

MECOFLOCK® D 404

Screenable 2-K-adhesive for hot-curing onto textiles

MECOFLOCK D 404 is a screenable, dispersion-based two-components flocking adhesive to be used for the direct-motif-flocking onto textiles. MECOFLOCK D 404 may be used for the manual screen printing as well as for automatic screen printing carousels. After curing completely, the flocked parts, depending on the used textiles and flock type, have very good wash- and dry-clean-resistance. To achieve an evenly shiny flocking, the adhesive may be dyed in the resp. flock colours.

APPLICATION

Adhesive preparation 100 parts of MECOFLOCK D 404
5-10 parts of MECODUR H 4040

Both components (adhesive and hardener) should be mixed to a homogeneous compound.

Coulouring: MECOCOLOR AF-coulour pastes (coloured), max addition 3 %
MECOCOLOR 404 AF White (white), addition 5 to max. 15 %.

We definitely warn not to add more MECOCOLOR 404 AF White than recommended, as a higher concentration of pigments can prevent flock fibres to sink into the adhesive layer and can therefore reduce resistances.

Furthermore the addition of colour-pastes can reduce manufacturing time depending on added quantity, total quantity and temperature.

Especially addition of colour paste from other manufacturers, which are not adjusted to the adhesive-system have to be seen critical as it may cause extreme pot-life-problems and/or reduced fastness.

Potlife: Min. 7 hours (depending on quantity and temperature).

Reduction of manufacturing time can become critical especially at midsummery temperatures between 30–40° C (10° C higher temperature means approx. bisection of pot-life). Therefore adhesive and hardener should be stored and mixed at 20-25° C and printing process should start immediately afterwards.

Dilution We do not recommend a dilution in order to not negatively influence the resistances of the adhesive.

Cleaning Wet: Water
Dry: PREGAN 1014 E

Application method For screen printing, manually or with a printing carousel. Fabric: 18 - 27 threads/cm, depending on the motif, the quality of flock and of the

substrate. One has to use water resistant copying layers from the AZOCOL- or KIWOCOL copying layer's program. The KIWO-applied technical team is at your service.

Application quantity	200 to 300 g/m ² 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 resistance, the textiles 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 2 to 5 minutes approx.
Drying/Curing	30 to 40 minutes at 80° to 100° C resp. 4 – 6 minutes at 130 – 140° C after which it has to be stored for 24 hours at room temperature (at least 20° C and 50 % rel. humidity). <u>Please note:</u> Hot-curing has to be done the same day as the flocking.
Product Safety:	Before using MECOFLOCK D 404 the suitability of the adhesive system has to be proofed by pre-trials before and also during production for the used substrates (textiles) and flock types regarding adhesion, authenticity features and manufacturing parameters as we cannot grant any liability for defect flocking.

PRODUCT DATA

Base	Watery dispersion of an acrylic polymer
colour / look	White; translucent drying resp. in the chosen colours.
Viscosity	65.000 mPas (Brookfield RVT, spindle 7, 20 rpm, 20° C)
Density	1,04 g/cm ³ approx.
P_H-value	6 approx.
Conductivity	> 200 approx. scale parts (Mahlo-Textometer)
Safety tips / Environmental protection	Please check the resp. safety data sheets of those products used.
Storage	9 months (at 20° to 25° in the original packing). Beware of freezing.