

2112 INDUSTRIAL P.O. BOX 124  
HOWELL, MI 48843

**20F0868**  
**CLEAR FLOCK ADHESIVE**

[www.nyatex.com](http://www.nyatex.com)

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**General:**

20F0868 Clear Flock Adhesive is a general use water borne system. This adhesive is formulated to be used for a wide variety of flocking projects including custom repair of automobile seats. This adhesive may also be used for some vinyl substrates.

**Designed Uses:**

All-purpose fiber coating (Flocking).

Physical characteristics include soft, flexible film with good abrasion and water resistance.

For bonding nylon, rayon or polyester flock fibers to Nylon, Polyester, ABS, Vinyl, Soft Foam and metals.

**Technical Specifications:**

*Odor and Appearance:* Characteristic (slight ammonia) & white liquid (dries clear)

*Viscosity:* 1,500 – 3,000 cP

*Density:* 9.0 ± 0.2 lbs/gal.

*Solids:* 65 +/- 2%

*pH:* 5.0 ± 0.5

*Flash Points:* N/A

*Film:* N/A

*Minimum Film Temp.:* N/A

*Borax Tolerance:* N/A

*Base:* VAE emulsion

*FDA Status:* N/A

**APPLICATION:**

**Surface Preparation:**

Substrate must be clean, dry, and free of contaminants; e.g., release agents, dirt, dust, etc.

**Application:**

Spray, roll, brush or dip methods.

20F0868 is formulated for use in both conventional air guns or air assist airless. HVLP recommended.

**Expected Mileage:**

Approximately 150-200 sq.ft. per gal. @ 8-10 mils wet.

**Open Time:**

Over 2 minute at room temperature possible, depending on air circulation, film thickness, temp.

**Suggested film thickness:**

A dry film thickness equal to 10% of the fiber length is recommended.

**Cure-Air Dry:**

30-60 minutes at room temperature to handle.  
24 hours for complete cure.

**Force Dry:**

Recommend 10-30 minutes @ 150-200 deg. F.  
Will cure at lower temps with extended time.

**Clean Up:**

Use warm water and detergent (before cure)

**Storage:**

Store in controlled dry area. Keep well sealed and at ambient temperature. Do not allow to freeze; *not freeze-thaw stable*.

**Recommended Inventory:** 90 days  
(1 yr shelf life)

**Precautions:**

**Health:**

Work in well ventilated areas. Avoid prolonged or repeated contact with skin. Wear safety glasses. More details can be found on accompanying MSDS.

**Environmental:**

Incinerate or bury in landfill in accordance with all local, state, and federal regulations.

**Standard Packaging:**

5 Gallon Plastic Pails, 1 Gallon Cans