

FEATURES

- 3820* Direct Print Flock Adhesive is a two-part, Non-Phthalate (NP) flock adhesive that can be used to produce high quality flock prints.
- 3820 provides excellent adhesion to most flock fibers and produces a very soft and flexible flock print when the product is properly printed and cured.

*Lead Compliant (Contains less than 90ppm lead)

Application & Storage Information

RECOMMENDED FABRICS	100% cotton and 50/50 or 100% polyester. Always check for possible dye migration when printing fabrics that contain polyester fibers. Always test print fabric before beginning a production run.
INK 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: 5% by weight = 20 parts ink to 1 part catalyst 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. Do not mix more ink than is needed for a job. Do not under catalyze the ink. Pot life of mixed ink is 4 to 8 hours. Over catalyzation will shorten pot life of ink.
SCREEN MESH AND EMULSION	86-110 t/in or 33-43 t/cm Monofilament Any direct or indirect solvent resistant emulsion or capillary film.
SQUEEGEE	60-70 Durometer: Sharp Edge 60-90-60 or 70-90-70 Triple Durometer: Sharp Edge
CURE TEMPERATURES	325°F (163°C) entire ink film. Since plastisols do not air dry, they must be fused with an appropriate heat source in order to achieve durability. 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.
CLEAN-UP	Any Environmentally friendly plastisol screen wash.
PRODUCT PACKAGING	Available in 1-Gallon and 5 Gallon Pails
STORAGE OF INK CONTAINERS	Keep inks indoor and store in a cool area. Recommend storage at 65° F to 90°F (18°C to 32°C). Avoid storage in direct sunlight or in extreme temperature conditions
PRODUCT MSDS	Refer to material safety data sheet 3820-MSDS8.

IMPORTANT INFORMATION

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. 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.

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3820 NP DIRECT PRINT FLOCK ADHESIVE