

Flocksil® 1501 (SF) Flock Adhesive

Technical Data Sheet

Flocksil® 1501 (SF) adhesive is a polyurethane adhesive used to adhere polyester or polyamide flock fibers to a variety of uncured and semi-cured elastomers including EPDM, NR, CR and SBR. When used in combination with a surface treatment, Flocksil 1501 (SF) adhesive can be used for flocking of a variety of thermoplastic elastomers (TPE).

Flocksil 1501 (SF) flock adhesive will react and cure with moisture; however, an elevated temperature cure is required to optimize adhesion and performance properties.

Features and Benefits:

Durable – provides a flexible, abrasion-resistant cured film.

Excellent Adhesion – provides excellent adhesion to a wide variety of substrates and types of flock.

Process Compatible – can be catalyzed to achieve faster cure time; provides extended working time at room temperature (>20 hours, 50% RH).

Application:

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

Mixing – Thoroughly stir adhesive before use, and agitate sufficiently during use to keep dispersed solids uniformly suspended.

The cure rate of Flocksil 1501 (SF) adhesive can be accelerated by using Cuvertin® K4 or Cuvertin K18 catalyst. Adding 1% catalyst is suggested. Keep the adhesive at low agitation when adding the catalyst.

Applying – Apply adhesive by brush or spray methods. Recommended dry film thickness of Flocksil 1501 (SF) adhesive is 40-50 micron (1.6-2.0 mil).

Curing – When uncatalyzed, Flocksil 1501 (SF) adhesive will typically cure in 4 minutes at 180°C (356°F). When catalyzed with Cuvertin K4 or Cuvertin K18 catalyst, Flocksil 1501 (SF) adhesive will cure in approximately 1-1.5 minutes at 180°C (356°F).

Shelf Life/Storage:

Shelf life is six months from date of manufacture when stored by the recipient in a well ventilated area below 25°C (77°F) in original, unopened container. During transportation to the customer, the temperature restriction does not apply.

After opening and while removing contents, protect adhesive from excessive exposure to moisture by using dry nitrogen as an inert cover. Do not leave container open.

Typical Properties*

Appearance	Brown Liquid
Viscosity**	
mPa·s / cps @ 25°C (77°F) Brookfield LVT Spindle 1, 30 rpm	20-100
seconds @ 20°C (68°F) 4 mm DIN cup	15-30
Density @ 20°C (68°F) g/cm ³ (lb/gal)	0.93-0.97 (7.76-8.01)
Solids Content by Weight, % 2.5 gram dried 30 minutes @ 130°C (266°F)	45-49
Gel Time, minutes @ 180°C (356°F)	4

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

**Viscosity may increase by 25% after production.



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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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