

# Flocklok® 853 Flock Adhesive

## Description

LORD Flocklok® 853 adhesive is a blocked, heat-curing, single-coat adhesive used to adhere polyester or nylon flock fibers to a variety of elastomers including EPDM, NR, CR and SBR. Flocked substrates provide good resistance to abrasion.

## Features and Benefits

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

**Easy to Use** – eliminates moisture sensitivity, allowing for slower evaporation rate and longer open time.

**Process Compatible** – can be catalyzed to achieve faster set time.

## 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** – Mix Flocklok 853 adhesive for 15-30 minutes with drum mixer at low speed to disperse any settling that may have occurred during storage. Then mix for 4-6 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. Use an air-driven mixer or other explosion-proof mixer.

If application method requires dilution, use xylene as the diluent.

The cure rate of Flocklok 853 adhesive is improved by using Flocklok Catalyst 9984. Add 1-3 parts catalyst, by weight, to 100 parts adhesive. A pot life of at least two days can be expected when stored at 21°C (70°F) and material is protected from moisture.

## Typical Properties\*

Appearance	Brown Liquid
Viscosity	
cps @ 25°C (77°F)	150 - 400
Brookfield LVT	
Spindle 3, 30 rpm	
seconds @ 25°C (77°F)	20 - 45
Zahn Cup #3	
Density	
kg/m <sup>3</sup>	976.6-1012.5
(lb/gal)	(8.15-8.45)
Solids Content by Weight, %	52 - 56
Flash Point (Seta), °C (°F)	18 (66)
Solvents	Toluene, Xylene, Methyl Isobutyl Ketone (MIBK), Acetates, Acetone

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

# LORD TECHNICAL DATA

**Applying** – Transfer Flocklok 853 adhesive using a peristaltic pump or pressurized vessel.

Apply adhesive by drip-and-drag (brush) or spray methods. Apply Flocklok 853 adhesive at a wet film thickness of 101-152 micron (4-6 mil), which is the dry film equivalent of 51-76 micron (2-3 mil).

Thicker films of Flocklok 853 adhesive may be required depending upon profile temperature and flocking efficiency.

The optimum profile temperature at time of adhesive application is 71-93°C (160-200°F).

**Curing** – When used uncatalyzed, Flocklok 853 adhesive will typically cure in 3 minutes at 204°C (400°F) or in 2-1/2 minutes at 246°C (475°F).

**Cleanup** – Use a ketone solvent to clean up adhesive.

## 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.

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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## 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.

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