

The World of Bookbinding.



Product information

for using hotmelt gelatine

To ensure high-quality production when working with hotmelt gelatine, the working temperature and the refractometer value are very important.

Gelatine is processed at a temperature of 60 +/- 5°C, measured in the glue tray. At this temperature, the gelatine is fluid. A working temperature above 70°C must be avoided, as otherwise the adhesion will decrease. When the glue is applied, it changes from the liquid sol phase to the solid gel phase at the so-called gelatinising point. Thereby the gelatine develops an instant enormous adhesion, the so-called 'tack'.

For the production of book cases, we recommend PLAKAL 375.

This product, with a viscosity of approx. 2400 mPas, is characterised by a very high adhesion, which makes it suitable e. g. for processing very stiff materials (cellophaned papers etc.). The solids content of PLAKAL 375, the so-called refractometer value - measured at 60°C - is 56 %.

Depending on the type of binding material, PLAKAL 375 may be diluted with water: light, flexible cloth with more, 'bulky' papers with less water.

When using cellophaned papers, the refractometer value should be approx. 54 %, which corresponds to a percentage of water of 3 - 4 %. If the percentage of water is too high, the wet time is too long and the 'tack' is reduced. If the percentage of water is too low, the opposite is the case.

When using binding cloth, the refractometer value should be approx. 49 %, which corresponds to a percentage of water of approx. 10 %.

The refractometer value may be verified with a so-called refractometer. A few drops of fluid gelatine taken from the glue tray or from the glue roller are applied on the mirror window of the refractometer. The refractometer has a scale on the inside indicating the value. The value is read off by holding it against light.

If the refractometer value does not match the recommended values, a correct case-making cannot be guaranteed.

The information given is based on current technical knowledge and experience and is without obligation. The data and information given do not relieve the worker from his duty of care, in particular his trial and test obligations.