

## MECOFLOCK<sup>®</sup> D 585 WFP

### Screenable, one- or two-components, dispersion-based flocking adhesive

MECOFLOCK D 585 WFP is a dispersion-based, screenable, one- or two-components flocking adhesive, especially suitable for the flocking of paper in the gift-, greeting cards- and packaging trade. A good adherence on critical substrates is achieved by adding 10% of MECODUR H 5580.

#### APPLICATION

Adhesive mixture to be shaken or stirred well before use.

#### PREPARATION

##### One component:

Adhesive is ready to be used

Pot life:

Not applicable

##### Two components:

100 parts MECOFLOCK D 585 WFP

10 parts MECODUR H 5580

Pot life:

At least 4 h

Dyeing

With MECOCOLOR D or AF-dyeing pastes in the colour of the flock used by adding max. 2%.

#### **Cleaning**

Wet:

Water

Dry:

PREGAN 1014 E

#### **Application method**

By the screen printing method.

#### **Fabric:**

21-43 threads/cm<sup>2</sup>, depending on the motif and on the flock quality. One has to use water resistant copying layers made from the AZOCOL- or the KIWOCOL copying layer program.

The KIWO application technical people are glad to advise you properly.

In order to guarantee a defined adhesive coat, a high and even fabric tension (> 16 N/cm<sup>2</sup>) is essential.

#### **Application quantity:**

Coating thickness: The thickness of the adhesive coating mainly depends on the selection of the screen printing fabric. Generally in order to achieve a good flock adherence, the dried adhesive coat should have 1/10<sup>th</sup> of the flock length.

#### **Substrate preparation:**

In order to achieve a good flock adherence and the required fastness, the parts to be flocked have to be dry and free from any substances which might act as separating agents (grease, oil, wax, dust, impregnation, etc.). All materials to be used in this process should be prior checked of their suitability by resp. pre-tests.

Because of the availability of very different paper material on the market, respective pre-trials regarding the intended final use are imperative.

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|-----------------|---|
| <b>Flocking</b> | Flocking should be carried out immediately after the adhesive coating. A minimum waiting time between adhesive coating and flocking is not necessary. The open time of the adhesive depends on the quantity, the substrate and on the temperature and lies between 2 to 4 min approx.   |
| <b>Drying</b>   | <p>MECOFLOCK D 585 WFP may be dried at room temperatures (over 20 C°). Before handling the product (i.e. cleaning, finishing, packaging), one should wait not less than 48h after the flocking has taken place. The final curing of the adhesive normally is finished after 72 h (3 days) after flocking.</p> <p>PLEASE NOTE: The absolut drying- and curing times depend on the actual drying conditions and may differ from the a.m. times.</p> |

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## **PRODUCT DATA:**

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| <b>Base</b>  | Watery acrylic polymer dispersion  |
| <b>Colour/Look</b>                                     | White, translucent drying resp. in the chosen MECOLOR D color.   |
| <b>Viscosity</b>                                       | 25.000mPas approx. (Brookfield RVT, 20 r.p.m., spindle 6, 20° C)   |
| <b>Solids</b>  | 46 % approx.   |
| <b>pH-value</b>  | 7 approx.  |
| <b>Density</b>   | 1,03g/cm <sup>3</sup> approx.  |
| <b>Hazard advise/<br/>Environmental<br/>protection</b> | Please observe the advises given in the safety data sheet  |
| <b>Storage</b>   | <p>1 year (at 20° C to 25° C in the original packaging)</p> <p>Beware of freezing!</p> <p>MECOFLOCK D 585 WFP should not come in contact with unprotected metal for a longer period of time.</p> |