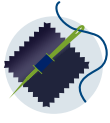




3820 FLOCK ADHESIVE



RECOMMENDED FABRICS

100% Cotton
50/50 Cotton/Polyester Blends
100% Polyester



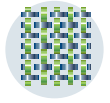
INK APPLICATION

3820 Flock Adhesive must be mixed with the 900 Catalyst before printing.



ADDITIVES

Not recommend



SCREEN MESH

86-110 t/in (34-43t/cm)
monofilament recommended.



EMULSION

Any direct or indirect solvent resistant emulsion or capillary film.



SQUEEGEE

60-70 Durometer
Sharp edge



CURE TEMPERATURES

325°F (163°C) entire ink film.



CLEAN-UP

Any eco-friendly plastisol screen wash



PRODUCT PACKAGING

Quart, 1 gallon, 5 gallon, 30 gallon or 50 gallon containers



STORAGE OF INK CONTAINERS

65° to 90°F (18°C to 32°C)
Avoid storage in direct sunlight Keep containers well sealed



SDS

Refer to SDS prior to use

FEATURES

3820 Flock Adhesive is a two-part flock adhesive used to produce high quality flock prints.

3820 Flock Adhesive provides excellent adhesion to most flock fibers and produces a very soft and flexible flock print when the product is properly printed and cured.

Designs made with 3820 Flock Adhesive may be applied to light or dark fabrics.

SPOT FLASHING

3820 Flock Adhesive will spot dry, with a very low after flash tack. Dwell time is dependent on the spot dryer used. In some cases, you may have to lower the heat of the spot cure unit because too much heat may actually make the ink tacky. When you spot dry, you are only partially fusing or gelling the surface of the ink. The ink should be just dry to the touch, with no lift off, but not totally fused. Totally fusing the underprint may cause inter-coat adhesion problems with the inks printed on top. Final fusing or curing should occur in the dryer.

FLOCK APPLICATION

3820 Flock Adhesive must be mixed with the 900 Catalyst before printing. Catalyst is provided in 2 oz. and 8 oz. containers and should be thoroughly hand stirred into the ink to the following proportions:

20 parts ink to 1 part catalyst (5% by weight)

- 1 oz. Catalyst to 1 pint of ink
- 2 oz. Catalyst to 1 quart of ink
- 8 oz. Catalyst to 1 gallon of ink

Ink may be used immediately after mixing. Pot life of mixed ink is 4 to 8 hours. Do not mix more ink than is needed for a job. Do not under catalyze the ink. Over catalyzation will shorten pot life of ink.

1. Stir or mix the 3820 Flock Adhesive before each use.
2. Make sure that the 3820 Flock Adhesive is kept more on the surface of the fabric when printing in order to help insure a maximum adhesive surface for the flock fibers to bond to.
3. Immediately after printing the 3820 Flock Adhesive, apply the flock fibers to the wet adhesive using the proper electrostatic flocking equipment.
4. The properly printed and cured flock print should be vacuumed to remove excess flock fibers that have not completely attached themselves to the flock adhesive.

IMPORTANT INFORMATION

Wash test flock print to check for proper curing/adhesion before beginning a production run. There will be some small loss of the flock fibers in general because not all of the flock fibers will be completely sealed to the adhesive.

Test dryer temperatures and wash test printed product before and during a production run.

LEGAL DISCLAIMER

Recommendations and statements made are based on International Coatings' research and experience. Since International Coatings does not have any control over the conditions of use or storage of the product sold, International Coatings cannot guarantee the results obtained through use of its products. All products are sold and samples given without any representation of warranty, expressed or implied, of fitness for any particular purpose or otherwise, and upon condition that the buyer shall determine the suitability of the product for its own purpose. This applies also where rights of third parties are involved. It does not release the user from the obligation to test the suitability of the product for the intended purpose and application.

REV. 1700001