

## PRODUCT DATA SHEET

# PET/PVC FLOCKTAPE™

## 80 Black PET Flock



### GENERAL DESCRIPTION

This member of **DORRIE'S** flock product line is manufactured using high-grade black polyester flock on 0.008" (.203mm) black polyvinyl chloride film. It is also available in Polyamide flock, dependent on volume.

### APPLICATIONS

The product has found extensive use in automotive applications. Our development efforts have designed a product that will adhere to numerous substrates, including PVC and its elastomers (e.g. Alcryn™ and Sunprene™).

This material is certified to meet GM Engineering Materials and Process Specification No. GM2724M and Chrysler's MS - DC 229 and MSAK87.

### PROCESSING PARAMETERS

Laminating techniques common to the decorative films extrusion industry are recommended. These may vary by the profile thickness.

Thick profiles (2mm and thicker) lend themselves to *post-die* lamination techniques. Aided by the retained heat of the extruded PVC (325° - 350° F, 163° - 177° C) 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.

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

### PROCESSING PARAMETERS (cont.)

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.

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**SLIT WIDTHS AVAILABLE:** 5 - 38.1mm  
**SPOOL CAPACITY:** 3000' at 12mm (example)  
**AVAILABILITY:** In stock  
**PRICING:** Upon request

**DORRIE  
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<u>PROPERTIES</u>	<u>TEST METHOD</u>	<u>MINIMUM REQUIREMENT</u>	<u>MEASURED PERFORMANCE</u>
Fiber Length	Per Specification		0.020" ± .005" (.508mm ± .127mm)
PET Fiber	Per Specification		3 Denier
PVC Thickness	Direct Measurement via Gauge	0.008" ± 10% (.203mm)	.008" ± .0008" (.203mm ± .0203mm)
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.	3.63 x 10 <sup>4</sup> /cm <sup>2</sup>
Florida Weathering	ASTM G7	Delta E < 3.0	Delta E < 3.0 No degradation or color loss
Xenon Arc Weathering	GM2724M/ SAE J1960 1240.8 kJ/m <sup>2</sup>	No degradation or color loss	No degradation or color loss
Flock Adhesion:	CLP 463-AB-37-01		
• <i>Original</i>		5.7 lb./in. min. (10 N/cm)	8.8 lb./in. (15.5 N/cm)
• <i>Oven Aged</i>		5.9 lb./in. min. (10 N/cm)	6.4 lb./in. (11.2 N/cm)
• <i>H<sub>2</sub>O Immers.</i>		4.0 lb./in. min. (7 N/cm)	7.6 lb./in. (13.3 N/cm)
• <i>8h @ 125°C</i>		5.7 lb./in. min. (10 N/cm)	6.4 lb./in. (11.2 N/cm)
• <i>2XHumid</i>		4.0 lb./in. min. (7 N/cm)	8.0 lb./in. (14 N/cm)
Wear Resistance:	CLP 463-AB-35-01		
• <i>Original</i>		No base exposed	No base exposed
• <i>Oven Aged</i>		No base exposed	No base exposed
• <i>H<sub>2</sub>O Immers.</i>		No base exposed	No base exposed
Wear Resistance (Taber)	ASTM D3884	No obvious wear	No obvious wear
Oven Aging	GM2724M	No brittleness, adhesion loss or color change	Pass
Density/Upright Fibers	GM2724M	Uniform, upright	Pass
Cycle Test/ Color Change	GM2724M	No change in color	No change in color
Water Spotting	AATCC TM4	No more than slight color change	No more than slight color change
Dust Out	GM2724M	No appreciable dust out	No appreciable dust out
PSA Adhesion	PSTC-1	32 oz./lin. in. (3.5 N/cm)	48(+) oz./lin. in (5.3 N/cm)
Flammability	FMVSS 302	< 100mm/min. Burn Rate	Pass

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