



swift[®] tak 4337

Application

Two-component dispersion adhesive for the lamination of leather with polyurethane and PVC-foils, as well as PVC-foam foils and ABS-foils on molded parts from ABS, PVC, particle board, derived timber products, etc. by deep drawing.

Especially suitable for the adhesion of glossy foils in heat-activated procedure (3-D-process).

Properties

- low activation temperature

Technical Data

Base:	Polyurethane dispersion
Colour:	White
Viscosity (Brookfield):	Ca. 1.800 mPas*
Density:	Ca. 1,06 g/cm ³
Thinner/Cleaner:	Water
Hardener:	swift [®] hardener 4547 or swift [®] hardener 9545 Dark blue
Mixing ratio:	100 parts by weight of swift [®] tak 4337 5 - 10 parts by weight of swift [®] hardener
Pot life:	Ca. 8 hours
Application:	Spray gun
Drying time:	Ca. 60 minutes at normal temperature; depending on material and amount
Sealing temperature:	50 - 60°C, depending on material
Heat resistance:	80 - 100° C, depending on material and Hardener amount (Helmitin-test; bonding PVC-foil/beech wood)
Setting time:	Ca. 72 hours
Storage life:	Ca. 6 months
Conditions for storage and transport:	Well closed at temperatures between 10°C and 25°C
Sensitive to cold:	Yes; after influence of temperatures below 10°C, the adhesive can not longer be worked up
Labelling acc. to regulations for dangerous goods:	None See safety data sheet

* The viscosity indicated above is based on a temperature of 20°C prevailing at the time of production. Minor deviations may occur during storage.



Instruction for use

Mix adhesive and hardener carefully. Mix the hardener carefully but slowly into the adhesive.

Apply the mixture with spray gun on the carrier material.

After drying time approx. 60 minutes (can be accelerated by heat), the adhesion can be done with activation by deep drawing.
Sealing time depends on thermal conductivity of the material. It is approx. 10 - 20 seconds. Determine the sealing- and press time by preliminary tests.

To avoid faulty bonding, the temperature of room and adhesive should not be below 18°C.

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