

PRODUCT DESCRIPTION

Purmelt QR 3317 BR provides the following product characteristics:

Technology	Hot Melt
Product Type	Reactive prepolymer
Application	Graphic Industry
Cure	Moisture cure
Appearance	white, transparent, fluorescent

Application Areas

- Perfect binding
- Book spine gluing of thread stitched books

Product Properties

Purmelt QR 3317 BR shows an excellent adhesion to a variety of papers and materials and is as well suitable for difficult-to-bond papers.

Depending on external conditions, 50 - 80% of the final bonding strength can be achieved already after 12 to 24 hours.

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

The storage temperature should not be below 18 °C as otherwise the reaction time of Purmelt QR 3317 BR will be significantly slower.

Purmelt QR 3317 BR has a good adhesion to 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).

Film Properties

- white
- transparent
- hard elastic

Technical Data

Purmelt QR 3317 BR:

Viscosity, mPa.s	2,500 to 4,500
Brookfield Thermosel, 130 °C	
Open Time	medium

Compliance with food packaging regulations

Under specific conditions (FDA, EC-guidelines and BfR recommendations) the adhesive is suitable for the manufacture of food packaging materials.

A conformity letter with further details is available on request.

The responsibility for compliance with the specific conditions is with the converter and not with the adhesive supplier.

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

Depending on size and weight of the book the thickness of the adhesive film should be 0,3 – 0,6mm.

Application

Application method:

- roller
- nozzle

Recommended working temperature: 115 to 130 °C

Working Temperature:

Processing of Purmelt QR 3317 BR with bulk melter should be effective at the following temperatures:

Premelting Area, °C	80 to 90
Hose, °C	110 to 120
Glue Applicator / Roller, °C	120 to 130
Spinner, °C	150

For the production of very thick books the temperature of the melting plate may increase by 10 to 50 °C and of the hose by 10 to 20°C in order to secure a continuous and sufficient flow of premelt into the glue applicator.

Important: Do not forget to reduce the temperatures back to the a.m. levels afterwards.

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

Cleaning

We recommend to use our Purmelt ME Cleaner to clean the applicators and adhesive tanks. While working with the cleaning agent, please strictly observe the safety regulations. Bulk melters can be cleaned by means of reactive melt Purmelt® Reiniger 2 (light blue). During use, please follow the safety instructions.

Handling Information

Due to the variety of different materials available on the markets pre-tests should be carried out.

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 12
Frost-Sensitive No

Classification:

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

Hazardous Information
Transport Regulations
Safety Regulations

ADDITIONAL INFORMATION

Disclaimer:

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. This datasheet replaces all former versions.

Reference 0.0