PLANATOL FF 54
PLANATOL FF 55
PLANATOL FF 60

Application

PLANATOL FF 54, **FF 55** and **FF 60** are adhesives that have been designed for the production of self-separable forms composition made-up of chemically reacting copying papers. As a rule, the production of form sets from sheets onwards is feasible.

Composition *)

SM 80 g/m² + SC/CB + CFB and / or CF, SM 80 g/m² + SC + SC/CB + CFB + CF.
The addition of the sets with CFB middle sheets is arbitrarily possible.

Properties

PLANATOL FF 54, **FF 55** and **FF 60** are liquid dispersion glues, based on synthetic resin in aqueous phase.

How to produce the forms composition

The collated and head-trimmed form sets are knocked-up to form even edges. Then they are piled up and burdened by a weight on top of the stack. If available, it may also be put in a gluing device. The weight or some type of clamping device should just be strong enough to avoid the formation of gaps between the single sheets so that no excessive penetration of adhesive between them and into them may occur.

The interval between trimming of the glued edge and the glue application should be kept as short as possible. Shake the adhesive vigorously before use and pour only the amount of glue needed at the moment into a suitable receptacle. Do not add water and do not pour any residual glue back into the original tub. Apply the adhesive with a soft brush by starting in the middle of the stack spread the adhesive towards the outside with horizontal movements. Saturation of the paper edge with adhesive is achieved by applying several layers of adhesive one on top of the other, taking care that the previous layer is still wet when the following one is applied

After complete drying of the glue film (approx. 90 minutes) separate the stack into individual sets by fanning it both ways by hand or by knocking it softly on the table. Separation is made easier if the weight is removed from the stack after a drying time of approx. 15 minutes. If at all, a drying facility using infra-red or hot air should not be activated earlier than 15 minutes after glue application. Brushes and receptacles are to be cleaned with water after termination of work.

*) Refer to the remarks on page 4

PLANATOL FF 52-1
(Preparation agent / primer)

PLANATOL FF 52-B Spezial
(Self-separation adhesive)

Application

PLANATOL FF 52-1 in combination with **PLANATOL FF 52-B Spezial** allows for the production of self-separable form sets made-up of natural paper with carbon paper with white margin or slanted corners at the binding edge.

The combination **PLANATOL FF 52-1** + **FF 52-B Spezial**, is recommended for normal papers. For self-separable gluing of natural papers, 3 sheets are required at a minimum.

Properties

PLANATOL FF 52-1 is a preparation agent on aqueous base, supplied ready for use. **PLANATOL FF 52-B Spezial** is liquid adhesive, also supplied in ready condition, which are efficient only in combination with **FF 52-1**.

Any sign of depositing shown by the products after a certain time of storage does not affect the quality of the adhesives. Such deposition will disappear after shaking the glue tubs vigorously. Adhesion among the single sheets of a set is achieved by penetration of the glue dispersion into the treated surface of the paper. The untreated papers, i.e. front of the first sheet and reverse of the last sheet of a forms composition, neither stick to the previous nor to the following set, thus allowing for a separation into individual sets between exactly these sheets.

Working instructions

All inner sheets of the forms composition are piled up to completely equal stack, then burdened with a weight and subsequently be coated with a thick layer of **PLANATOL FF 52-1** by means of a brush moving in horizontal strokes. After drying (approx. 30 minutes) the glued inner sheets are collated with the untreated top and bottom sheets. Completion of the sets is achieved by gluing them either with **PLANATOL FF 52-B Spezial**.

Some Information on Form Set Gluing

Explanations:

CB-paper: A paper coated on its reverse which copies the printing of its front to the following sheet. This is why it is used as front sheet.

CFB-paper: A paper that is coated on either side, thus taking the printing of the previous page and passing it of the following sheet. CFB papers are therefore used as centre sheets.

CF-paper: A paper coated on its front just taking the printing of the previous sheet. This is why CF papers serve as end sheets.

SC-paper: A paper coated on its front which takes the printing of the previous page. It is used in combination with common typing papers.

SC-CB-paper: A paper that has been coated on either side, thus taking the printing of the previous page and passing it to the next sheet.

Options for the combination:

Double set:	Sheet 1	CB		Quadruple set:	Sheet 1	CB
	Sheet 2	CF			Sheet 2	CFB
					Sheet 3	CFB
Triple set:	Sheet 1	CB			Sheet 4	CF
	Sheet 2	CFB				
	Sheet 3	CF				

For more voluminous sets, a yet larger number of centre sheets can be used.

If a common typing paper (SM) or a particularly well glued hard paper is combined with self-copying papers, following options are available to the user:

Sheet 1	SM
Sheet 2	SC
Sheet 3	SC

(triple set that can be completed with as many SC sheets as one likes).

If the user wants to combine a common typing paper (SM) or a hard paper with the self-copying paper types CFB and CF, he will have to us a SC-CB sheet as the CFB sheet only reacts in combination with CB. In this case, the forms composition must be made up of a minimum of 3 sheets which may be as follows:

Sheet 1	SM		Sheet 1	SM
Sheet 2	SC-CB		Sheet 2	SC-CB
Sheet 3	CF		Sheet 3	CFB
			Sheet 4	CF

The set may also contain more than 1 CFB sheet.