

MECOFLOCK® D 564/1

Screenable dispersion-based flocking adhesive

MECOFLOCK D 564/1 is a dispersion-based screenable flocking adhesive to be used for the flocking of PS (Polystyrene), ABS (Acrylnitrile-Butadiene-Styrene-Terpolymere), SAN (Styrene-Acryl-Nitrile-Copolymer), Soft-PVC and other substrates. MECOFLOCK D 564/1 shows on various TPE-parts good adhesion, but pre-trials are generally recommended. When cured, the adhesive results in a hard, tenacious adhesive film with high mechanical characteristics and very good water-resistance. By adding of 5% of MECODUR H 5580 a very good water-resistance and wet-scratch-resistance is achieved. If there are colour differences between substrate and flock fibre, the adhesive may be dyed with MECOCOLOR D-colouring pastes.

APPLICATION

Adhesive preparation	MECOFLOCK D 564/1 is adjusted ready-to-use. Prior to removing the product from its container, it has to be stirred well. <u>For very good water-resistance:</u> Add 5 % of MECODUR H 5580 Pot life: 4 h approx. <u>Colouring:</u> With MECOCOLOR D-colouring pastes in the colour of the flock used: add 2 – 4 %
Dilution	In order to have no bad influence on the resistance of the adhesive a dilution is not advisable.
Cleaning	Wet: Water / Dry: MECOPLUS 4221 CR-L
Application method	By the screen printing method, either manually or with a printing carousel. Fabric: 21-43 threads/cm ² , 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; here the KIWO application technical people are glad to advise you properly.
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 2 to 4 minutes approx.

**Drying
(with hot air)**

Normally for 20 to 30 minutes at 60° to 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 at hot air drying for
- one component - after 24 h approx. (1 day)
- two components - after 72 h approx. (3 days)

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

MECOFLOCK D 564/1 may also be dried at room temperatures. The cleaning, mounting and handling, however, should take place only 24 h after the flocking procedure. The final curing of the adhesive at room temperatures is normally achieved after 72 h approx.

Please note: The absolute drying and curing times depend on the actual drying conditions and may differ from the a.m. figures. Better wet resistancies are obtained when the drying is done with hot air.

PRODUCT DATA

Base	Watery dispersion on polyurethane base
colour / look	White, drying transluscent
Viscosity	40.000 mPas approx. (Brookfield RVT, spindle 7, 20 rpm, 20° C)
Solid contents:	40 % approx.
Density	1,06 g/cm ³ approx.
pH-value:	8,5 approx.
Conductivity	Over 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) MECOFLOCK D 564/1 should not come in touch with unprotected metal for a longer period of time. Beware of freezing