



**OLYMPIC**  
ADHESIVES

## **Preparation of STAR DRYFLEX**

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Proper preparation of STAR DRYFLEX results in the best possible adhesion, reduced waste and maximum equipment efficiency.

STAR DRYFLEX is a finely granulated mixture of animal glue, plasticizer and other chemical ingredients. When properly mixed with and dissolved in water and used at the correct temperature, STAR DRYFLEX produces both excellent adhesive results and maximum economy.

1. STAR DRYFLEX can be prepared in two ways:
  - A) COLD SOAK AND HEAT
  - B) HOT COOK UP
  
2. Both preparation methods require accurate measurement of STAR DRYFLEX (which is supplied in either 50 lb. or 100 lb. net weight bags) and the water portion. While estimation is "possible" - in the long run, this results in improperly prepared glue causing waste, inefficiency and poor adhesion.
  
3. For the purpose of this explanation, we will assume that:
  - A) You purchase STAR DRYFLEX in 50 lb. bags.
  - B) Your preparation vessel can hold 113 lbs. of finished adhesive.
  - C) The recommended dilution rate for your STAR DRYFLEX formula is 1.25 lbs. water to 1.0 lb. STAR DRYFLEX.

#### 4. Cold Soak And Heat Method

- A) Place 63 lbs. room temperature water into your clean cooker with the heat off.
- B) While stirring (a small, low speed, power agitator - ideally powered by compressed air), slowly add 50 lbs. STAR DRYFLEX (the entire contents of one 50 lb. bag). Add slowly, to avoid lumping.
- C) Always add glue to water.
- D) As soon as all the STAR DRYFLEX is mixed in ("wet out"), STOP agitation.
- E) Wait 30 minutes.
- F) Turn on heat. As soon as the glue mix starts to liquefy, stir or start agitator.
- G) Heat to 140°F - 150°F (60°C - 66°C). DO NOT rely on indexed thermostats. Use an accurate immersion glue thermometer.
- H) As soon as the glue is smooth, fully liquid and between 140° - 150°F (60°C - 66°C), it is ready for use.
- I) After preparation - keep glue cooker covered and agitate frequently.
- J) Do not make more glue that you will use in one day. Do not try to "save" small amounts of glue in a cooker. Dispose of it. Its value is minuscule compared to the difficulties which might arise from using "old" glue. Keep your cooker CLEANED OUT when not in use.

#### 5. Hot Cook Up Method

- A) Place 63 lbs. of hot water into your clean cooker and turn heat on.

- B) Heat water to approximately 150° - 160°F (66°C - 71°C). DO NOT rely on indexed thermostats. Use an accurate immersion thermometer to check the temperature.
- C) While stirring (a small, low speed power agitator - ideally powered by compressed air), slowly add STAR DRYFLEX.
- D) Always add glue to water.
- E) As soon as all the STAR DRYFLEX is added, continue agitating or stirring until the glue is fully dissolved. You can determine this by checking the solution - it will be free of grit, stringing and will be completely fluid.
- F) Reduce temperature slightly to 140° - 150°F (60°C - 66°C). The glue is now ready for use.
- G) After preparation, keep glue cooker covered and agitate frequently.
- H) Do not make more glue than you will use in one day. Do not try to "save" small amounts of glue in a cooker. Dispose of it. Its value is minuscule compared to the difficulties which might arise from using "old" glue. Keep your cooker CLEANED OUT when not in use.

## 6. **Suggestions**

- A) DO NOT heat STAR DRYFLEX or any animal glue-based product above 160°F (71°C). At higher temperatures, protein in animal glue is destroyed and adhesion is reduced.
- B) Temperature IS important - optimum glue cooker and machine temperature is 140°F - 150°F (60°C - 66°C). ALWAYS use an accurate immersion thermometer to check the temperature.
- C) When adding water to machines:
  - I) Use hot water.
  - II) Mix in slowly.
  - III) Mix thoroughly before making more bonds.

7. The above procedures for a proper preparation of dryflex glues are generally accepted guidelines.

**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.