

## Planatol VP 1253 HM

### Application

Perfect-binding of catalogues, brochures, telephone directories, magazines etc. on common perfect-binding systems at high machine speed.

Pasting and casing-in of thread-stitched book spines.

### Properties

Plasticizer-free hot melt adhesive for book spines with medium clamping effect and excellent adhesion to the sheet edges, containing fillers.

<b>Viscosity</b>	approx. 3,800 mPas (at 443 K / 170 °C acc. to HAAKE RS 1 / ISO 3219) approx. 6,200 mPas (at 423 K / 150 °C acc. to HAAKE RS 1 / ISO 3219)
<b>Open time</b>	medium
<b>Colour</b>	ivory
<b>Film</b>	elastic, flexible
<b>Form of delivery</b>	granulate, packed in 25 kg bags, octabines

### Processing

Work temperature (temperature taken at the roller):

One shot	160 °C – 170 °C (433 – 443 K)
One shot, pasting of thread-stitched book spines	150 °C – 160 °C (423 – 433 K)
Two shot as top coat	160 °C – 170 °C (433 – 443 K)
Inside premelter	10 – 40 °C lower

Heating for substantial periods as well as repeated heating will lead to a gradual darkening of the product, if heated for too long a period or at extremely high temperatures, the adhesive will finally be rendered useless. This is why the amount of adhesive to be processed should be in line with the user's daily requirements.

Ideal conditions that guarantee a maximum durability (page pull values) are as follows:

Notch depth	0.5 – 1.0 mm
Distance of notches	4.0 - 7.0 mm
Dust-free book spine	
Smooth coating width	0.5 – 1.0 mm

Prior treatment of book spines and the application quantity need to be adapted to the papers types used. Papers with long fibres require a smaller grooving depth, thin papers like, for example, rotogravure papers require repeated and deep grooving. If particularly heavy coated papers are involved, prior tests are essential.

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**Wichtiger Hinweis!** Alle Angaben, auch mündlich gegebene Empfehlungen, entsprechen unseren Erfahrungen, Prüfungen und Entwicklungsergebnissen. Prüfen Sie bitte die Eignung des Klebstoffes für Ihr Material durch Eigenversuch. Eine Verbindlichkeit für die durch Sie zu erzielenden Ergebnisse kann nicht übernommen werden, wenn Klebstoff und Klebearbeit unterliegen beim Verarbeiten verschiedenen Einflüssen, die der Kontrolle des Klebstoffherstellers entzogen sind.

**Important!** Any instructions and recommendations given, verbal or written, are based on our personal experience, tests and research. Preliminary testing for suitability of adhesive on materials to be used is recommended. We cannot be held liable for unsatisfactory results, as adhesives and working conditions are subject to various influences which are beyond our control.

**Important!** Toutes nos informations, même les recommandations écrites ou verbales, sont le résultat de nos propres expériences, essais ou développements. Cependant aucune garantie ne peut être assurée par Planatol en ce qui concerne les résultats. Trop de paramètres, notamment les conditions d'utilisation de la colle et des machines, sont indépendants de notre contrôle. Merci donc de tester toute nouvelle colle sur votre propre matériel.



## Note

Even if the prescribed working temperature is adhered to, hot melt adhesives release fumes which may be felt as molesting. Should the prescribed processing temperature be considerably exceeded for substantial time, there may also be the danger of development of harmful decomposition products. This is why the product's user is held to take care for prophylactic measures like installing adequate suction devices and cleaning both the melting tank and the application unit at regular intervals.

## Storing

The bags have to be stored at a cool place and must not be piled up too high in order to prevent the granulate from sticking together.

For further details call our division Application Technologies (phone: +49 8031 720-0).

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