

## Flocking with 5118 EVA

5118 is a medium viscosity adhesive specially formulated for the manufacture of screen printed flocked pictures. It is designed to attract the flock and, when dried, to have a good degree of scrub resistance and to be transparent and flexible. 5118 provides excellent bonds to board and to wood composites and has some resistance to moisture and plasticizers. It is suitable for use in packaging and film lamination and has also been used for bonding carpeting materials, felt and fabrics.

5118 is characterised by its high wet grab, good setting speed, excellent adhesion to low surface energy substrates, and good heat, moisture and plasticizer resistance. 5118 shows good adhesion to plastic films and is therefore suitable for polyester, polystyrene, PVC and coated cellophanes.

5118 is a polyvinyl alcohol stabilised, vinyl acetate / ethylene copolymer.

### Materials 5118 EVA is suitable for

- ✦ Board
- ✦ Wood composites
- ✦ Carpeting materials
- ✦ Felt
- ✦ Fabric
- ✦ Polyester
- ✦ Polystyrene
- ✦ PVC
- ✦ Coated cellophanes

### Storage

5118 EVA should be stored in a sealed container away from heat, direct sunlight and frost, at temperatures between 5°C and 25°C for not more than 6 months.

### Applications

5118 is specifically formulated for the manufacture of screen printed flocked pictures. It can also be used for other purposes such as, bonding vinyl floor coverings to sample boards, carpet, felt and fabrics to sample boards, packaging, filter manufacturing, bonding of clear film inserts in boxes, laminating board and high quality tube winding.

### Method of Application

There are various ways to apply the adhesive; any way that you can apply paint to a surface is also a possible way to apply the adhesive. Any of the following methods can be used (although some will be more successful after the viscosity of the adhesive has been reduced).

- ✦ Paint Brush
- ✦ Paint Roller
- ✦ Spray Gun
- ✦ Screen printing

The adhesive must not be applied to any part of the substrate that does not require flocking. Those areas should be covered with a mask or sealed off with masking tape.

### Preparation of the substrate

The substrate must be clean, dry and grease-free before the adhesive is applied. It is important that the adhesive coating does not get absorbed by the surface of the substrate, therefore, with porous substrates (e.g. wood, chipboard, etc), a primer (such as thinned EVA glue) may have to be used prior to the adhesive. A thick layer of adhesive must be applied (approximately 1/10 of the length of the flock fibre), so that the flock can adhere adequately to the substrate.

### Curing Times

Air Temperature	Curing Time	
	Working Cure	Full Cure
°C	hrs	hrs
°C	hrs	hrs

### Using Pigments

Pigments can be added to the adhesive, in order to achieve a seamless finish, where the substrate is a markedly different colour to the flock being used. In addition, if the substrate comprises more than one colour, adding pigment to the adhesive will prime the substrate, giving a uniform appearance. The adhesive is matched to the flock in colour. This also compensates for areas with a slightly lower flock density (e.g. in interior corners).

When applying a dark flock onto a bright substrate a few percents of pigment added are quite sufficient. At least 10% of white pigment has to be added to the adhesive for white flocking onto dark surfaces. When you are flocking a lighter coloured flock onto a darker coloured substrate (e.g. yellow flock onto a blue substrate) it will be necessary to add white pigment, as well as pigment matching the colour of the flock, to the adhesive in order to attain the appropriate finish.

### Reducing the viscosity of 5118 EVA

5118 EVA can be used straight from the container, it can also be diluted with water. By thinning down the adhesive, you increase the range of possible uses, for example, priming a substrate or spray application.

To thin down the aqueous adhesives, simply use clean water. The adhesive can be thinned down by up to 10%.

### Health & Safety

This product is classed as having a low level of hazard if handled with normal care. It should not be ingested and care should be taken to avoid contact with skin and eyes.

Spillages can be absorbed with sawdust or other suitable material and small quantities may be washed away with water according to Local Authority Regulations.

The adhesive is water-based and is, therefore, non-flammable.



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