

## PRODUCT DATA SHEET

# FLOCKTAPE™ FOR EPDM AND TPE EXTRUSIONS

## 50 Black PET Flock



### GENERAL DESCRIPTION

This member of **DORRIE'S** flock product line is manufactured using high-grade, 3 denier black polyester flock on 0.005" (.127mm) polyolefin film. Flock fiber length is typically .025" ± .005" (.635mm ± .127mm).

### APPLICATIONS

**DORRIE** has developed a line of rubber-adherable flock tape products that has found use in both decorative and functional automotive applications. This product is designed to adhere to a wide variety of materials, including EPDM rubber, TPOs, TPEs and polypropylene.

Current OEM certifications include: GM2724M, Chrysler's MSDC-229 & MSAK87 and Ford's WSB-M8H13-A.

### PROCESSING PARAMETERS

The preferred method of bonding to EPDM takes place at the outlet of the curing oven. Temperatures should be maintained at 350° - 380° F (177° - 193° C). Pressure provided by a laminating roller should be sufficient to provide uniform intimate contact between the mating surfaces.

Bonding to thermoplastics varies somewhat by profile thickness. Profiles of 2mm and thicker lend themselves to *post-die* lamination techniques. Aided by the retained heat (350° -380° F, 177° - 193° C) of the extruded thermoplastic and the pressure of laminating rollers, the two surfaces are bonded together.

Thinner profiles will not sustain enough heat to affect a sufficient bond and require a *through-die* technique. This method utilizes the heat and pressure generated at the *die lip* on the inboard side of the die to bond the two surfaces together.

### PROCESSING PARAMETERS (cont.)

Do not exceed 10% stretch when processing **DORRIE** FlockTape™.

For more in-depth applications advice, we recommend that you talk to one of our applications experts.

### STORAGE CONDITIONS

**DORRIE INTERNATIONAL** recommends that storage conditions be maintained at 72° F (22° C) with 50% relative humidity. The processing performance of these types of flocking will not be adversely affected when stored under these conditions for up to six (6) months. However, as the ambient conditions vary, or as the length of storage time increases above this limit, the material may not process as well.

### PACKAGING/SHIPPING FACTS

Standard Package: 1 spool per box  
Average Weight per Box: 9.1Kg (20 lb.)  
Box Dimensions: 35.6cm x 33cm x 33 cm  
(14" x 13" x 13")  
Slit Widths Available: 6mm - 38.1mm  
Spool Capacities (Typical):  
Width: 9.5mm / Length: 2520m  
Width: 12.7mm / Length: 1850m  
Width: 19mm / Length: 1174m

*The information given herein is based on data believed to be reliable, but **DORRIE INTERNATIONAL** makes no warranties, express or implied, as to its accuracy and assumes no liability arising out of its use by others. This publication is not to be taken as license to operate under, or recommendation to infringe upon, any patents.*

**DORRIE  
INTERNATIONAL**

9 Wilton Ave., Norwalk, CT 06851 · Tel: (203) 846-2087 · Fax: (203) 847-2831

[WWW.DORRIE.COM](http://WWW.DORRIE.COM) · [info@dorrie.com](mailto:info@dorrie.com)

Rev. Date: 03/06

# FLOCKTAPE™ FOR EPDM AND TPE EXTRUSIONS

## 50 Black PET Flock



<u>PROPERTIES</u>	<u>TEST METHOD</u>	<u>MINIMUM REQUIREMENT</u>	<u>MEASURED PERFORMANCE</u>
Color/Appearance	GM9220P	Engr. Approval vs. Std.	Engineering Approval
Construction	Conformance to drawings/specs	Conformance to drawings/specs	Conformance
Colorfastness to light	GM9125P	Delta E < 3	Delta E < 3
Flock Density (Fibers/cm <sup>2</sup> )	Chrysler CLP 463-AB-35-01	1.15 x 10 <sup>4</sup> /cm <sup>2</sup> min.	3.34 x 10 <sup>4</sup> /cm <sup>2</sup>
Weatherometer	GM9125P <sup>o</sup>	No deterioration or color change	No deterioration or color change
Color Change Due To Heat/Humidity	GM9131P	No change in color	No change in color
Water Spotting	AATCC TM4	No more than slight change to color or finish	No more than slight change to color or finish
Wear Resistance	ASTM D3884 (Taber)	No obvious wear	No obvious wear
Cleanability	GM9126P <sup>1</sup>	Satisfactory Rating	Satisfactory
Odor Resistance	SAE J1351	Odor Rating 3 or lower	Rating = 3
Oven Aging	GM9131P	No brittleness, adhesion loss or color change	Pass
Mar/Scuff Resistance	GM9150P <sup>2</sup>	No apparent marking after: Orig., Solvent, Moisture	No apparent marking after: Orig., Solvent, Moisture
Dust Out	N/A	No appreciable dust out	No appreciable dust out
Density/Upright Fibers	Visual	Equiv. to approved standard	Equiv. to approved standard
Ozone Exposure	72h/38°C/50pphm	No deterioration/loss of adhesion between fibers and rubber	No deterioration/loss of adhesion between fibers and rubber
Flammability	GM9070P	Report Burn Rate	Result Code "B" Burn Rate: 47.9 mm/min.
Adhesion Requirement <ul style="list-style-type: none"><li>• Mar Test</li><li>• Knife Peel</li></ul>	GM9210P <sup>3</sup>	After Orig., Solvent, Moisture No substrate/adhesive visible 3 N Minimum	No substrate/adhesive visible Destructive Bond

### NOTES:

<sup>o</sup> Test run using SAE J1960

<sup>1</sup> Test run using Permatex P/N 135EA (vs. 9984175 & 9985684 with 9981062 [VM+P Naptha])

<sup>2</sup> Specified Mar tester was not available. Test was run manually with a 500g weight.

<sup>3</sup> Parts related testing was done on Vyram® and Santoprene® based parts.

**DORRIE**  
**INTERNATIONAL**

9 Wilton Ave., Norwalk, CT 06851 · Tel: (203) 846-2087 · Fax: (203) 847-2831

[WWW.DORRIE.COM](http://WWW.DORRIE.COM) · [info@dorrie.com](mailto:info@dorrie.com)