



**OLYMPIC**  
ADHESIVES

## **General Procedures for Proper Use of STARFLEX Jelly Glues**

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Jelly glue is a “thermosetting” adhesive – at room temperature it is a “gel” and at application temperature 140°F - 150°F (60°C - 66°C) it is a *sticky* liquid. One surface to be bonded is coated with hot jelly glue and then combined with the other surface; when the temperature drops, the bond forms.

### **Temperature**

1. The ideal temperature for use is 140°F - 150°F (60°C - 66°C). This is by far the most important factor in using jelly glue.
2. Temperatures above 160°F (71°C) will, at a certain point, break down the adhesive and cause foul odors, stringing, “cottoning”, poor adhesion, excessive stickiness and glue darkening or blackening.
3. If the glue looks too dark and has a bad odor, clean all wetted parts.  
Burned glue will contaminate fresh glue.
4. If glue is gelled in the glue pan, start up by heating it slowly and get the glue moving as quickly as possible by frequently stirring, to avoid a “frying pan” effect.
5. When the temperature is below 130°F (54°C) the glue is too cold which results in a rapid increase in viscosity (thickening), poor machining (excessive build up) and loss of tack.

# Equipment and Housekeeping

1. Stainless steel vessels (glue meters, glue pots) are ideal. However, vessels made of other metals are used successfully.
2. Heating of jelly glue must be indirect. The temperature of the jelly glue should be controlled, preferably by a thermostat.
3. The jelly glue vessels should be kept very clean at all times.
4. Never use stagnant water to dilute jelly glue or for clean up. Fresh water is to be used because there is far less chance of bacterial growth which can cause foul odors and a breakdown of adhesive properties.

The above procedures for properly using jelly glues are generally accepted guidelines in the adhesive industry.

## **NON-WARRANTY:**

As the storage, handling and usage of this product is beyond the control of the Producer and Seller, no warranty as to the results to be obtained is made, expressed or implied, whether the product is purchased or furnished as a sample. The Purchaser or User should, therefore, by their own tests and experiments determine the suitability of this product for their own particular use.