



TECHNICAL DATA SHEET

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Kimbond 2322

Bookbinding Hot Melt Adhesive

Product Description

Kimbond 2322 is a light yellow colored, very high quality, EVA based hot melt adhesive. It's recommended for spine gluing of books, magazines and catalogues on automatic bookbinding machines. Kimbond 2322 is an excellent choice in both soft paperback cover and heavily hard cover bookbinding applications. It also performs well on most medium to fast running speed machines in both cold winter and hot summer conditions.

General Properties

Type	• Bookbinding hot melt adhesive
Appearance	• Light yellow
Forms	• Pellets
Features	<ul style="list-style-type: none"> • Excellent adhesion • Excellent flexibility • Non-fuming and non-tainting • Very high hot tack • Medium setting speed • Very high heat stability • Very low odor
Uses	• Spine gluing of books
Odor	• Slight resinous molten
Packaging	• 25 Kg PE Bag

Physical Properties	Nominal Value Unit	Test Method
Viscosity @ 180 °C	7000-9000 cP	ASTM D3236
Ring & Ball Softening Point	70-80 °C	ASTM E28
Open Time @ 174 °C	15-35 sec	ASTM D4497
Specific Gravity	0.9±0.05 gr/cm ³	ASTM D792
Heat Stability	Very high	ASTM D4499
Setting Time	≤ 5sec	-
Tensile strength	≥3 MPa	ASTM D638
Elongation at break	400-600 %	ASTM D638

Storage and Handling

Kimbond 2322 should be stored in a cool dry place between 5-30°C, away from sources of heat and direct sunlight. Keep product and hot melt units covered to avoid contamination. It must be stored away from any solvents or chemicals. Do not mix with other adhesives.

Safety and Health

Kimbond 2322 is solid at room temperature, so it's not dangerous for handling at these conditions. When it's molten, for protection from burns, wear gloves and a long sleeved shirt during operation. For eyes protection, wear safety goggles. If the burns were occurred, first flush the affected area with large amount of cold water, do not remove adhesive, and then seek for medication immediately.

Shelf life

Best used within 24 months from date of manufacture when stored under the above conditions.

Operating Conditions

The recommended running temperature range is 160-180 °C (320-360°F). Kimbond 2322 can be applied by using of roller, disk and extrusion applicator systems. The cleaning up methods are using of heat, scraper, mineral oil or paraffin.