

**TECHNOMELT PUR 3365**

Moisture Curing Hot Melt Adhesive

January 29, 2014

**PRODUCT DESCRIPTION:**

Technomelt PUR 3365 film provides a good flexibility at high and low temperatures. The adhesive cures to its final bond strength within approximately 7 days, and Approx 80% cure is typically achieved in 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. Technomelt PUR 3365 has good adhesion to PVC and Acetate-films. Bonding of PP and PE films which is only possible after a recent Corona pretreatment that must produce a surface energy of >40 dyne/cm.

**PHYSICAL PROPERTIES:**

Appearance:	Off white translucent solid
Solids:	100%
Viscosity:	Approx. 5,600 cps @ 225°F Approx. 3,225 cps @ 250°F Approx. 2,070 cps @ 275°F
Weight/Gal.	Approx. 8.8 lb/gal

**SUGGESTED USES:**

Perfect Binding, Burst Binding, Edition Binding, Lining/Backing, Tight Backing

**OPERATING CONDITIONS:**

Can be applied by slot coater or teflon coated roll coater adapted for reactive hot melts at material temperature of 250-275°F. Drum and pail unloaders may be set to melt temperatures of between 230°F and 240°F. Hose settings should be the same as the platen setting (never hotter to avoid burning the adhesive in the hose.) Typical applicator temperature is 245°F to 255°F. Temps up to 275°F may be used if desired and will include appropriate increase in platen and hose settings.

**Note:** NEVER heat above 300°F. Use only in equipment intended for reactive hot melts. Do not use in conventional hot melt equipment. Forced ventilation must be provided over applicator and melting equipment to remove any small amount of isocyanate vapors from the work area. All users of RHM products should maintain an ongoing industrial hygiene program. This program should include contingency provisions in the event of ventilation failure as well as MDI monitoring.

**CLEAN UP:**

Flush system by running Purmelt Cleaner #2 through equipment. Do not allow Technomelt PUR 3365 to cure on equipment. Cured adhesive requires special solvent for removal (e.g., n-methyl pyrrolidene). Read MSDS for NMP before using.

**PRECAUTIONS:**

Read material safety data sheet before using this product. Technomelt PUR 3365 is a product which contains minor amounts of organic isocyanates. Health hazards have not been fully evaluated. **NEVER** heat above 300°F. Use only in equipment intended for reactive hot melts. Do not use in conventional hot melt equipment. Forced ventilation must be provided over applicator and melting equipment to remove any small amount of isocyanate vapors from the work area. Store in original unopened containers and use within 6 months (180 days) from date of manufacture. Rotate stock and use oldest material first. Do not expose to the atmosphere or otherwise contaminate with moisture. Moisture contamination will cause a sharp viscosity increase or gelation.(curing) Containers must be used completely after opening. Do not attempt to reseal. Do not heat to melting without proper forced ventilation. Vapor is harmful if product is overheated (excess of 300°F). Prevent breathing of vapor. Prevent contact with skin. Do not take internally. Material is applied hot. Appropriate clothing and eye protection should be used to prevent severe burns. Do not mix with other materials except to flush system as noted above. **USE ONLY WITH ADEQUATE VENTILATION.**

**Note**

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01/29/2014

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