

Technical Information

Adhesive D 404

Screenable 2-K-flocking adhesive for hot-curing onto textiles

Adhesive D 404 is a screenable, dispersion-based two-components flocking adhesive to be used for the direct-motif-flocking onto textiles. Adhesive D 404 may be used for the manual screen printing as well as for automatic screen printing carousels. After curing completely, the flocked parts, depending on the used textiles and flock type, have very good wash- and dry-clean-resistance. To achieve an evenly shiny flocking, the adhesive may be dyed in the resp. flock colors.

APPLICATION

Adhesive preparation 100 parts of Adhesive D 404
5 – 10 parts of Hardener H 4040

Both components (Adhesive and Hardener) should be mixed to a homogenous compound.

Coloring Bomoprint CM Color pigments (colored), max addition 3%
Bomoprint CM 001(white), addition 5 to max 15%

We definitely warn not to add more Bomoprint CM 001 white than recommended, as a higher concentration of pigments can prevent flock fibers to sink into the adhesive layer and can therefore reduce resistances.

Furthermore the addition of color-pastes can reduce manufacturing time depending on added quantity, total quantity and temperature.

Especially additions of color paste from other manufacturers, which are not adjusted to the adhesive-system, have to be seen critical as it may cause extreme pot-life-problems and/or reduced fastness.

Pot life min. 7 hours (depending on quantity and temperature).

Reduction of manufacturing time can become critical especially at midsummer temperatures between 30-40 °C (10 °C higher temperature means approx. bisection of pot-life). Therefore Adhesive and Hardener should be stored and mixed at 20-25 °C and printing process should start immediately afterwards.

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Dilution	We do not recommend a dilution in order to not negatively influence the resistances of the adhesive.
Cleaning:	Wet: Water Dry: PREGAN 1014 E
Application method:	For screen printing, manually or with a printing carousel. Fabric: 18 – 27 threads/cm, depending on the motif, the quality of flock and of the substrate. One has to use water resistant copying layers from the AZOCOL- or KIWOCOL copying layer's program. The technical team is at your service.
Application quantity:	200 to 300 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 1/10 th of the flock length, i.e. 1mm flock length = 0,1mm off dried adhesive coat.
Substrate preparation:	to achieve a good flock adherence and resistance, the textiles 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 5 minutes approx.
Drying/Curing:	30 to 40 minutes at 80° to 100° C resp. 4 – 6 minutes at 130° - 140° C after which it has to be stored for 24 hours at room temperature (at least 20° C and 50% re. humidity).
Product Safety:	Before using Adhesive D 404 the suitability of the adhesive system has to be proofed by pre-trials before and also during production for the used substrates (textiles) and flock types regarding adhesion, authenticity features and manufacturing parameters as we cannot grant any liability for defect flocking.

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PRODUCT DATA

Base:	Watery dispersion of an acrylic polymer
Color / look:	White; translucent drying resp. in the chosen colors
Viscosity:	65.000 mPas (Brookfield RVT, spindle 7, 20 rpm, 20°C)
Density:	1,04 g/cm ³ approx.
Ph-value:	6 approx.
Conductivity:	> 200 approx. scale parts (Mahlo-Textometer)
Safety tips / Environmental protection	Please check the resp. safety data sheet of those products used
Storage:	9 months (at 20° to 25° C in the original packing). !!! Beware of freezing !!!

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