



# FLOCK ADHESIVE 1820



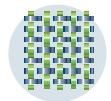
**RECOMMENDED FABRICS**  
100% Cotton  
50/50 or 100% Polyester



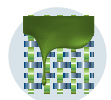
**INK APPLICATION**  
Flock Adhesive 1820 must be mixed with the 900 Catalyst before printing.



**ADDITIVES**  
Not recommended



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



**EMULSION**  
Any direct or indirect solvent resistant emulsion or capillary film.



**SQUEEGEE**  
60-75 Durometer  
Sharp edge.



**CURE TEMPERATURES**  
325°F (163°C) entire ink film.



**CLEAN-UP**  
Any eco-friendly plastisol type screen wash



**PRODUCT PACKAGING**  
Quart, 1 gallon, or 5 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

**AXEON™** Flock Adhesive 1820 is a two-part flock adhesive used to produce high quality flock prints.

Flock Adhesive 1820 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 Flock Adhesive 1820 may be applied to light or dark fabrics.

## SPOT FLASHING

This product 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 dry just 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 will occur in the dryer. Failure to fuse ink properly may cause cracking, poor adhesion and poor wash fastness.

## FLOCK APPLICATION

**AXEON™** Flock Adhesive 1820 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 1820 Flock Adhesive before each use.
2. Make sure that the 1820 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 1820 Flock Adhesive, apply the flock fibers to the wet adhesive using the proper electrostatic flocking equipment.
4. The properly cured flock print should be vacuumed to remove excess flock fibers that have not attached themselves to the flock adhesive.

## IMPORTANT INFORMATION

The optimum time/temperature cycle will vary with the amount of ink deposited, fabric and the type of heat source used. Test dryer temperatures and wash test printed product before and during a production run. Always check for possible dye migration when printing fabrics that contain polyester fibers. Always test print fabric before beginning a production run.

This ink and those in the **AXEON™** product line are not formulated with PVC resins or phthalate plasticizers, nor are they intentionally added.

**Care should be taken to not cross-contaminate the **AXEON™** products with PVC or phthalates containing products.**

**Do not use standard plastisol curable reducers with this or any of the **AXEON™** products.**

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