

## Adhesive <sup>®</sup> DV D 535

### One-component flocking adhesive for spraying and dipping on dispersion base

ADHESIVE DV D 535 is especially suitable for the flocking of PU-Integrated foam material, for which the preservation of its elasticity is the first goal. When cured, the adhesive coat is very elastic and carries good mechanical resistances. One also receives a flocking with good humidity resistances. If there are colour differences between substrate and flock the adhesive may be dyed with MECOCOLOR colouring pastes.

### APPLICATION

<b>Adhesive preparation</b>	<p>Stir well prior to use. ADHESIVE DV D 535 is adjusted for spraying and dipping (with throwing off).</p> <p>potlife: not applicable</p> <p><u>Dyeing:</u> By adding 2 to 4 % of BOMOPRINT CM-colouring pastes in the colour of the flock to be used.</p>
<b>Dilution</b>	Water (max. 5%)
<b>Cleaning</b>	Wet: Water Dry: PREGAN DL
<b>Application method</b>	Spray application (airless or with compressed air), dipping or throwing
<b>Application quantity</b>	100 to 200 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 1/10th of the flock length, i.e. 1 mm flock length = 0,1 mm of dried adhesive coat.
<b>Substrate preparation</b>	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.
<b>Flocking</b>	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**

Drying of the adhesive for 15 to 20 minutes with temperatures of 110 to 120° C in the circulating air dryer.

After cooling down to room temperature, the dried parts may be cleaned, and assembled ready for shipping. The final curing of the adhesive is achieved after 24h (1 day) normally.

Please note: The final drying and curing times depend on the actual drying conditions and may differ from the a.m. figures.

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**PRODUCT DATA****Base**

Watery dispersion of an acrylic polymer

**colour / look**

cream-coloured, drying cream-coloured resp. in the BOMORPINT CM colour chosen.

**Viscosity**

2400 mPas approx. (Brookfield RVT, spindle 4, 20 rpm, 20° C)

**Solid contents**

34 % approx.

**Density**

1,02 g/cm<sup>3</sup> approx.

**ph-value**

8 approx.

**Conductivity**

> 200 approx. scale parts (Mahlo-Textometer)

**Safety tips /  
Environmental protection**

Please check the resp. safety data sheets of those products used.

**Storage**

9 months (at 20° to 25° in the original packing).  
Beware of freezing.