

TECHNICAL INFORMATION FOR BACK COATING KANECARON.

1. Back Coating

There are 2 typical systems; Kiss-roller and foam coating. We recommend the Kiss roller system.

(a) Latex type

Polyacrylate ester is the most recommendable types of Latex for the back coating. The concentration of Latex had better be rather low, which brings even coating and good bonding fastness of pile to back yarn. Ordinary 12-15 weight % solution of Polyacrylate. Increased viscosity Latex has a bad influence to penetrate Latex to the back side of fabric. Temperature of Latex should be kept around 20-30°C.

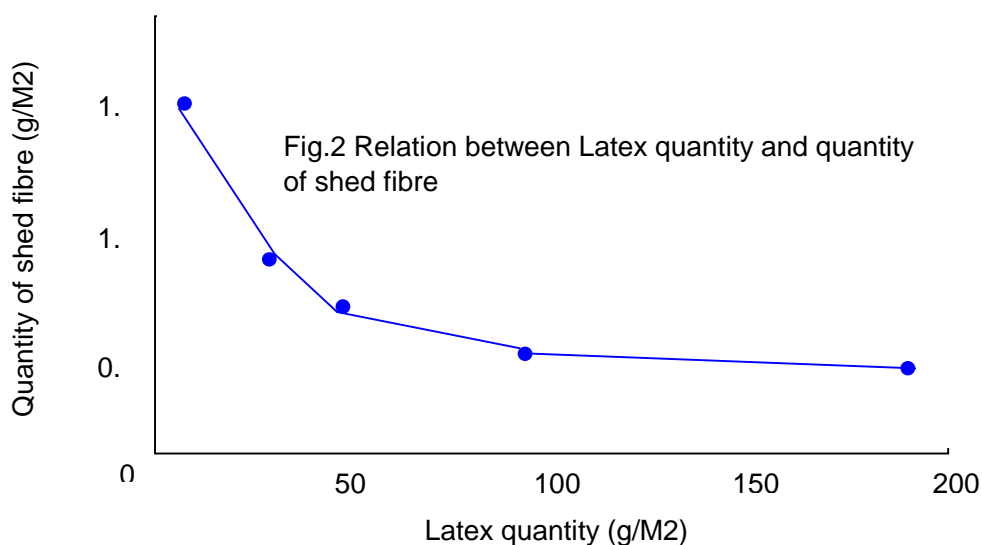
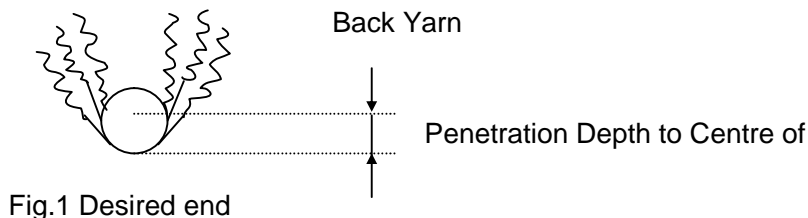
(b) Latex quantity

It is necessary to be coated is 40-60 g/m² after dried up. Optimum quantity of Latex used depends on the end use of the fabric, e.g. Outer, Liner, Toy. However, with more Latex, the touch will be stiffer or harsher, drape will be spoilt and costs increased. Therefore, we recommend the usage shown in the following table:

Outer : Use 40-60 g/M2 Toy : Use 40-80 g/M2 Rug : Use 100 g/M2

(c) Penetration of Latex

By increasing penetration of Latex, shedding can also be reduced.



How to increase penetration:

- 1) Add penetration agent to Latex.
- 2) At the blending stage use a hydrophilic softener (attracted to water).
- 3) Adjust the back coating machine:

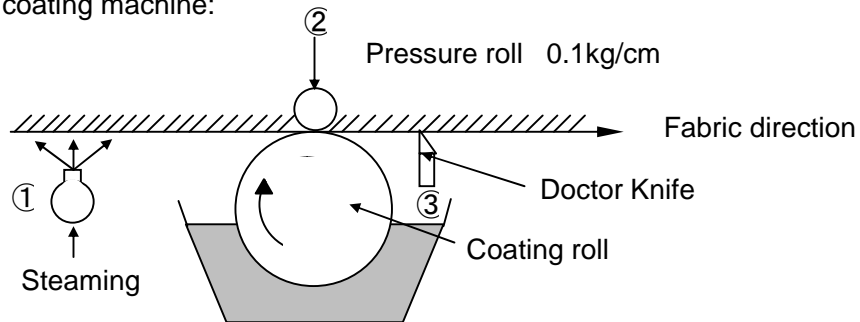
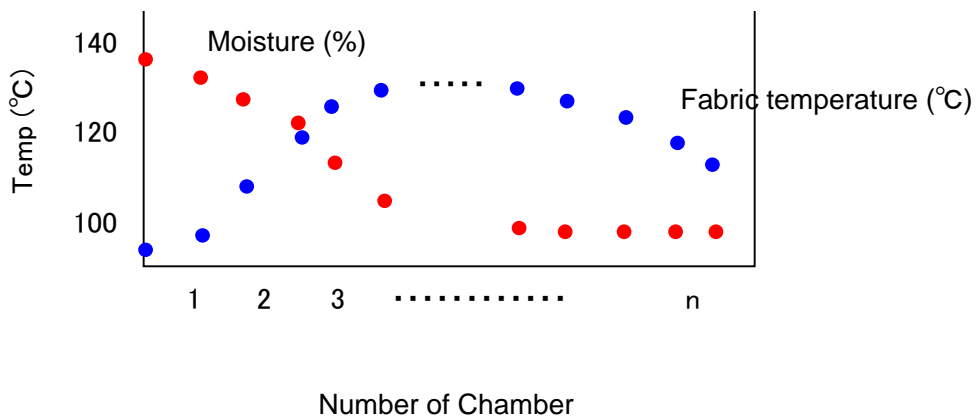
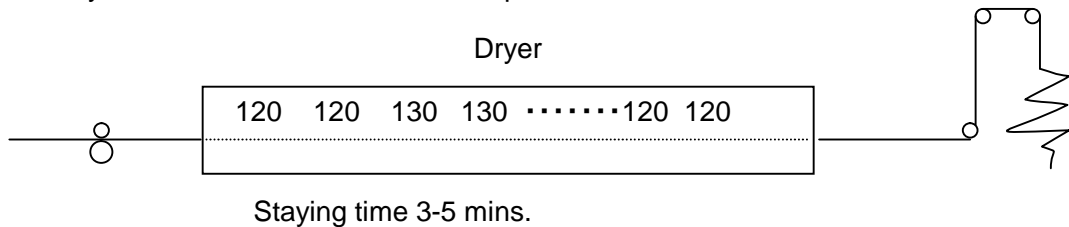


Fig.3 Position of Steaming, Pressure roll and doctor knife

- ① Immediately prior to coating, steam the back of fabric, i.e. apply moisture in order to help penetration of the latex.
- ② Press using pressure roll is also effective increasing quantity and penetration of Latex will be coated. Usually 0.1kg per cm is kept.
- ③ After coating, improve the penetration of the Latex by using a doctor knife.

(d) Drying

Temperature of Dryer should be held between 130 and 140 °C. At that time, temperature of pile surface will be 120-130°C. If it is higher than 150°C, Kanecaron fibre wick be seriously damaged degenerated. Staying time in dryer should be 3-5 mins at the temperature of 120-130°C.



2. Remove the unfixed fibre (Brushing)

We recommend to setting 2 or 3 sets Brushing machine between high temperature polishing and medium temperature polishing. It is effective to remove loose fibres.

Clearance between brushing wire and bed is depends on the pile length of fabric.

Brushing machine has 2 brushing rolls. Usually, second brushing roll should be set more tightly than first burushing roll. The direction of the rotaition of each brushing roll should be set in the opposite dir

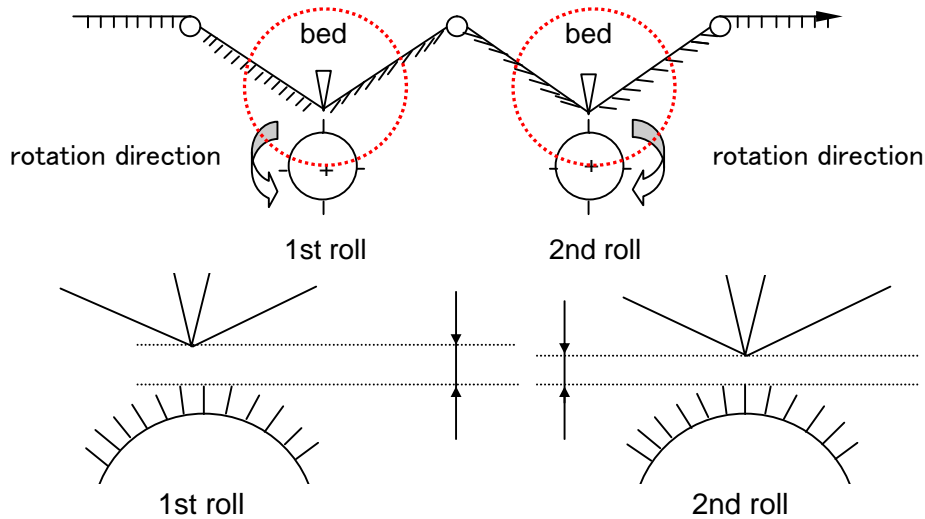


Fig.5 Position of Brushing

Table-1. example for setting of Clearance

Item	Pile Height (mm)	Clearance(mm)	
		1st roll	2nd roll
Beaver	10-20 mm	4 mm	3 mm
Mink	20-25 mm	5 mm	4 mm
Fox	No cut	8 mm	7 mm

* narrow the clearance gradually throughout the process.

Remark

Type of Latex used in our labo as follows;

	ionic character	active conc.(%)	main component
Marposol M-1K *1	anion	40 %	Polyacrylate ester
TEB-3K *2	anion	40 %	Polyacrylate ester

note; *1 Soft type *2 Hard type

We make up a 12% Latex solution with both Marposol M-1K and TEB-3K.

1) 40% Concentrate solution of both Latex dilute by 12% with water.

2) Blend both Latex in accordance with below ratio.

Garment ; 7 parts 12% Marposol M-1K solution with 3 parts 12% TEB-3K solution.

Toy ; 6 parts

4 parts.

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