

MECOFLOCK[®] D 591 SP

Spray- and brush able, dispersion based, two-components flocking adhesive

MECOFLOCK D 591 SP 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 dishwasher fastness as well as a good resistance to household cleaners and chemicals. Furthermore MECOFLOCK D 591 SP can be used for the flocking of ABS, polyurethane or metals.

PREPARATION

Adhesive preparation Prior to use, stir well.

Flocking of glass and ceramic substrates

100 parts of MECOFLOCK D 591 SP
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.

Pot life: at least 12h

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

Flocking of ABS, PU or metals

100 parts of MECOFLOCK D 591 SP
5-10 parts of MECODUR H 5580 LMC

Pot life: at least 4-6 h

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

Attention: When using MECODUR H 5590 the end of the pot life is not indicated by an increase of viscosity or any other change of properties!

Dilution Water (max 5 %)

Cleaning Wet: Water / Dry: MECOPLUS 4274 RE-L

Application method MECOFLOCK D 591 SP is prepared for adhesive application by brush and pneumatic spraying.

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. Liability for damages due to a slightly negligent breach of duty on our part or on the part of our legal representative or vicarious agent is excluded. Our liability for damages due to injury to life, body or health is not covered by this limitation of liability. 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 from the date stated above (annexes may be provided with their own date). Any industrial property rights as well as existing laws and regulations are to be observed by the recipient of our product on his own responsibility. Intellectual 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, ceramics and other materials 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 4 to 6 min approx.

Drying**Drying of glass and ceramic substrates:**

Dry for 10-20 min at 60-80° C, then cure for 40 min at 140° C.

Drying of ABS, PU and other metals:

Dry at room-temperature or 30 min at 80° 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	2200mPas approx. (Brookfield RVT, 20 r.p.m., spindle 3, 20° C)
Solids	44 % approx.
Density	1,05 g/cm ³ approx.
PH-value	7,5 approx.
Hazard advise/ Environmental protection	Please observe the advises given in the safety data sheet
Storage	12 months (at 20° C to 25° C in the original packaging). Beware of freezing!

MECOFLOCK D 591 SP should not come in touch with un-protected metal for a longer period of time.