

## Glue Guide

Below is simple guide to help you decide on what adhesives is best for your needs.

### Creating a two-part set using Bond & Carbonless Paper

Use Howrex Adhesive & Release Agent, an innovative adhesive system that allows you to simply self-separate fanapart sets. Howarex Adhesive & Release Agent works with any combination of bond and carbonless paper - CB + CFB ; CFB + CF.

### Gluing Membership/Credit Cards to Carrier Sheets

Stick the card to the carrier sheet using a small dot of Carrimount adhesive applied with a Pafra Pen. The card can then be peeled off easily without tearing the paper.

### Creating Multi-Part Sets using Plain Paper

You need Superflex Adhesive and Inercote Adhesive Agent. Simply pre-treat the middle sheets of the set with Inercote by brushing onto the edge of the stack. Allow to dry, and collate with the top & bottom sheets before brushing on Superflex to the collated stack. The pre-treated sheets will be glued and you have just produced fanapart sets.

## Inercote & Superflex

### For production of a glued, self separating set of normal bond or bank paper

Many companies are unaware that it is possible to produce a self separating, glued set, with bond or bank paper, in a similar manner to that possible with carbonless (N.C.R) paper. The process works by pre-treating the middle sheets before collation with a chemical agent called Inercote. When dry the sheets are collated together with the two untreated outer sheets (top sheet and bottom sheet), and the whole stack glued up with Superflex Adhesive. When dry the sets will fan apart without the requirement to knife apart by hand. If carbon paper with a selvage forms part of the set, this should be treated with Speedcote. If a two part bond set is required, the Howrex System should be utilised. Inercote, Superflex and Speedcote are available directly from Howarine or through our distributor network in either 5 litre or 3 litre containers.



## Inercote & Superflex

### Fan-Apart 3 Parts to 8 Part Plain Paper Sets

- Before collating treat all middle sheets of set with Inercote adhesive Agent. Sets with one-time carbon only treat selvage of OTC with Speedcote and not middle bond/bank sheets
- Stack sheets on bench or in Howapress. Place a thick strawboard along edge to be treated; clamps or heavy weights should not be used. (Skim trim OTC paper)
- Using a flat side of a very soft 5-7cm brush, apply Inercote or Speedcote. Start at top and with light horizontal strokes brush from centre towards sides. Then brush over once more in same manner {making sure left and right edges are well treated}, ensuring penetration of 2mm
- Check Inercote or Speedcote penetrates 2mm by lifting a corner of pile shortly after brushing. To find Inercote treated edge of dry sheets of paper, moisten edge. If moisture penetrates, the sheet edge has been treated. Speedcote is solvent based and may discolour tinted sheets
- Superflex adhesive is applied with a separate brush after collating into sets; Inercote-treated inner sheets with untreated outer sheets. Jog well, preferably using a flat 'table top' Howajogger
- Stack sheets on bench or in Howapress. If pile is 'spongy' apply enough pressure to reduce 'sponginess'. Apply Superflex adhesive, using Superflex brush. Brush must be fully saturated, apply 2 coats wet on wet
- When dry, fan sets apart by gentle sideways movement along gluing edge. Inercote Ink additive also available to print on middle sheets and on web. If mixing bond and 'NCR-type' sheets, test 550mm pile of sets before collating job

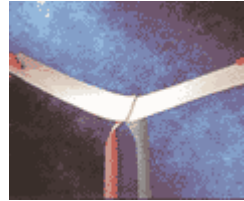
## Remo Adhesive

Remo, applied by hand or printing press, where the user requires to lick and stick, particularly appropriate for envelopes.

## Rioflex

### For the production of glued, self separating N.C.R Carbonless Sets

Howarine invented, in 1962, the adhesive process whereby a collated set of carbonless (N.C.R) paper can be stacked on the bench and padded up with Rioflex adhesive, and the sheets will bond and fan apart into their correct sets without the requirement to knife apart by hand. A range of Rioflex adhesives are available that will produce sets of almost every manufacturers' carbonless (N.C.R) paper on the market in the UK and Europe, even if the job has an unusual collation. Rioflex is available directly from Howarine or through our distributor network in either 5 litre or 3 litre containers.



## Rioflex

### For the production of glued, self separating N.C.R Carbonless Sets

- Check that sets are collated in correct sequence and guillotine with a sharp clean blade immediately before application of adhesive. Do not mix carbonless papers. Refers to data sheet for instructions
- It is advisable that sheets should be the same length with an ink free margin of 5mm on the edge to be glued and the grain direction must be the same throughout the set
- After collating jog well (on flatbed jogger) and stack sheets on bench or in Howapress. Sets to be glued should not be stacked more than 12-15" inches high. Place a thick strawboard along the edge to be glued. Clamps or heavy weights should not be used. (Flat bed jogger is recommended)
- Use a clean soft bristle brush 5/7cm [2/3 inches] wide and apply the adhesive with horizontal strokes starting from the top of the stack and working from the centre towards and working the edges. Two or three coats applied wet on wet should be sufficient for up to a 4 part set. For each additional two sheets in a set [or if using CF card] apply one further coat
- Drying time will vary with conditions and content of set i.e. three part set approx. ½-1 hour, more than three part set up to two hours. If forced drying is used allow 10 mins for adhesive to penetrate between sheets before applying heat
- When adhesive is dry, fan the sets apart by a gentle sideways movement along the glued edge

## Dryflex & Padset

### For production of general purpose pads

Padset is a thick white PVA adhesive with a reputation for reliability and economy. Over the last 20 years it has been Europe's biggest selling general purpose adhesive, and continues to be so. Dryflex is an extra fast drying adhesive, that when dry, allows the padded spine complete flexibility to fold back on itself. This product overcomes the problems many of our customers have experienced with competitors padding compounds, which crack particularly when atmospheric changes occur. Available in 5 or 25 litre containers, every printer who at some time or another makes pads, should keep a tub of Dryflex or Padset in stock. The adhesive is guaranteed for a minimum of 12 months, and is available directly from Howarine or through our distributor network



## Dryflex & Padset

### For production of general purpose pads

- Guillotine trim spine pads, and stack them in Howapress or in a Pyramid Padder under pressure
- Brush on to spine PADDING ADHESIVE
- Dries to a transparent film
- Slice apart between pads with a Howaknife
- DRYFLEX - fast drying adhesive, flexible when dry. Before guillotining slice apart between pads to prevent re-blocking
- Use wide brushes for best adhesion, never open pads until following day
- If sets are required, apply Rioflex, 10 minutes later, brush on Padset or Dryflex
- Howaknives are flat, thin Teflon coated blades to ensure easy slicing of pads with minimal fibre tear

## Howarleim 100 & 200

### For production of perfect bound, open flat books with 2 cold adhesives

It is now possible to produce open flat, perfect bound books, up to 3 inches thick, without having to buy expensive machinery. Only 2 cold adhesives are required, Howarleim 100 and Howarleim 200, and two flat brushes. The procedure is extremely simple. Firstly, apply a coat of Howarleim 100 to the spine of the collated and stacked sheets. This thin adhesive penetrates into the spine. After 10-15 minutes apply a thick coat of Howarleim 200 on the spine. The Howarleim 100 sucks the Howarleim 200 into the book. When dry the result is a perfect bound, open flat and very strong book. If required a wrap around cover can be applied by putting an extra coat of Howarleim 200 on the spine. With the Howarleim process all companies can make perfect bound books which previously would have required expensive hot melt binding equipment. Howarleim adhesives are available directly from Howarine or through our distributors network in 5 litre and 3 litre containers.



## Howarleim 100 & 200

### To make 'open-flat' books of bank, bond or M.F. paper without machinery

#### Card Covers

- If book contains perforated leaves, allow margin of 4-5mm from spine edge to perforation. Stack books with covers interleaved, on bench or in Howapress with a thick strawboard on top - do not apply weight
- Brush on a heavy application of HOWARLEIM 100
- Make sure the left and right edges are well treated
- Wait 5 minutes, apply full clamp pressure and brush on a thick coat of HOWARLEIM 200
- When dry, slice apart between covers and apply spine tape to each book

#### Wrap Around Covers

- Stack books WITHOUT covers, do not apply weight
- Brush on a heavy application of Howarleim 100, wait 5 minutes and then apply full pressure and brush on HOWARLEIM 200
- Smooth on a sheet of blank paper to the glued area for added strength
- When dry, slice off each book from pile, apply Howarleim 200 onto the spine and place in scored "wraparound" paper covers
- The Howarleim process is not yet applicable for coated papers. Use a flat 2" bristle brush for best adhesion, never open books until following day. Spine tape 1 ½ , 2 and 3 inches available ex-stock

## Howarleim III

### For production of tear out copy books without the need to perforate

Howarleim III is designed for pads where there is the requirement to tear out pages from the middle of a pad, rather than just the top, (as in the case of normal telephone pads when Padset or Dryflex can be used). Prior to the invention of Howarleim III the only way of guaranteeing sheets to be pulled out from the middle of a pad, and the remainder of the pad to stay bound together, would have been to perforate the sheets. This is costly in terms of materials and time, particularly press time. With Howarleim III all that is required is to stack the collated pages, apply the adhesive, and wait to dry - providing tear out copy books without the need to perforate. Howarleim III is available in 2.5 litre and 5 litre containers direct from Howarine or through our distributor network.



## Howarleim III

### For production of tear out copy books without the need to perforate

- Guillotine trim spine pads, and stack them in Howapress or in a Pyramid Padder under pressure
- Brush on to spine PADDING ADHESIVE
- Dries to a transparent film
- Slice apart between pads with a Howaknife
- Before guillotining slice apart between pads to prevent re-blocking
- Use wide brushes for best adhesion, never open pads until following day
- Howaknives are flat, thin Teflon coated blades to ensure easy slicing of pads with minimal fibre tear

## Howrex System

### For the production of glued and self part bind sets

When there is a requirement to glue a two part set of bond paper, the Inercote and Superflex process as described above is not applicable. This is due to there being no middle sheet onto which Inercote can be applied. This is why we have developed the Howrex system. Before collation, either the top sheet or the bottom sheet of the set should be fanned out on the bench into steps of 1/8th inch and Howrex release agent applied, to either the top side of the first sheet or the bottom side of the last sheet. The Howrex release agent effectively repels the subsequent adhesive to allow separation to take place. Howrex adhesive is then applied to the collated sheets. Once dry the pad will fan apart into two part glued sets. The Howrex system has numerous applications with difficult or unusual collations e.g. CB, CFB etc. or sets of action paper. Howrex release agent is available in aerosol spray, paste and grease to be applied by hand or dry offset.



## Howrex System

### Fan-apart 2 part plain paper sets

- Before collating, fan out on bench bottom sheets in steps of at least 4mm, bottom Surface uppermost, where separation is required. Alternatively, you may fan-out Top sheets top surface uppermost
- It is advisable that sheets should be the same length with an ink free margin of 5mm on the edge to be glued and the grain direction must be the same throughout the set
- Spray Howrex Release Agent Aerosol along fanned edges - from left to right - From top of the stack of fanned sheets to the bottom, and not reverse. Alternatively brush Howrex Release

Paste over fanned edges. When dry, take a sheet from the middle of the stack and hold it under a running taps. Water should not hold on treated surface

- After collating jog well, and stack sheets on bench with a thick strawboard on top, and apply light hand pressure, or stack in a Howapress. Starting at top with light horizontal strokes apply Howrex adhesive with a soft wide brush - from centre towards sides. Then brush over once more in the same manner
- Immediately when dry [after approx. 15 mins] fan up side of stack 2 inches from corner, to release sets as blocking can occur if left too long

### Unusual Collations on "NCR - Type" Sets

- CFB; CFB; CF and plain card or bond as bottom sheet CB
- CFB as top or bottom sheet - instead of CB or CF sheet
- CF board coated both sides as bottom sheet [such as CFF card]
- Howrex Release Agent Paste also available to print dry offset

### Fastack

#### Fast drying contact adhesive for card to card or paper to paper.

When a fast drying contact adhesive is required, there can be no better adhesive product than Fastack. The applications for Fastack are numerous, but the most common application is in gluing folders, particularly card, where one flat surface needs to be bonded to another flat surface. Fastack may be applied by brush or using the Howarine Pafra 60 Adhesive Glue Pen Dispensers. Alliteratively for longer runs, Fastack can be applied on the press or collator. When Fastack is applied to the paper, it remains fluid until is comes into contact with the paper to which it is to be adhered. The tack is very fast and complete bonding occurs with 10 minutes. Fastack is available in 15 litre, 5 litre and 3 litre containers from Howarine or through our distributor network.



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### S.S.P Padding

#### For production of self separating pads without the requirement to knife apart

Developed for the mass production of pads with a maximum thickness of 1/2", S.S.P. Padding Adhesive, when used in conjunction with Howrex release paste or grease, will result in a self separating pad. This cuts hours off the laborious hand process of knifing apart pads between their bottom boards. Howrex release agent is applied to the bottom of the base board by fanning out into a step formation prior to collation. The boards are then inserted, and then S.S.P Adhesive applied. This has taken 10 years to perfect, because holding bonding of strong pads and the requirement of self separate are opposite extremes. The S.S.P process is successfully being utilised by hundreds of print shops in Europe and has applications wherever padding is done. S.S.P and Howrex release agent is available in 25 litre or 5 litre containers from Howarine or through our distributor network.



## SSP Padding

### For production of self separating pads without the requirement to knife apart

- Guillotine trim spine pads, and stack them in Howapress or in a Pyramid Padder under pressure
- Brush on to spine PADDING ADHESIVE
- Dries to a transparent film
- Slice apart between pads with a Howaknife
- DRYFLEX - fast drying adhesive, flexible when dry. Before guillotining slice apart between pads to prevent re-blocking
- Use wide brushes for best adhesion, never open pads until following day
- If sets are required, apply Rioflex, 10 minutes later, brush on Padset or Dryflex
- Howaknives are flat, thin Teflon coated blades to ensure easy slicing of pads with minimal fibre tear.

## Carrimount

### A peelable / low tack non-permanent adhesive, suitable for the following jobs:

- Attaching credit cards to leaflets
- Paper-bands around magazine
- Credit cards to matt-art paper carrier sheet
- Attaching envelopes or reply paid cards onto letters
- Disks onto magazines



## Carrimount

### Carrimount

- Will bond within 1 minute and has minimal fibre tear on the material when removed

### Carrimount 848

- No fibre tear, but the surfaces will remain slightly tacky

### Carrimount 525

- Latex adhesive, with no fibre tear and will allow the end-user to remove the residue off most surfaces
- Shelf life is limited to 6 months

Customers are advised to test all 3 adhesives to check the material being bonded, LEAVE FOR 24 HOURS / OVERNIGHT and THEN, assess the amount of tear, and if acceptable to the end-user. To reduce any fibre tear, we recommend, "sealing" the printed sheet and the card to be removed. The adhesives should be applied with a small dot using a Pafra 60 Pen or similar applicator.

## Glue Dots on a roll

- Simply press dots in place and lift of the liner
- High tack removable = considered removable on most surface
- Low tack removable = temporary bond - easily removed from any surface
- Super High Tack = permanent bond on most surfaces

**IMPORTANT - Leave 24 hours/overnight to assess the amount of fibre tear**

**ALWAYS USE A SEPARATE BRUSH FOR ADHESIVES AND RELEASE AGENTS  
SHAKE WELL BEFORE USE. AVOID EXTREMES OF TEMPERATURE  
PROTECT FROM FROST. WASH BRUSH IN CLEAN WATER**

## Howabrushes

Flat 2" brushes specially designed for use with Howarine adhesives. Extra strong bristles that will not fall out in cleaning solvents. (Printers should note each Howarine adhesive or adhesive agent should utilise a separate brush.)

## Hot Metal Glue Gun

Specially designed for the gluing of folders, or any other jobs requiring paper, card or plastic to be stuck surface to surface. Simple to operate, and highly accurate.



## Hot Metal Glue Stick

For use with the Howarine TG4 Hot Melt Glue Gun. Designed to be clear and flexible to stick paper and board, flat on flat.

## Howaknives

Flat Teflon coated knives specially designed to slice apart sets or pads. This pallet knife will avoid cutting or damaging paper and Teflon coating assists in cleaning where the adhesive will not stick to the knife.

## Hot Metal Glue Chips

719 For use with Howarines's Hot Melt Binder or our competitors' Hot Melt Binders. The Glue Chips 719 is designed to be non brittle and dry to clear finish.

## Glue Pen

Special dispenser for precise fast and accurate gluing with fast-setting adhesives.

- Self cleaning, non-clogging, glue head
- Choice of 4 different line widths
- Easy to handle 125mm refillable squeeze bottles
- Ideal for factories and outworkers
- Also available fixed head & disposable



## Carriemount

Developed for use with machines which automatically mount either letter headings or credit cards onto a continuous carrier sheet.