

## Planatol HM 9925

Hot melt spine glue based on EVA, free of plasticizers

### Typical Application

- Perfect-binding of catalogues, brochures, etc. on perfect-binding systems of Horizon, C.P. Bourg, etc.

### Technical Data

#### Specification Values

Viscosity * (Brookfield, DIN 53019, 170° C)	2000 – 3500 mPas
Softening Point (Mettler)	75 - 85 °C

\*at date of production

#### Typical Technical Characteristics

Open time	medium
Color	white–translucent
Melt stability	very good
Clamping effect	good
Adhesion to sheet edges	very good

#### Form of Delivery/Container

Granulate in 25 kg bags, further on demand

### General Application Instructions

#### Processing

Suitable for nozzles, rollers and wheels.

Processing temperatures (measured on the rollers):

Perfect-binding	160 °C – 170 °C
Inside premelter	10 – 20 °C lower

Please be aware that in case the working temperature will be changed all other parameters of the adhesive such as open time, viscosity and adherence will change as well. Long heating - and several preheating phases cause a gradually yellowing of the adhesive and will lead to its uselessness. Therefore it is recommended to adjust the amount of melted adhesive to the daily use.

Spine treatment as well as application quantity of the glue have to be adapted to the type of paper used. In general, paper fibers should be exposed as well as possible.

**Please Note:** Hotmelts emit fumes although when the required working temperature will be observed. Nevertheless unpleasant odors will often occur. In case the stipulated working temperatures will be exceeded substantially for a longer period of time, harmful decomposition products can develop. Therefore it is necessary to take measurements to eliminate the harmful fumes, e.g. by installing a suitable extraction system as well as by cleaning the melting container and coating head in regular intervals.

## Storage

Max. Processing Period: 12 Months

After delivery of the shipment the product can be consumed during the a.m. period provided that it is stored properly packed in factory sealed containers at a dry site at temperatures from 15 to 25° C. The bags must not be stacked higher than delivered by Planatol GmbH to prevent a locking of the granulate.

Planatol GmbH grants no warranty or guarantee in case the product will be used after the expiration date of the indicated processing period.

## Cleaning

To avoid deposits on the melting and application equipment, we recommend cleaning with our liquid cleaner PLANATOLIN HM on a regular basis. Time intervals for cleaning have to be determined individually depending on the degree of contamination.

## For Your Attention:

*The indicated specification values are valid for the products at the time of delivery ex works Rohrdorf. In case of doubt Planatol storage samples will be examined as sole reference. Planatol only guarantees the compliance with the specification values as indicated on the data sheet. Furthermore assurances, also orally given, are not guaranteed.*

*A self-test respectively a test of the adhesive regarding the purpose of application through the client is compulsory, especially testing the production conditions/substrates at the customer's site is obligatory. Recommendations given by Planatol are based on experiences and are without any obligation.*

*Indications made on this data sheet present no warranty of characteristic in the sense of the current Federal Supreme Court jurisdiction and are therefore not binding. Please always get in touch self-reliant with the responsible Planatol employee to receive the updated version of this data sheet or for further information concerning suitability regarding the FDA, BfR or EU guidelines.*

*For information regarding product safety please refer to the material safety data sheet.*