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MECOFLOCK® L 856

One-component, solvent based flocking adhesive for spraying and brushing

MECOFLOCK L 856 is a one-component solvent based flocking adhesive for the spray- and brush application. It is mainly used for the flocking of rubber profiles (i.e. EPDM) in the car industry. Also, good results are achieved with the flocking of PVC and other plastic. Once it is cured, MECOFLOCK L 856 forms an elastic adhesive film with good abrasion resistancies. If the colour of the substrate and the flock colour differs, the adhesive may be dyed with MECOLOR L-colouring agents.

APPLICATION

Adhesive preparation

Stir well prior to use

MECOFLOCK L 856 is used with 10 % (max. 20 %) MECOPLUS 4856 ZL-L (additive for conductivity). Add MECOPLUS 4856 ZL-L in the necessary quantity to the adhesive and mix well.

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

Cleaning

Wet: KIWOSOLV L 72
Dry: PREGAN DL

Application method

Spray and brush application

Application quantity

80 to 150 gm/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. 0,5 mm flock length = 0,05 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 required. The open time of the adhesive depends on the quantity, the substrat and the temperature during the flocking process and lies between 3 and 5 minutes.

Please note: In order to guarantee a sufficient flock adherence, the use of flock up to a length of 0.6 mm max is recommended.

Drying

2 minutes approx. at 140 to 160° C are required. After cooling down to

(with hot air)	room-temperature, for intermediate curing the parts are stored at room temperature for 12h approx., after which the cleaning is effected followed by handling and packing. The final curing is achieved after 48h approx. at room temperature.
Drying at room temperature (above 20° C)	A drying at room temperature is also possible. However, further handling such as cleaning, mounting and packing, should not take place prior to 24h of waiting after the actual flocking. The final curing of the adhesive is accomplished after 120h approx. (5 days). Please note: The drying and curing times depend on the actual drying conditions and may differ from the times quoted. The better resistancies are achieved with hot air drying.

PRODUCT DATA

Base	Isocyanatic solvent based polyurethane
Colour / look	Colourless – light yellow, transluscent drying
Viscosity	300 mPas approx. (Brookfield RVT, Sp. 3, 20 rpm, 20° C)
Solid contents	60 % approx.
Density	1,08 g/cm³ approx.
Safety tips / Environmental protection	Please check the resp. safety data sheets of those products used.
Storage	6 months (at 20° to 25° in the original packing) MECOFLOCK L 856 is sensitive to humidity and therefore has to be stored in tightly closed original containers.