

MECOFLOCK® D 466 LE

Sprayable, one-component, dispersion-based flocking adhesive

MECOFLOCK D 466 LE is a one-component, dispersion-based flocking adhesive for spraying, to be used for the flocking of PS (Polystyrene), ABS (Acrylonitrile-Butadiene-Styrene-Terpolymers), SAN (Styrene-Acryl-Nitrile-Copolymers), 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. MECOFLOCK D 466 LE fulfils resistance to standard damp heat atmosphere (KK40) according DIN 50017.

APPLICATION

Adhesive preparation	Adhesive component is adjusted ready to use. Stir well prior to use. Pot life: not applicable
Cleaning	Wet: Water Dry: PREGAN 1014 E
Application method	Spray application: airless or with compressed air
Application quantity	150 to 250 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 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 2 to 4 minutes approx.

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.

Drying

Drying is achieved within 30 to 60 minutes at 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 after 24 hours (1 day).

Please note: The absolute drying and curing times depend on the actual drying conditions and may differ from the a.m. figures.

PRODUCT DATA

Base	Watery acrylate dispersion
colour / look	Black
Viscosity	5500 mPas approx. (Brookfield RVT, spindle 4, 20 rpm, 20° C)
Solid contents	51 % approx.
Density	0,985 g/cm ³ approx.
P_H-value	7,0 approx.
Conductivity	< 200 approx. scale parts (Mahlo-Textometer)
Safety tips / Environmental protection	Please check the resp. safety data sheets of those products used.
Storage	1 year (at 20° to 25° C in the original packing) Beware of freezing