**PURMELT® QR 3365**  
Reactive Prepolymer  
February 2010

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**TYPE OF ADHESIVE:**  
Reactive Prepolymer, Moisture Curing

**FIELD OF APPLICATION:**  
Bookbinding > Graphic Industry

**TYPICAL TECHNICAL DATA:**  
Viscosity: 1,800 - 4,200 cPs at 250°F Brookfield, Thermosel, #27  
Color: White  
Open Time: Short - Medium

**PROPERTIES:**  
Purmelt® QR-3365 film provides a good flexibility at high and low temperatures. The adhesive cures to its final bond strength within approximately 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. Purmelt® QR-3365 has good adhesion to PVC and Acetate-films. Bonding of PP and PE-films is only possible after a recent Corona pretreatment which produces a surface energy of >40 dyne/cm.

**HANDLING AND APPLICATION:**  
Processing of Purmelt® QR-3365 with a bulk meter should be performed at the following temperatures: Melting Platen 180 - 200°F; Hose 220 - 235°F; Adhesive applicator/nozzle 240 - 260°F. For the production of very thick books the temperature of the melting plate and the hose may be increased by 20°F in order to secure a continuous and sufficient flow of premelt into the adhesive applicator. Remember to reduce the temperatures back to the original levels afterwards. Uncured material can be cleaned off by using benzyl alcohol, M-Pyrol and other similar solvents. To clean hoses and nozzles, use Purmelt Cleaner 2. To clean roll coaters, use CS-0007. Cured materials can only be cleaned mechanically.

**PRECAUTIONS:**  
Read Material Safety Data Sheet before using and handling this product.

**STORAGE CONDITIONS:**  
Adhesive should be stored in a dry place and should be processed immediately after the container has been opened. In closed original packaging and under normal storage condition, shelf life is 12 months from date of production without negative impact on quality.

**CLEAN UP:**  
To clean hoses and nozzles, use Purmelt Cleaner 2. To clean roll coaters, use CS-0007. Cured materials can only be cleaned mechanically.

**Note**  
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