

Flocklok® 750T/750C Flock Adhesive

Description

LORD Flocklok® 750T/750C adhesive is a two-part, single-coat adhesive used for adhering polyester or nylon flock fibers to TPV and TPO substrates.

Features and Benefits

Excellent Adhesion – provides excellent adhesion to properly treated TPV and TPO substrates.

Low Temperature Cure – enables flocking of heat-sensitive substrates.

Convenient – accommodates various types of pumping, mixing and application equipment.

Easy to Use – provides longer open time for greater flock density.

Environmentally Recommended – formulated to reduce emissions of Hazardous Air Pollutants (HAPs).

Application

Surface Preparation – Remove contaminants (e.g., dirt, plasticizers, processing oils) from substrate surface. Adhesion can be enhanced by using surface treatments such as corona, plasma or mechanical abrasion.

Mixing – Prior to use, thoroughly mix Flocklok 750T adhesive with Flocklok 750C catalyst. Mix ratio is best determined by the customer depending on particular application. Recommended initial mix ratio is 100 parts adhesive to 2 parts catalyst, by weight. Hand stirring or slow-speed mechanical mixing should be sufficient to ensure good mixing.

Applying – Apply adhesive/catalyst mixture by brush or spray methods.

Apply Flocklok 750T/750C adhesive at a wet film thickness of 100 micron (4 mil) to obtain optimum adhesion and performance properties.

Curing – An elevated temperature cure cycle is required to optimize adhesion. Typical cure cycle is 7-10 minutes at 65°C (150°F) in a forced, hot air oven. Allow flocked parts to cure at least 24 hours before testing.

Typical Properties*

	750T Adhesive	750C Catalyst
Appearance	Clear Blue Liquid	Clear Liquid
Viscosity, cps @ 25°C (77°F) Brookfield LVT	150-300 Spindle 2, 30 rpm	<10 Spindle 1, 30 rpm
Density kg/m ³ (lb/gal)	982.6-1018.5 (8.2-8.5)	874.7-922.6 (7.3-7.7)
Solids Content by Weight, %	53-57	4.75-6.75
Flash Point (Seta), °C (°F)	32 (90)	36 (97)
Solvents	Xylene, n-Butyl Propionate	n-Butyl Propionate

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

LORD TECHNICAL DATA

Cleanup – Purge fluid lines and equipment with xylene or methyl ethyl ketone (MEK). Do not use water. Once the adhesive is in a dried and cured state, clean up will be more difficult.

Shelf Life/Storage

Shelf life of each component 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.

Do not store or use near heat, sparks or open flame. After opening and while removing contents, protect adhesive from excessive exposure to moisture by installing desiccant cartridges in the cover and/or using dry nitrogen as an inert cover. Do not leave container open.

Cautionary Information

Before using this or any 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 technical data sheet 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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