

Bid List No. 0017

SPECIFICATION FOR ADHESIVE, HOT- MELT

PROPERTY NO. 024481

General Requirements

The adhesive shall be 100% solid ethylene vinyl acetate based product suitable for use on the Harris UB-4 adhesive binder. It shall be free of objectionable odor over the normal application temperature range. The adhesive should be formulated for high speed bookbinding operations with tin-line trimming (up to 15,000 books per hour), and exhibit good adhesion on both coated and uncoated stocks for books up to 64 mm (2-1/2") thick.

Specific Requirements

Application temperature range: 163° - 204°C (325° - 400°F)

Viscosity, Brookfield, @ 177°C (350°F)...8000-10000 cps

Set time...10 seconds

Color...amber or natural

Tensile strength, min....700 pounds per square inch

Elongation, min....1000%

Durability Requirements

The finished book shall meet the following durability requirements.

Subway test: no loosening of pages at any location.

Page pull: 35.7 g/mm (2.0 lb./in) minimum

Page flex: 125 flexes, minimum

The above durability tests will also be performed after conditioning the book at 54.4°C (130°F) for over 72 hours, followed by conditioning at -5.6 C (22F) for 72 hours, followed by condition at 25C (77F) for 24 hours.

The hot-melt adhesive shall be packaged as pellets in bulk (Gaylord) binds containing 545 kg (1200 lbs.). The packaging and its contents shall withstand at least one-year storage under normal conditions at 43F to 90F (7C to 32C).

Sample Requirements

A 45-kg (100-pound) sample is required for laboratory and performance tests. A Material Safety Data Sheet and technical specification sheet must be submitted with the sample. The Government Printing Office may purchase an additional quantity for extended testing, if necessary.

Qualified Products

The following products have been tested and are satisfactory.

H.B. Fuller: HM-1440,

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