

## TECHNOMELT 3635

Known as TECHNOMELT Q 3635

July 2015

### Description:

High performance hot melt adhesive used for one-shot perfect binding on automatic bookbinding lines. Suitable for magazines, directories, unsewn binding and spine gluing of thread (hard cover) books.

### Characteristics

- High processing quality and adhesion.
- Good thermostability.
- Good heat resistance.

### Fields of application

- Gluing a wide range of papers.
- Permits high line speeds.
- Magazines, directories unsewn binding and spine gluing of hard cover books.

### Typical Properties:

|                         |                                  |
|-------------------------|----------------------------------|
| <b>Appearance:</b>      | White                            |
| <b>Odour:</b>           | Low                              |
| <b>Viscosity:</b>       | Approx. 4600 cP at 160°C (320°F) |
| <b>Solids:</b>          | 100%                             |
| <b>Open Time:</b>       | Medium                           |
| <b>Set Time:</b>        | Medium                           |
| <b>Softening Point:</b> | Approx. 82°C                     |

### Directions for Use:

Technomelt 3635 is suitable for perfect binding of most of the common papers and provides an excellent bond strength. We recommend that testing is conducted on coated papers before starting production. Technomelt 3635 usually is applied without primer with an application thickness of 0.5 - 1 mm on a dust free paper surface. The bonding strength of difficult-to-bond papers can be increased by an appropriate spine preparation (notches of 0.5-1.5mm depth and distance of 5-10 mm). The grinding depth of long fibrous papers may be less. 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 adjusted 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.

### Supplementary Products:

This adhesive is a replacement for Technomelt Q 3218 & Q 3218A

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**Clean Up:**

TECHNOMELT PUR CLEANER ME can be used for cleaning the hot melt tank and application system. While working with this cleaning agent, strictly observe safety regulations. Refer to the TDS/MSDS for details.

For the cold cleaning of application equipment, conveyor belts or other machine parts TECHNOMELT CLEANER Melt-O-Clean can be applied. TECHNOMELT CLEANER Melt-O-Clean is based on natural resources and supplies the manual cleaning. Before using TECHNOMELT CLEANER Melt-O-Clean, its suitability for lacquered or synthetic coated surfaces should be tested. Refer to the TDS/MSDS for details.

**Storage and Handling:**

Please read the Material Safety Data Sheet for this product BEFORE use.

Store in a cool and dry place and prevent exposure to temperature extremes. Do not mix with other adhesives.

Please ensure that products classed as a dangerous good are stored in compliance with the applicable regulations.

**Shelf Life:**

Best used within 24 months from date of manufacture when stored under the above conditions in the original unopened containers.

**Last Updated:** 15-07-2015

**DISCLAIMER**

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