

MECOFLOCK[®] D 590

Screen printable, dispersion based, two-components flocking adhesive

MECOFLOCK D 590 is a dispersion-based, two-components flocking adhesive, especially suitable for the flocking of glass and ceramic substrates. It shows good properties, carries an excellent dish washer fastness as well as a good resistance to household cleaners and chemicals.

PREPARATION

Adhesive preparation Prior to use, stir well.

100 parts of MECOFLOCK D 590
4 parts of MECODUR H 5590

Both components have to be thoroughly mixed into a homogenise mixture which than has to be left alone to ripe for 20min in a closed or at least covered container.

Dyeing: MECOCOLOR D or AF-dyeing pastes, max. addition: 2%.

Pot life: at least 12h

Attention: The end of the pot life cannot be recognised by an increase in its viscosity or by any other change in properties!

Dilution Water (max 5 %)

Cleaning Wet: Water
Dry: PREGAN DL

Application method By the screen printing method

Fabric: 21-36 threads/cm², depending on the motif and on the flock quality. One has to use water resistant copying layers originating from the AZOCOL- or the KIWOCOL copying layer program. For this, the KIWO application technical people are glad to advise you properly.

In order to guarantee a defined adhesive coat, it is basically important to have a high and even fabrics tension (>16 N/cm²).

Application quantity The thickness of the adhesive coat will be primarily determined by the selection of the screen fabrics. Generally to achieve a good flock adherence, the dried adhesive coat should be about 1/10th of the flock length.

This data sheet is for your information. A legally binding assurance of the product's suitability for a specific purpose cannot be derived from it and no liability can be assumed for any potential damages that may occur. Our products are subject to continuous production and quality control and leave our company in perfect condition.

This product is intended solely for industrial applications and not for use by the end consumer. We recommend to our customers to always test the product themselves since only in this way – also after production – can the freedom from certain substances and the suitability for a particular purpose be verified. The user has to test the product for suitability for the intended application. We reserve the right to modify product specifications. Tests that are not part of the specifications of the product mentioned above have not been carried out.

All information applies only to the above-mentioned product obtained from Kissel + Wolf GmbH. It corresponds to our current state of knowledge, but is not a confirmation of a particular application and is not automatically replenished. All information is valid for a maximum of 12 months (annexes may be provided with their own date) or until legal changes are made in this time period. The recipient of our product is solely responsible for observing any possible property rights as well as existing laws and regulations. Property rights of third parties must be observed. Our terms and conditions of sale and delivery shall apply.

Substrate In order to achieve a good flock adherence the surface tension of the parts to be flocked should be bigger than 38mN/m. Further the parts to be flocked have to be dry and free from any substances which might act as separating agents such as silicone, graphite, dust, grease (finger prints), etc. A flame pre-treatment immediately prior to the adhesive application, generally will increase the adhesive adherence to the substrate. With cold final finished glass, a flame pre-treatment is always recommended.

Because of the large number of different kind of glass and ceramics available on the market, respective pre-tests regarding the proposed final use are mandatory.

Flocking Flocking should be carried out immediately after the adhesive coating. The open time of the adhesive depends on different factors and usually lies between 2 to 4min approx.

Drying Because of the watery base of the adhesive and in order to avoid air bubbles, the flocked part should be dried for 10-20min at 60-80° C prior to the actual curing process. The curing requires a forced oven curing for 40min approx. at 140° C.

Recommended process:

First to dry for 10-20min at 60-80° C, after which the curing takes place for 40min at 140° C.

Please note: A deviation from the recommended procedure is possible, however, respective tests and pre-trials are mandatory.

PRODUCT DATA:

Base	Watery acrylic polymer dispersion
Colour/Look	White, drying translucent
Viscosity	58.000mPas approx. (Brookfield RVT, 20 r.p.m., spindle 7, 20° C)
Solids	50% approx.
Density	1,05g/cm ³ approx.
PH-value	7,5 approx.
Conductivity value	> 200 scale parts (Mahlo Textometer)
Hazard advise/ Environmental protection	Please observe the advises given in the safety data sheet
Storage	1 year (at 20° C to 25° C in the original packaging). Beware of freezing! MECOFLOCK D 590 should not come in touch with un-protected metal for a longer period of time.