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## **Technical Information adhesive L 844**

### **Two-components, solvent based flocking adhesive**

Adhesive L 844 is a two-components solvent-based adhesive for spray- and roller-application used for the flocking of many metals and plastic requiring high quality characteristics when flocked. When completely cured, the adhesive features special resistances to high temperatures of up to 160° C. It is fast to water and oil, grease and acid.

### **APPLICATION**

Adhesive preparation	Stir well before using  100 parts of adhesive L 844 100 parts hardener L 5515  Pot life: 12 h approx.  <u>Dyeing:</u> Add between 1 % to 3 % of coloring agents in the color of the flock used.
Dilution	Thinner 4274 RE-L
Cleaning	Wet: Thinner 4274 RE-L
Application method	by roller resp. spray application.
Application quantity	100 to 150 g/m <sup>2</sup> 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 <sup>th</sup> of the flock length, i.e. 1 mm flock length = 0,1 mm dried adhesive coat.
Substrate properties	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 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 the temperature and amounts to 20 – 30 minutes approx.
Drying (with hot air)	Normally done within 10 – 15 minutes at 80° C (in a circulating air dryer). The final curing is achieved after a waiting period of 24 h at room-temperature

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Drying at room temperature (above 20° C) A drying at room temperature is possible. However, the finishing cleaning, mounting, packing) should be carried out only after a waiting period of at least 24 h after flocking. The final curing of the adhesive is achieved after 72 h approx. (3days).

Please note: The drying and curing times depend on the actual drying conditions and may differ from the times quoted.

#### **PRODUCT DATA:**

Base	Solvent based polyurethane
Color/look	Adhesive L 844 / hardener L 5515: colorless, translucent
Viscosity	Adhesive L 844 1500 mPas approx. (Brookfield RVT, spindle 3, 20 rpm, 20° C)  Adhesive L844 / Hardener L 5515, mixed 1:1 4500 mPas approx. (Brookfield RVT, spindle 5, 20 rpm, 20° C)
Solid contents	60 % approx.,
Density	1,11 g/cm³ approx.
Conductivity	75 approx. scale parts (Mahlo-Textometer)
Flash pint	Adhesive L 844: + 50° C approx. Hardener L 5515: + 38° C approx.
Danger class (VbF)	Adhesive L 844: A II Hardener L 5515: not applicable
Safety tips/ Environmental protection	Please check the resp. safety data sheets of those products used.
Storage	2 years (at 20° to 25° C in the original packing)

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