

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 2 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 four 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)	3

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

**Viscosity may increase by 25% after production.



ENGINEERING YOUR SUCCESS.

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.

Information provided herein is based upon tests believed to be reliable. In as much as Parker LORD has no control over the manner in which others may use this information, it does not guarantee the results to be obtained. In addition, Parker LORD does not guarantee the performance of the product or the results obtained from the use of the product or this information where the product has been repackaged by any third party, including but not limited to any product end-user. Nor does the company make any express or implied warranty of merchantability or fitness for a particular purpose concerning the effects or results of such use.

WARNING — USER RESPONSIBILITY. FAILURE OR IMPROPER SELECTION OR IMPROPER USE OF THE PRODUCTS DESCRIBED HEREIN OR RELATED ITEMS CAN CAUSE DEATH, PERSONAL INJURY AND PROPERTY DAMAGE.

This document and other information from Parker-Hannifin Corporation, its subsidiaries and authorized distributors provide product or system options for further investigation by users having technical expertise.

The user, through its own analysis and testing, is solely responsible for making the final selection of the system and components and assuring that all performance, endurance, maintenance, safety and warning requirements of the application are met. The user must analyze all aspects of the application, follow applicable industry standards, and follow the information concerning the product in the current product catalog and in any other materials provided from Parker or its subsidiaries or authorized distributors.

To the extent that Parker or its subsidiaries or authorized distributors provide component or system options based upon data or specifications provided by the user, the user is responsible for determining that such data and specifications are suitable and sufficient for all applications and reasonably foreseeable uses of the components or systems.

©2020 Parker Hannifin - All Rights Reserved

Information and specifications subject to change without notice and without liability therefor. Trademarks used herein are the property of their respective owners.

OD DS4456 08/20 Rev.0



Parker LORD
Engineered Materials Group

111 LORD Drive
Cary, NC 27511-7923
USA

phone +1 877 ASK LORD (275 5673)

www.lord.com