

# Product information

## PLAKAL 380



**Major use:** File production, Machine made bookcase production

**Description:** PLAKAL 380 is a protein adhesive with medium viscosity. It shows high initial tack. PLAKAL 380 resists high temperature and humidity levels and shows excellent no-mess handling properties. PLAKAL 380 may be thinned down depending on the quality of the file material or book binding material. Due to its quick-tack properties it is especially suitable for use on high-speed bookcase machines (e.g. Hörauf, Kolbus, Stahl/VBF). PLAKAL 380 has especially good adhesion on corona pretreated PO foils, for example at file production.

PLAKAL 380 is a natural product and colour deviation is normal. The variation in colour has no effect on the quality of the adhesive.

**Characteristics:**  
(undiluted adhesive)

<b>Refractometer value:</b>	<b>57 %</b>
Gelatinizing power:	instantly, strong <sup>1)</sup>
Gelation point:	36.0 °C <sup>2)</sup>
Open time:	short

**Instructions for use:**

**Temperature:** **55 - 65 °C**

The amount of adhesive per surface unit depends to a high degree on the machine type and the materials to be bonded.

- 1) This value was determined at 22°C and 40% relative humidity. It is subject to change through changing climatic conditions and changing concentrations of the solution.
- 2) The gelation or solidification point is defined as the temperature at which the protein adhesive gels (solidifies) under pre-defined conditions.

**Preparation directions:** PLAKAL 380 is molten in the heatable circulation tank at 55 - 65 °C. Please avoid temperatures above 70 °C.

When ready for use the solution should be consumed within 24 hours.

**Dilution:**

Addition of water (%)	0	3	6	9	12	15	18
Refractometer value (%)	56.6	54.9	53.2	51.5	49.8	48.1	46.4

**Storage:** Dry and cool.

**Storage life:** Storage life of at least 6 months if storage conditions are observed.

**Delivery specifications:** Appearance: light brown

Viscosity: 2650 mPas ± 200 mPas <sup>3)</sup>

Solid content: 48.4 %

**Form of delivery:** Pileable 20 kg cartons containing 8 polythene wrapped portions of 2.5 kg each.

**Disposal:** As a rule PLAKAL 380 is biodegradable or degradable in biological sewage plants. In case of doubt, contact your wastewater management authorities.

**Cleaning:** Warm water. We recommend our separating and cleaning agent **PARTINOL**.

For further information please refer to our safety data sheet.

3) Viscosity measure with a Haake rotating viscosimeter at 60°C. As a rule the reading does not coincide with the reading from the viscosimeter on the machine.

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

As per 25. May 2010