

03.06.14

Technical Information adhesive D 280

Spray and brush capable flocking adhesive based on dispersion

Adhesive D 280 Flex is a one- or two-component flocking adhesive based on dispersion. Main applications are flocking elastomeric and thermoplastic substrates such as EPDM and TPU. Good results are also obtained in flocking of PVC and other plastics. When the adhesive D280 is cured it forms an elastic plastic film with good resistance. For variations in color between the substrate and flock the adhesive can be colored with color pastes.

APPLICATION

Adhesive preparation:	Shake well before using <u>Approach to two-component processing:</u> 100 parts of adhesive D 280 5 – 10 parts hardener HD 5580 <u>Coloring:</u> color pastes, adding 2% max <u>Pot life:</u> at least 8 hours
Dilution:	Water 5% max
Cleaning:	Wet: Water Dry: Mecoplus 4274 RE-L
Application method:	Adhesive D 280 is set for the application with brush and pneumatic atomization.
Substrate properties:	for a good adhesive bond, the surface should be roughened mechanically or plasma – pretreated. Further, the parts must be free from all the active substances as a release agent, such as silicone, graphite, oil, dust, fat (fingerprints), and so on. Because of the many different on the market available EPDM elastomeric materials preliminary trials regarding the intended purpose of use are essential.
Flocking:	Flocking should be carried out immediately after applying the adhesive The open time of the adhesive is usually 2 – 4 min, depending on various factors.
Drying:	Drying of the adhesive should be at least 80 °C in a circulating air dryer. After cooling down to room temperature, the dried parts can be cleaned, assembled and packed. The adhesive reaches its final resistance after 72 hours.

VELOURDECOR • FIBRE-WALL • BOMOPRINT

03.06.14

Please note: Deviations from the recommended drying times and temperatures are possible, but appropriate tests and preliminary tests are necessary.

PRODUCT DATA:

Base	Aqueous polymer dispersion
Colour/look	White, colorless when dry
Viscosity	2.400 mPas. approx. (Brookfield RVT, spindle 3, 20 rpm, 20° C)
Solid contents	50 % approx.
Density	1,01 g/cm ³ approx.
PH-value	7,5 approx.
Conductivity	>200 scale parts (Mahlo-Textometer)
Safety tips/	Please check the resp. safety data sheets of those products used.
Environmental protection	
Storage	6 month (at 20 – 25 ° C in the original packing), protect from frost Adhesive D 280 should not be in contact with unprotected metal for long periods of time

VELOURDECOR • FIBRE-WALL • BOMOPRINT
