



giroform

for the production of forms using
giroformDEKA in combination with standard paper

Instructions for Use:

1. The top sheet of the set should be an uncoated, well-sized standard paper grade possessing a smooth surface - its suitability for fan-apart gluing must always be tested. When sets are produced using uncoated standard top sheets combined with giroform DEKA CB and giroform, gluing performance is reduced because of the different paper characteristics. Adequate bonding of the top and second sheet may prove difficult - therefore it is necessary to carry out gluing tests before production, to increase adhesive application and to separate the forms carefully. When giroform DEKA CB is used as the top sheet in form sets combined with giroform, we recommend the use of giroform fan-apart adhesive. Gluing tests and early separation are also required in this case, as the top surface of giroform DEKA CB tends to bond with the giroform CF.
2. With the exception of the top sheets, all other sheets in the form set must have an ink-free margin of approx 3 mm.
3. The grain direction of the sheet within the form set must be uniform. Wavy edges can be avoided by ensuring that the grain direction of the paper is always parallel to the gluing edge.
4. The collated sets should be knocked up to produce a smooth gluing edge. We recommend a "skim" trim cut before gluing. Good results can only be achieved when the gluing edge is perfectly smooth. The time between trimming the gluing edge and adhesive application should not exceed 30 minutes.
5. In order to establish the optimal amount of adhesive application and the correct timing for separation, we recommend test gluing with small stacks of forms.
6. The stack height for gluing should not exceed 30 cm. The stack should be weighted uniformly; 1-2 kg is sufficient.
7. Shake the fan-apart glue well before use. The required amount of adhesive should be poured into a small, clean container. The adhesive should be applied generously with horizontal strokes until the gluing edge is uniformly glossy. The amount of adhesive applied should be increased when top sheets of higher substance are used.
8. Separation of the sets should be performed carefully by sliding the sets apart. Separation should take place after 30 minutes. Complete drying of the adhesive and bonding of the sheets within the sets takes place after 2-3 hours. We do not recommend the use of heaters to accelerate drying.
9. The adhesive bottle should be closed properly use. The brush and container should be thoroughly cleaned with water. The adhesive should be stored at room temperature for a period not exceeding one year. The adhesive must be protected against frost.
10. We regret that we cannot give a guarantee for the perfect functioning of this gluing system, as various paper qualities possessing varying characteristics are used with giroform DEKA form set combinations.

