

TUBASSIST MELT F

Characterization	Hot-melt adhesive granulate for producing flock transfers in combination with TUBVINYL BOND
Chemical Structure	Thermoplastic synthetic granulate/powder
Supplied Form	White, <u>fine</u> powder
Storage	On proper storage in a dry place, between + 5 °C and + 40 °C in closed original containers the product will hold for at least 12 months.

The above given values are product describing data. Please consult the 'delivery specification' for binding product specifications. Further data about product properties, toxicological, ecological data as well as data relevant to safety can be found in the safety data sheet.

System Survey

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| 1. Flock support | White or coloured TUBASSIST flock papers, alternatively TUBASSIST T flocked films |
| 2. Screen-printable dispersion adhesive | e.g. TUBASSIST BOND, processed preferably as two component system with TUBASSIST FIX 102 W-N |
| 3. Hot-melt adhesive granulate/powder | TUBASSIST MELT F fine hot-melt adhesive powder with high melting temperature for high fastness demands |

Properties

	Fineness	Melting range	Transfer parameters
TUBASSIST MELT F	100 - 200 my	120 - 130 °C	160 - 190 °C, 10 - 30 sec., 2 - 5 bar

Film Properties

In combination with TUBVINYL BOND, TUBASSIST MELT F produces flexible, viscoelastic flock transfers with a high layer stability.

Processing

TUBASSIST MELT F is thermoplastic and facilitates the bonding between the textile substrate and the flock + flock adhesive layer by means of contact heat and pressure (ironing press).

This hot-melt type is preferably used in combination with TUBVINYL BOND as flock adhesive; moreover, TUBASSIST MELT F can be applied, after corresponding preliminary trials, as hot-melt layer on aqueous printing transfer systems.

Stability

The flock transfers properly produced with TUBASSIST MELT F in combination with TUBVINYL BOND/TUBASSIST FIX 102 W-N show a very good adhesion to the textile substrate. Generally a good fastness to dry cleaning as well as a washfastness up to 95 °C are achieved.

Application Procedure

Application Fields

TUBASSIST MELT F serves as hot-melt adhesive component for producing flock transfer motifs in combination with TUBVINYL BOND. Furthermore, TUBASSIST MELT F can be used as hot-melt powder in combination with water-based transfer systems after preliminary trials.

Recommendation for Use / Processing

Condition of Substrate

The ready-made flock transfers can be applied to a multitude of nowadays common wovens and stable knitwear qualities. With very stretchable or elastic fabric qualities we recommend flock transfers on the basis of the systems TUBVINYL ELASTOBOND/TUBASSIST ELASTOMELT.

Processing Recommendation

Application of hot-melt powder Normally the hot-melt powder is sprinkled onto the still wet adhesive layer immediately after the adhesive printing, or the just printed sheets are drawn through a tub with hot-melt powder

**Drying the adhesive/
hot-melt layer** Can be effected either in the drying chamber or in the continuous drier at temperatures of up to 80 °C; the drying at room temperature for 12 – 24 hours is possible as well.

**Cleaning-off excess hot-melt
adhesive powder** Can be removed by being brushed off with a soft brush by hand or with special cleaning units, possibly with the help of a corresponding vacuum unit.

**Fixation of the adhesive system
+ sintering of the hot-melt layer** For achieving best possible fastness properties a fixation of the adhesive layer by a heat treatment is necessary. By doing so the hot-melt layer is melted a little and thus stabilized for further processing. With multicoloured flock transfers with this process the final dyestuff fixation is effected.

Water steam arising during the fixing process (polycondensation) must be drawn off continuously; too much humidity accumulating at the fixing zone can cause an incomplete fixation of the adhesive.

Transfer Generally by means of customary ironing presses with low up to medium pressure.

Standard values 160 - 190 °C, 30 - 10 sec., 2 - 5 bar

depending on working conditions and textile quality.

Recommendation for Use

Before going into production we recommend making it a rule first to test the suitability of the hot-melt adhesive powder in combination with the flock adhesive and the flock papers used regarding wettability, adhesion respectively layer stability, fastness properties and process parameters and to control everything as well during the production run. Besides we recommend to test in any case the ready transfers as to their suitability for the substrate to be applied and the existing transfer conditions.

We reserve the right to modify the product and technical leaflet.

Our department for applied technique is always at your service for further information and advice.

Our technical advice and recommendations given verbally, in writing or by trials are believed to be correct. They are neither binding with regard to possible rights of third parties nor do they exempt you from your task of examining the suitability of our products for the intended use. We cannot accept any responsibility for application and processing methods which are beyond our control.

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