

Flocklok® 852F Flock Adhesive

Technical Data Sheet

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

Features and Benefits:

Versatile – performs under a wide range of cure conditions.

Excellent Adhesion – provides excellent adhesion to 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 adhesive 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 adhesive using a peristaltic pump or pressurized vessel.

Apply adhesive 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 adhesive may be required depending upon profile temperature and flocking efficiency.

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

Typical Properties*

Appearance	Brown Liquid
Viscosity, seconds @ 25°C (77°F) Zahn Cup #2	50 - 100
Density kg/m ³ (lb/gal)	980 - 1050 (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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Curing – An elevated temperature cure cycle is required to optimize adhesion 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 adhesive cure and performance properties.

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

Shelf Life/Storage:

Shelf life is six months from date of shipment 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 adhesive is moisture sensitive. Minimize exposure to moisture during application and storage. After opening and while removing contents, protect adhesive from excessive moisture by installing desiccant cartridges and/or using dry nitrogen as an inert cover. Do not leave container open.

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. Must be applied by trained personnel only. Not to be used in household applications. Not for consumer use.

Values stated in this document represent typical values as not all tests are run on each lot of material produced. For formalized product specifications for specific product end uses, contact the Customer Support Center.

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