

## Adhesive DV D 591 SP

### Spray- and brushable, dispersion based, two-components flocking adhesive

MECOFLOCK D 591 SP is a dispersion-based, two-components flocking adhesive, especially suitable for the flocking of glass and ceramic substrates. It shows good properties, carries an excellent dish washer fastness as well as a good resistance to household cleaners and chemicals.

### PREPARATION

**Adhesive preparation** Prior to use, stir well.

100 parts of Adhesive DV D 591 SP  
4 parts of Hardener H 5590

Both components have to be thoroughly mixed into a homogenise mixture which than has to be left alone to ripe for 20min in a closed or at least covered container.

Dyeing: Mixcolors DV, max. addition: 2%.

Pot life: at least 12h

Attention: The end of the pot life cannot be recognized by an increase in its viscosity or by any other change in properties!

**Dilution** Water (max 5 %)

**Cleaning** Wet: Water  
Dry: MECOPLUS 4274 RE-L

**Application method** Adhesive DV D 591 SP is prepared for adhesive application by brush and pneumatic spraying.

**Substrate** In order to achieve a good flock adherence the surface tension of the parts to be flocked should be bigger than 38mN/m. Further the parts to be flocked have to be dry and free from any substances which might act as separating agents such as silicone, graphite, dust, grease (finger prints), etc.

A flame pre-treatment immediately prior to the adhesive application, generally will increase the adhesive adherence to the substrate. With cold final finished glass, a flame pre-treatment is always recommended.

**Because of the large number of different kind of glass and ceramics available on the market, respective pre-tests regarding the proposed final use are mandatory.**

<b>Flocking</b>	Flocking should be carried out immediately after the adhesive coating. The open time of the adhesive depends on different factors and usually lies between 2 to 6 min approx.
<b>Drying</b>	Because of the watery base of the adhesive and in order to avoid air bubbles, the flocked part should be dried for 10-20min at 60-80° C prior to the actual curing process. The curing requires a forced oven curing for 40min approx. at 140° C.  <u>Recommended process:</u> First to dry for 10-20min at 60-80° C, after which the curing takes place for 40min at 140° C.  <u>Please note:</u> A deviation from the recommended procedure is possible, however, respective tests and pre-trials are mandatory

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**PRODUCT DATA:**

<b>Base</b>	Watery acrylic polymer dispersion
<b>Colour/Look</b>	White, drying translucent
<b>Viscosity</b>	2200mPas approx. (Brookfield RVT, 20 r.p.m., spindle 3, 20° C)
<b>Solids</b>	44 % approx.
<b>Density</b>	1,05 g/cm <sup>3</sup> approx.
<b>PH-value</b>	7,5 approx.
<b>Conductivity value</b>	> 200 scale parts (Mahlo Textometer)
<b>Hazard advise/ Environmental protection</b>	Please observe the advises given in the safety data sheet
<b>Storage</b>	6 months (at 20° C to 25° C in the original packaging). Beware of freezing!  Adhesive DV D 591 SP should not come in touch with un-protected metal for a longer period of time.