

MECOFLOCK[®] D 540

Two-components flocking adhesive for application by spraying, by roller and by squeegee

MECOFLOCK D 540 is a two-components dispersion-based flocking adhesive for spraying, for rolling and for the use with a squeegee to flock polyurethane-soft foam. When cured, the adhesive results in a soft, elastic glutinous adhesive film with high resistances to water and UV light. If there are colour differences between substrate and flock, the adhesive may be coloured with MECOCOLOUR-D colour pastes.

APPLICATION

Adhesive preparation	MECOFLOCK D 540 has to be stirred well prior to use 100 parts of MECOFLOCK D 540 4 to 8 parts of MECODUR H 5580 Pot life: at least 8 h <u>Colouring:</u> Add 2 to 5 % of MECOCOLOUR D-colouring paste in the colour of the flock.
Dilution	Water (max. 5 %)
Cleaning	Wet: Water Dry: PREGAN DL
Application method	Spraying, with rollers, with a squeegee
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 resistance, 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 3 to 5 minutes approx.
Drying (with hot air)	Normally for 20 to 30 minutes at 60° to 80° C (circulating air dryer). After cooling down to room temperature, the dried parts may be cleaned and handled. The final curing after hot air drying is reached for after 24 h approx.

**Drying
(at room temperature
(above 20° C)**

MECOFLOCK D 540 may also be dried at room temperatures above +20° C. The finishing (cleaning, handling and packing) however, should take place only 24 h after the flocking procedure. The final curing of the adhesive at room temperatures is normally reached after 72h approx.

Please note:

The final drying and curing times depend on the actual drying conditions and may differ from the a.m. figures. The better wet resistances are obtained when the drying is done with hot air.

PRODUCT DATA

Base	Watery dispersion on a polyurethane base
colour / look	White, translucent drying
Viscosity	2200 mPas approx. (Brookfield RVT, spindle 4, 20 rpm, 20° C)
Solid contents	50 % approx.
Density	1,06 g/cm ³ approx.
ph-value	8,3 approx.
Conductivity	< 200 approx. scale parts (Mahlo-Textometer)
Flashpoint	not applicable
Safety tips / Environmental protection	Please check the resp. safety data sheets of those products used.
Storage	12 months (at 20° to 25° in the original packing) Beware of freezing