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® K 24 catalyst. Adding 1-3% 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 K 24 catalyst, Flocksil 1501 (SF) adhesive will cure faster at 180°C (356°F) depending on the amount of catalyst added.

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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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.

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.

Verify Volatile Organic Compounds (VOC) requirements with the applicable local, regional and state air quality authorities before importing, selling or using this product. VOC rules, thresholds and reporting obligations vary by jurisdiction; compliance is the responsibility of the importer/seller/owner.

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

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