

# Flocklok® 852F

## Technical Data Sheet

Flocklok® 852F 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 852F 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.

**Fast Cure** – typical cure is 2 minutes at 204°C (400°F).

## 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 852F 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 6-8 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.

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

Apply Flocklok 852F at a wet film thickness of 95-145 micron (3.7-5.7 mil), which is the dry film equivalent of 51-76 micron (2-3 mil). Thicker films of Flocklok 852F 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 2 minutes at 204°C (400°F) or 1 minutes at 232°C (450°F) in a forced, hot air oven. On exiting the curing oven, a flocked profile surface temperature of 180-190°C (356-375°F) is optimal for cure and performance properties.

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

## Typical Properties\*

|                                                 |                                |
|-------------------------------------------------|--------------------------------|
| Appearance                                      | Brown Liquid                   |
| Viscosity, seconds @ 25°C (77°F)<br>Zahn Cup #2 | 50-100                         |
| Density<br>kg/m <sup>3</sup><br>(lb/gal)        | 980-1050<br>(8.2-8.8)          |
| Solids Content by Weight, %                     | 52-56                          |
| Flash Point (Seta), °C (°F)                     | 29 (84)                        |
| Solvents                                        | Xylene, Ethyl Benzene, Acetone |

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



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## Shelf Life/Storage:

Shelf life is six months 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 852F 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.

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OD DS4426CE 12/20 Rev.0



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# Flocklok® 852F

## 技术说明书

Flocklok® 852F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 852F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:

**用途广泛** – 可在广泛的固化条件下发挥功用。

**优异的性能** – 对各种弹性体和各种类型的植绒具有优异的附着力。

**工艺兼容** – 可在线或离线使用。

**固化速度快** – 在204°C (400°F) 下的典型固化时间为2分钟。

### 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** – 清除基材表面的污染物 (如灰尘、橡胶发白、加工油和脱模剂)。针对某些橡胶，可以使用电晕、等离子处理或机械打磨进行处理以提升性能。

**混合** – 使用圆筒混合机低速混合Flocklok 852F 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搅拌器滚筒内的搅拌器或其他合适的混合器，以40-60 rpm的速度混合至少6-8小时。以15-30 rpm的速度保持连续混合，或者以15-30 rpm的速度每小时混合滚筒10分钟。

如果涂敷方法需要稀释，使用二甲苯作为稀释剂。

**涂敷** – 使用蠕动泵或压力容器输送Flocklok 852F。

以95-145微米 (3.7-5.7 密尔) 的湿膜膜厚涂敷Flocklok 852F，相当于51-76微米 (2-3 密尔) 的干膜。根据型材温度和植绒效率，可能需要更厚的Flocklok 852F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。固化周期与时间和温度相关。固化温度通常介于 190-232°C (375-450°F) 之间。典型的固化条件是在204°C (400°F) 下2分钟，或者在强制热风烘箱中 232°C (450°F) 下1分钟。离开固化烘箱时，植绒型材表面的温度介于180-190°C (356-375°F) 时是确保固化和性能的最佳温度。

**清理** – 使用酮或芳香族溶剂吹扫流体管路和设备。请勿用水清洗。一旦Flocklok 852F处于干燥和固化状态，则无法清理。

### 保质期/储藏要求:

储存在未开封的原装容器中，放置在储存温度介于 21-27°C (70-80°F) 的良好通风区域，则从生产之日起，有6个月的保质期。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。储藏或使用不得靠近热源、火花或明火。请勿将容器存放在阳光直射的地方。

Flocklok 852F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。

| 典型特性*                                    |                       |
|------------------------------------------|-----------------------|
| 外观                                       | 棕色液体                  |
| 粘度, seconds @ 25°C (77°F)<br>Zahn Cup #2 | 50-100                |
| 密度<br>kg/m³<br>(lb/gal)                  | 980-1050<br>(8.2-8.8) |
| 固体含量, %                                  | 52-56                 |
| 闪点 (Seta), °C (°F)                       | 29 (84)               |
| 溶剂                                       | 二甲苯、乙苯、丙酮             |

\*典型数据不可作为产品标准之用。



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