

# Flocklok® 852

## Technical Data Sheet

Flocklok® 852 is a single-coat surface treatment used to affix polyester or nylon flock fibers to a variety of elastomers. Flocked substrates provide good resistance to abrasion. Flocklok 852 will react and cure with moisture; however, an elevated temperature cure is required to optimize performance properties.

### Features and Benefits:

**Versatile** – performs under a wide range of cure conditions.

**Excellent Performance** – provides excellent performance on a wide variety of elastomers and types of flock.

**Process Compatible** – may be used on-line or off-line; can be catalyzed to achieve faster set time.

### Elastomers:

- Styrene-butadiene (SBR)
- Polychloroprene (CR)
- Nitrile (NBR)
- EPDM Polymers

### Application:

**Surface Preparation** – Remove contaminants (e.g., dirt, rubber bloom, processing oils and mold release) from substrate surface. For some rubber compounds, performance is enhanced by using surface treatments such as corona, plasma or mechanical abrasion.

**Mixing** – Mix Flocklok 852 for 30 minutes with drum mixer at low speed to disperse any settling that may have occurred during storage. Then mix for a minimum of 4-6 hours at 40-60 rpm using the agitator contained in an agitator drum or other suitable mixer. Maintain either continuous mixing at 15-30 rpm or mix the drum for 10 minutes every hour at 15-30 rpm.

If application method requires dilution, use xylene as the diluent.

The cure rate of Flocklok 852 is improved by using Flocklok Catalyst 9986. Adding 1-4% catalyst is suggested. A pot life of 1-2 days can be expected when stored at 21°C (70°F) and material is protected from moisture.

**Applying** – Transfer Flocklok 852 using a peristaltic pump or pressurized vessel.

Apply Flocklok 852 at a wet film thickness of 101-152 micron (4-6 mil), which is the dry film equivalent of 51-76 micron (2-3 mil). Thicker films of Flocklok 852 may be required depending upon profile temperature and flocking efficiency.

The optimum profile temperature at time of application is 52-79°C (125-175°F). Optimum appearance after application is a uniform brown color with no black profile color showing through, no streaks and no “fisheyes”.

**Curing** – An elevated temperature cure cycle is required to optimize performance to EPDM elastomers. The cure cycle is time and temperature dependent. Cure temperatures usually range from 190-232°C (375-450°F). A typical cure cycle is 3 minutes at 204°C (400°F) or 2 minutes at 232°C (450°F) in a forced, hot air oven. On exiting the curing oven, a flocked profile surface temperature of 162-190°C (325-375°F) is optimal for cure and performance properties.

### Typical Properties\*

|                                                 |                                                 |
|-------------------------------------------------|-------------------------------------------------|
| Appearance                                      | Brown Liquid                                    |
| Viscosity, seconds @ 25°C (77°F)<br>Zahn Cup #2 | 30 - 60                                         |
| Density<br>kg/m <sup>3</sup><br>(lb/gal)        | 982.6 - 1006.5<br>(8.2 - 8.4)                   |
| Solids Content by Weight, %                     | 50 - 55                                         |
| Flash Point (Seta), °C (°F)                     | 29 (84)                                         |
| Solvents                                        | Xylene, Methyl Isobutyl Ketone (MIBK), Acetates |

\*Data is typical and not to be used for specification purposes.



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**Cleanup** – Purge fluid lines and equipment with ketone or aromatic solvents. Do not use water. Once Flocklok 852 is in a dried and cured state, clean up will not be possible.

## Shelf Life/Storage:

Shelf life is one year from date of manufacture when stored in a well ventilated area at 21-27°C (70-80°F) in original, unopened container. If not stored at ambient temperature, equilibrate container at ambient temperature for 48 hours prior to initial mixing and use. Do not store or use near heat, sparks or open flame. Store container out of direct sunlight.

Flocklok 852 is moisture sensitive. Minimize exposure to moisture during application and storage.

## Cautionary Information:

Before using this or any Parker LORD product, refer to the Safety Data Sheet (SDS) and label for safe use and handling instructions.

*For industrial/commercial use only.* Required to use under organized emissions. Must be applied by trained personnel only. Not to be used in household applications. Not for consumer use.

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# Flocklok® 852

## 技术说明书

Flocklok® 852是一种单涂型表面处理剂，用于帮助和促进聚酯或尼龙植绒纤维附着至各种弹性体上。植绒基材具有良好的耐磨性。Flocklok 852会与湿气反应并固化；为了提供与基材最佳的附着力，还需进行高温固化。

### 特征和优点:

**多功能性** – 可在广泛的固化条件下发挥功用。

**性能优异** – 适用于多种弹性体和植绒。

**工艺兼容性** – 在线或离线均可使用；加入催化剂可实现快速固化。

### 弹性体:

- 丁苯橡胶 (SBR)
- 氯丁橡胶 (CR)
- 丁腈橡胶 (NBR)
- EPDM 聚合物

### 使用方法:

**表面处理** – 从基材表面除去污染物 (例如灰尘、橡胶喷霜、操作油和脱模剂)。针对某些橡胶混合物，可以使用电晕、等离子处理或机械打磨以提升性能。

**混合** – 大桶中用机械搅拌器低速混合Flocklok 852 30分钟，以分散储存过程中可能出现的任何沉淀物。然后使用包装桶自带的搅拌器或其他合适的搅拌器以 40-60 rpm 的转速至少搅拌 4-6 小时。使用时，保持15-30 rpm的转速持续搅拌，或以15-30 rpm的转速每小时搅拌10分钟。

如果需要稀释，请使用二甲苯作为稀释剂。

加入Flocklok Catalyst 9986催化剂，Flocklok 852的固化速度会加快。建议添加 1-4% 的催化剂。在 21°C (70°F) 及没有湿气的条件下，加入催化剂的产品适用期为 1-2 天。

**涂敷** – 使用蠕动泵或压力容器输送Flocklok 852。

按照101-152 微米 (4-6密耳) 的湿膜膜厚涂敷Flocklok 852，相当于51-76微米 (2-3 密耳) 的干膜。根据型材温度和植绒效率，可能需要更厚的Flocklok 852膜层。

涂敷时的最佳型材温度为52-79°C (125-175°F)。涂敷后的最佳外观是均匀的棕色，看不到黑色型材，无条纹和“鱼眼”。

**固化** – 需要高温固化来提升对EPDM的附着力。固化周期取决于时间和温度。固化温度的范围通常在190-232°C (375-450°F)。典型的固化周期为 204°C (400°F) 时 3 分钟，或 232°C (450°F) 时 2 分钟 (使用热空气烘道)。离开固化烘箱时，植绒型材表面的温度介于162-190°C (325-375°F)时是确保固化和性能的最佳温度。

**清理** – 使用酮类或芳烃溶剂清理液体管路和设备。请勿使用水。一旦Flocklok 852处于干燥和固化状态，则无法清理。

### 典型特性\*

|                                     |                           |
|-------------------------------------|---------------------------|
| 外观                                  | 褐色液体                      |
| 粘度, 秒 @ 25°C (77°F)<br>Zahn 杯 #2    | 30-60                     |
| 密度<br>kg/m <sup>3</sup><br>(lb/gal) | 982.6-1006.5<br>(8.2-8.4) |
| 固体含量, %                             | 50-55                     |
| 闪点 (Seta), °C (°F)                  | 29 (84)                   |
| 溶剂                                  | 二甲苯、甲基异丁基酮 (MIBK)、乙酸酯类    |

\*典型数据不可作为产品标准之用。



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## 保质期/储藏要求:

自生产之日起,保质期为一年,但是收货人必须使用出厂未开封的原装容器,在 21-27°C (70-80°F) 的温度下保存于通风良好区域。如果在非室温条件下存储,则在初次搅拌和使用前将容器平置在室温条件下 48 小时。储藏或使用时不得靠近热源、火花或明火。储存容器时避免阳光直射。

Flocklok 852对于湿度敏感。在使用和储存的过程中,尽量减少本品与水分的接触。

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