Borchert + Moller GmbH & Co.KG • Kreuzäckerstraße 11-13 • D-72401 Haigerloch - Stetten

Technische Information

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Adhesive D 387

Screenable, low temperature-curing, two-components flocking adhesive

Adhesive D 387 is a dispersion-based, screenable, two-components flocking adhesive, suitable for the flocking of door mats made of coconut-, polypropylene- and polyamide fibres. ADHESIVE D 387 offers especially good wet- and dry resistancies with the flocking of low temperature stable substrates and is specially adapted to be used on automatic screen printing carousels. It also can be used in the manual screen printing.

PREPARATION

Adhesive preparation

100 parts of ADHESIVE D 387
4 parts of Hardener H 5580

Pot life: at least 8h (at 20 to 25° C)

Dilution

Water (max 5 %)

Cleaning

Wet: Water
Dry: MECOPLUS 4221 CR-L

Application method

by the screen printing method, either manually or with a printing carousel.

Fabric: 12-18 threads/cm², depending on the motif and on the flock- and mat 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

500 to 1.000g/m² of wet adhesive, depending on the flock length and the characteristics of the substrate. In order to achieve a good flock adherence, the dried adhesive coat should be 1/10th approx. of the flock length, i.e. for 2mm flock length = 0,2mm of dry adhesive coat.

Substrate characteristics	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.
Flocking	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 4 to 6 minutes approx.
Drying/Curing	The drying time depends on the applied quantity, on the kind of substrate and on the temperature used. Generally, the adhesive may be cured within 40 minutes at 80° C in the circulating air dryer and will achieve the required fastnesses after a storage time of 3 days. Higher temperatures of up to 130° C are also possible.

PRODUCT DATA:

Base	Watery dispersion
Colour/Look	Grey
Viscosity	23.000mPas approx. (Brookfield RVT, 20 rpm., spindle 6, 20° C)
Solids	51 % approx.
Density	1,10 g/cm³ approx.
pH-value	7,5 approx.
Conductivity value	Over 200 scale parts (Mahlo Textometer)
Hazard advise/ Environmental protection	Please observe the advises given in the safety data sheet
Storage	1 year (at 20° C to 25° C in the original packaging) Contact with not corrosion-proofed metals is to be avoided. Beware of frost!

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