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Technical Information adhesive D453/5

Adhesive D 453/5 is a diespersion-based flocking adhesive for spraying, to be used for the flocking of PS (Polystyrene), ABS (Acrylnitrile-Butadene-Styrene-Terpolymere), SAN (Styrene-Acryl-Nitrile-Copolymere), wood, chip boards, many metals and other substrates. When cured, the adhesive results in a hard, tenacious adhesive film with high mechanical characteristics. By adding of 5% harder H 5580 a good adherence is achieved even with difficult substrates. If there are colour differences between substrate and flock fibre, the adhesive may be dyed with MECOCOLOR D-colouring pastes.

APPLICATION

Adhesive preparation: adhesive D 453/5 is adjust ready-to-use. Prior to removing the product from its container, it has to be stirred well.

for polypropylene: Add. 5% of harder H 5580
Pot life: 8 h approx.

Colouring: with Mecocolour D-colouring pastes in the colour
of the flock used: add 2 – 4 %

Dilution: Water (max. 5%)

Cleaning: Wet: Water
Dry: Mecoplus 4221 CR-L

Application methode:spray application; airless or with compressed air

Application quantity: 150 to 250 g/m² 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 resistancy, the parts to the flocked have to be dry and free from all separating agents (grease, oil, wax, dust, impregnations, etc.). The materials used to ve checked on their suitability by resp. pre-trails.

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- 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 3 to 5 minutes approx.
- Drying:**
(at room temperature above 20° C) Adhesive D 453/5 may also be dried at room temperatures above 20° C. 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.
- 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.
 - two component: 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 of an acrylic polymere
Colour/look	Creme
Vicosity	5.000 mPas approx. (Brookfield RVT, spindel 4, 20 rpm, 20° C)
Solid contents	44 % approx.
Density	1,11 g/cm ³ approx.
pH-value	8 pprox.
Conductivity	< 200 approx. scale parts (Mahlo-Textometer)
Safety tips/	Please check the resp. safety data sheets of those products used.
Environmental protection	
Storage	12 months (at 20 – 25 ° C in the original packing)

Beware of freezing

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