

## MECOFLOCK<sup>®</sup> D 280 FLEX

### Spray- and brushable, dispersion based flocking adhesive

MECOFLOCK D 280 FLEX is a dispersion-based, one- resp. two-components flocking adhesive. Main application field is the flocking of elastomer and thermoplastic substrates as e.g. EPDM and TPU. Good results can be achieved for the flocking of PVC and other synthetics. In cured condition MECOFLOCK D 280 FLEX has an elastic synthetic-film with good resistances. If there are colour differences between substrate and flock fibre, the adhesive may be dyed with MECOCOLOR -colouring pastes.

### PREPARATION

**Adhesive preparation** Prior to use, stir well.

Preparation for two-component processing:

100 parts of MECOFLOCK D 280 FLEX  
5 parts of MECODUR H 5580

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

Pot life: at least 8h

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: MECOPLUS 4274 RE-L

**Application method** MECOFLOCK D 280 FLEX is prepared for adhesive application by brush and pneumatic spraying.

**Substrate** In order to achieve a good flock adherence the surface should be roughened mechanically or plasma pre-treated. 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, oil, dust, grease (finger prints), etc.

**Because of the large number of different kind of EPDM and elastomer material 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 4 min approx.

**Drying**

Adhesive drying is done within 20-20 minutes at minimum 80° C in the circulating air dryer. After cooling down to room temperature, the dried parts may be cleaned, mounted and packed. The final curing of the adhesive is achieved after 72 hours approx.

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

---

**PRODUCT DATA:**

<b>Base</b>	Watery acrylic polymer dispersion
<b>Colour/Look</b>	White, drying translucent
<b>Viscosity</b>	2400mPas approx. (Brookfield RVT, 20 r.p.m., spindle 3, 20° C)
<b>Solids</b>	50 % approx.
<b>Density</b>	1,01 g/cm <sup>3</sup> approx.
<b>PH-value</b>	7,5 approx.
<b>Conductivity value</b>	> 200 scale parts (Mahlo Textometer)
<b>Hazard advise/ Environmental protection</b>	Please observe the advises given in the safety data sheet.
<b>Storage</b>	1 year (at 20° C to 25° C in the original packaging). Beware of freezing!  MECOFLOCK D 280 FLEX should not come in touch with un-protected metal for a longer period of time.