

TECHNOMELT GA 3620

Known as Technomelt Q 3620

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PRODUCT DESCRIPTION

TECHNOMELT GA 3620 provides the following product characteristics:

Technology	EVA
Product Type	Hotmelt Standard application temperature
Application	Graphic Industry
Appearance	Granules, yellowish

Application Areas

- One shot perfect binding on automatic binding machines
- Manufacture of mail order catalogues, Telephone directories, timetables, magazines, etc
- Due to its low viscosity TECHNOMELT GA 3620 is used also at high speeds with low foam formation in the glue pot

Technical Data

TECHNOMELT GA 3620:

Viscosity, mPa.s	2,500 to 3,400
Brookfield Thermosel, 160 °C, Spindle 27:	
Softening Point, Ring & Ball, °C	81 to 91
Setting Time	medium
Open Time	medium

DIRECTIONS OF USE

Preliminary Statement

Prior to application it is necessary to read the **Material Safety Data Sheet** for information about precautionary measures and safety recommendations. Also, for chemical products exempt from compulsory labeling, the relevant precautions should always be observed. Please also refer to the local safety instructions and contact Henkel for analytical support.

Processing

TECHNOMELT GA 3620 is suitable for perfect binding of most 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 premelter should be 30 to 40 °C below the application temperature in order to avoid charring. For the same reason it is recommended not to premelt 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. If the adhesive level in the melting tank drops the adhesive residues remaining on the walls of the tank could char due to overheating.

See also "General Instructions for the Application of Hotmelts".

Application

Application method:

- roller

Working Temperature

Recommended working temperature: 160 to 180 °C

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.

Cleaning

For the cleaning of melting tanks and application systems, we recommend the use of our TECHNOMELT PUR CLEANER ME. For the cold cleaning of surface soiling on 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 facilitates manual cleaning even in case of pronounced charring. Before using TECHNOMELT CLEANER MELT-O-CLEAN, its suitability for lacquered and synthetic coated surfaces should be tested. During use, please follow the safety instructions.

STORAGE

Rotate stock, using oldest material first. Keep containers upright and closed to prevent contamination. Do not mix with other adhesives. When stored in a dry and cool place in the original unopened containers shelf life is as follows.

Shelf life

Shelf-life (in unopened original packaging), months	24
Frost-Sensitive	No

Classification:

Please refer to the corresponding **safety data sheets** for details on:

Hazardous Information**Transport Regulations****Safety Regulations****ADDITIONAL INFORMATION****Disclaimer****Note:**

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