Replaces technical information of 20.06.05 Update: 12.11.13

MECOFLOCK® L 835

Two-components, solvent based flocking adhesive

MECOFLOCK L 835 may be used for the flocking of metal and plastic parts requiring high mechanical and chemical resistances, as well as for concrete. The materials to be flocked may require only a limited elasticity, as MECOFLOCK L 835 cures into a hard rigid adhesive coat. After curing completely, the adhesive is resistant to water and to grease, oil and acids. MECOFLOCK L 835 may be mixed with MECOCOLOR L-colouring pastes if required.

APPLICATION

Adhesive preparation

Stir well prior to use

100 parts MECOFLOCK L 835
100 parts MECODUR L 5515

Pot life: 12 h approx.

Dyeing: Add between 2% to 4% of MECOCOLOR L colouring agents in the colour of the flock used.

Dilution

MECOPLUS 4274 RE-L (max. 5%) or MECOPLUS 4856 ZL-L.

Should flocking result in an insufficient flock-density, you may add max. 20 % MECOPLUS 4856 ZL-L to increase conductibility of the adhesive and therefore improve flocking result. An additional thinning with MECOPLUS 4274 RE-L afterwards is not necessary

Cleaning

Wet: MECOPLUS 4274 RE-L
Dry: PREGAN DL/1

Application method

By roller resp. spray application

Application quantity

100 to 200 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 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.

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 the temperature and amounts to 60 minutes approx.

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Drying (with hot air) 10 to 20 minutes at 110 to 130° C (circulating air dryer) are required. After cooling down to room-temperature, the dried parts may be handled. The final curing is done after 24 h approx.

Drying at room temperature (above 20° C) 24 to 36 h at room temperature (min. of 20° C). Further handling should not take place prior to 24 h of waiting. The final curing of the adhesive is accomplished after 72 h approx.

PRODUCT DATA

Base	Two-components solvent based polyurethane
Colour / look	Colourless, transluscent
Viscosity	MECOFLOCK L 835: 1700 mPas approx. (Brookfield RVT, spindle 4, 20 rpm, 20° C)
Solid contents	65 % approx.
Density	1,1 g/cm³ approx.
Conductivity	MECOFLOCK L 835 / MECODUR L 5515, mixed 1 : 1 55 approx. scale parts (Mahlo-Textometer)
Safety tips / Environmental protection	Please check the resp. safety data sheets of those products used.
Storage	2 years (at 20° to 25° in the original packing)