4777



Type of adhesive reactive prepolymer, moisture curing

Field of application **Graphic Industry, Bookbinding:**
side gluing, end sheet gluing, especially for the manufacture of Schweizer Brochure and Otabind®, Ota-PUR®.

Product specification

Viscosity 5.000 - 9.000 mPa.s
at 130 °C

Test Method

Brookfield, Thermosel,
spindle 27

Properties

Colour white to light-yellow

Open time very long

Processing

Working Temperature Processing of Purmelt® QR 4777 be effected at the following temperatures:

	Temperatures
Tank	100 – 110 °C
Hose	115 – 125 °C
Nozzle	130 – 150 °C

Purmelt® QR 4777 performs side gluing at low application quantity granting an optimum lay flat effect in book pile.

Purmelt® QR 4777 has a very long open time combined with a very good hottack.

Only specially coated melting and application devices can be used. When the machines are stopped for a longer period of time, the pre-melt and application temperatures should be reduced to a minimum. Excessive exposure to higher temperature leads to an increase of the viscosity.

Application by means of nozzle

.../2



Bonding properties and processing advice

Purmelt® QR 4777 is resistant against the effect of mineral oils from the printing ink.

The adhesive cures to its final bond strength within 1 - 2 days - depending on the atmospheric humidity, the moisture content of the paper, the thickness of the adhesive film and permeability of the material to be bonded. After the physical curing process, however, the bonded product can already be processed.

Purmelt® QR 4777 has a good adhesion to flexible PVC- and Acetate-films. Bonding of PP- and PE-films is only possible after a recent Corona pretreatment with a surface tension of > 40 mN/m (old: dyn/cm).

Also see "General Recommendations for the Processing of Hotmelts"

Sundry Remarks

The adhesive should be stored in a dry place and should be processed immediately after the container has been opened.

Cleaning

We recommend to use our cleaning agent Purmelt ME Cleaner to clean the applicators and adhesive tanks. While working with the cleaning agent, please strictly observe the safety regulations.

Disposal

see Safety Data Sheet

Protective Measures

see Safety Data Sheet

Packaging

Box 8 x 2 kgs / 20 kgs hobbock

**Storage Conditions/
Shelf Life**

In closed original packaging and under normal storage conditions 12 months 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, April 2008