

## User Guide for Formula glue

Formula glue, used in the Fan-Apart process, permits automatic separation of previously collated sets of Formula paper, it eliminates the need of using a blade to separate them later.

This glue acts by joining only the surfaces of the paper with surface treatment; therefore the last sheet of a set and the first of the following set, the sides of which are in contact and are uncoated, are not glued together.

### Procedure for the correct padding of Formula (Fan-Apart Process)

The process must be carried out at temperature between 20/25°C and 40/60% humidity.

1. Arrange the correctly assembled sets. A normal set will begin with the CB sheet and will end with the CF sheet.
2. All the sheets involved must have the same grain direction.
3. The side to be padded must be guillotined with a perfectly sharpened blade. The guillotine pressure should be the minimum possible and guillotining should be done precisely at the time of application of the glue.
4. The height of the stacks to be padded should not exceed 25-30 cm.
5. Shake the glue well before using directly from the container without additives.
6. Use a flat palette brush 5 cm wide. Application should be from the centre towards the edges and from the top edge downwards, always brushing horizontally.
7. The number of applications or coats of glue should be 2 for sets of 2-3 sheets, and a further run for each two additional sheets.
8. If using papers of 80, 90 g/m<sup>2</sup> or higher, apply a further application.
9. The stack should be placed projecting some 5 mm from the edge of the table and a small board should be placed on top, also 5 mm from the edge of the stack. Then apply glue while the board is held up to the edge of the set and the whole set is brought back to the edge of the table.

After approximately 2 minutes, place a weight on the board so as to apply a pressure of approximately 15 g/cm<sup>2</sup>.

10. Leave to dry for at least 2-3 hours, with natural drying.

11. If forced drying is necessary, wait 10 minutes between padding and the application of hot air.
12. Fan by forcing a transverse movement of the sets, but never separate by sliding one's fingers over the glued edge.
13. Papers having background type printing or areas covered with desensitizing ink in the area to be padded, make it more difficult to pad correctly. As a rule at least 3 mm should be left unprinted up to the padding edge. Capsules broken by pressure can adversely affect correct Fan-Apart padding.
14. The glue expiration date is one year from its manufacturing date.

