

ADHESIVE D 585 WFP

Screenable, one- or two-components, dispersion-based flocking adhesive

ADHESIVE D 585 WFP is a dispersion-based, screenable, one- or two-components flocking adhesive, especially suitable for the flocking of paper in the gift-, greeting cards- and packaging trade. A good adherence on critical substrates is achieved by adding 10% of HARDENER H 5580.

APPLICATION

Adhesive mixture to be shaken or stirred well before use.

PREPARATION

One component:

Adhesive is ready to be used

Pot life:

Not applicable

Two components:

100 parts ADHESIVE D 585 WFP

10 parts HARDENER H 5580

Pot life:

At least 4 h

Dyeing

With CM dyeing pastes in the color of the flock used by adding max. 2%.

Cleaning

Wet:

Water

Dry:

PREGAN 1014 E

Application method

By the screen printing method.

Fabric:

21-43 threads/cm², 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.

The KIWO application technical people are glad to advise you properly.

In order to guarantee a defined adhesive coat, a high and even fabric tension (> 16 N/cm²) is essential.

Application quantity:

Coating thickness: The thickness of the adhesive coating mainly depends on the selection of the screen printing fabric. Generally in order to achieve a good flock adherence, the dried adhesive coat should have 1/10th of the flock length.

Substrate preparation:

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.

Because of the availability of very different paper material on the market, respective pre-trials regarding the intended final use are imperative.

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 2 to 4 min approx.

Drying

ADHESIVE D 585 WFP may be dried at room temperatures (over 20 °C). Before handling the product (i.e. cleaning, finishing, packaging), one should wait not less than 48h after the flocking has taken place. The final curing of the adhesive normally is finished after 72 h (3 days) after flocking.

PLEASE NOTE: The absolut drying- and curing times depend on the actual drying conditions and may differ from the a.m. times.

PRODUCT DATA:**Base**

Watery acrylic polymer dispersion

Colour/Look

White, translucent drying resp. in the chosen MECOLOR D color.

Viscosity

32.000mPas approx. (Brookfield RVT, 20 r.p.m., spindle 6, 20° C)

Solids

49% approx.

pH-value

7 approx.

Density

1,03g/cm³ approx.

**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)

Beware of freezing!

ADHESIVE D 585 WFP should not come in contact with unprotected metal for a longer period of time.