

MECOFLOCK® D 453/5-08

Sprayable dispersion-based flocking adhesive

MECOFLOCK D 453/5-08 is a dispersion-based flocking adhesive for spraying, to be used for the flocking of PS (Polystyrene), ABS (Acrylnitrile-Butadiene-Styrene-Terpolymere), SAN (Styrene-Acrylonitrile-Co-polymere), wood, chip boards, many metals and other substrates. When cured, the adhesive results in a hard, tenacious adhesive film with high mechanical characteristics and very good water-resistance. By adding of 5% of MECODUR H 5580 a good adherence is achieved even with difficult substrates. The adhesive is dyed grey.

APPLICATION

Adhesive preparation

Please note: Stir well prior to use resp. prior to removing the product from the container, e.g. with a container-stirring machine of Messrs. Inotek, Typ: VJ 350.040. MECOFLOCK D 453/5-08 is adjusted ready-to-use, i.e. no further thinning is necessary.

as two-components:

Add 5 - 10 % of MECODUR H 5580, depending on kind of application.
Pot life: 4 - 8 h approx., stir every now and then.

Dilution

Water (max. 5 %)

Cleaning

Wet: Water
Dry: PREGAN 1014 E

Application method

Spray application: airless or with compressed air

Application quantity

150 to 250 g/m² of wet adhesive, depending on the kind of application, the flock length and the substrate conditions. In order to achieve a good flock adherence, the dried adhesive coat should make up 1/10th of the flock length, i.e. 1 mm flock length = 0,1 mm of dried adhesive coat.

Substrate preparation

To achieve a good flock adherence and resistancy, the parts to be flocked have to be dry and free from all separating agents (grease, oil, wax, dust, impregnations, etc.) The materials used have to be checked on their suitability by resp. pre-trials.

Flocking

Flocking should be carried out immediately after the adhesive application. A minimum waiting time between adhesive application and flocking is not necessary. The open time of the adhesive depends on the quantity, the substrate and the temperature and may last from 3 to 5 minutes approx.

**Drying
(with hot air)**

Normally for 20 to 30 minutes at 60° to 80° C in a circulating air dryer.
After cooling down to room temperature, the dried parts may be cleaned and handled.

The final curing is achieved at hot air drying for
- one component - after 24 h approx. (1 day)
- two components - after 72 h approx. (3 days)

**Drying
(at room temperature
(above 20° C)**

MECOFLOCK D 453/5-08 may also be dried at room temperatures above +20° C. The cleaning, mounting and handling, however, should take place only 24h after the flocking procedure. The final curing of the adhesive at room temperatures is normally achieved after 72h approx.

Please note: The absolute drying and curing times depend on the actual drying conditions and may differ from the a.m. figures. Better wet resistancies are obtained when the drying is done with hot air.

PRODUCT DATA

Base

Watery dispersion of an acrylic polymere

colour / look

Grey

Viscosity

5.000 mPas approx. (Brookfield RVT, spindle 4, 20 rpm, 20° C)

Please note: According to the recipe the viscosity may drop after a certain storage time, however, without changing the rheological behavior (thixotropy).

Solid contents

44 % approx.

Density

1,11 g/cm³ approx.

P_H-value

9 approx.

Conductivity

< 200 approx. scale parts (Mahlo-Textometer)

**Safety tips /
Environmental protection**

Please check the resp. safety data sheets of those products used.

Storage

12 months (at 20° to 25° C in the original packing)

Beware of freezing