

## MECOFLOCK<sup>®</sup> D 465

### Sprayable, one-component, dispersion-based flocking adhesive

MECOFLOCK D 465 is a one-component, dispersion-based flocking adhesive for spraying, to be used for the flocking of PS (Polystyrene), ABS (Acrylnitrile-Butadene-Styrene-Terpolymere), SAN (Syrene-Acryl-Nitrile-Co-polymere), 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 465 fulfils resistance to standard damp heat atmosphere (KK40) according DIN 50017.

### APPLICATION

<b>Adhesive preparation</b>	Adhesive component is adjusted ready to use. Stir well prior to use.  Pot life: not applicable
<b>Cleaning</b>	Wet: Water Dry: PREGAN 1014 E
<b>Application method</b>	Spray application: airless or with compressed air
<b>Application quantity</b>	150 to 250 g/m <sup>2</sup> 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.
<b>Substrate preparation</b>	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.
<b>Flocking</b>	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.
<b>Drying</b>	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).  <u>Please note:</u> The absolute drying and curing times depend on the actual drying conditions and may differ from the a.m. figures.

## **PRODUCT DATA**

<b>Base</b>	Watery acrylate dispersion
<b>colour / look</b>	Black
<b>Viscosity</b>	4000 mPas approx. (Brookfield RVT, spindle 4, 20 rpm, 20° C)
<b>Solid contents</b>	51 % approx.
<b>Density</b>	1,024 g/cm <sup>3</sup> approx.
<b>P<sub>H</sub>-value</b>	7,5 approx.
<b>Conductivity</b>	< 200 approx. scale parts (Mahlo-Textometer)
<b>Safety tips / Environmental protection</b>	Please check the resp. safety data sheets of those products used.
<b>Storage</b>	1 year (at 20° to 25° C in the original packing)  Beware of freezing