Swift®tak 4337 is a 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. Specially suitable for the adhesion of glossy foils in heat-activated procedure (3-D-process).

**Raw Materials Base:**
- **Polyurethane dispersion**
- **Colour:** white
- **Viscosity (#2/20rpm/30°C):** approx. 1800 mPas*
- **Specific Gravity:** Density: approx. 1.06 g/cm3
- **Hardener:** swift®hardener 4547 or swift®hardener 9545 Dark blue
- **Mixing ratio:** 100 parts by weight swift®tak 4337
  - 5 - 10 parts by weight swift®hardener 4547
- **Pot life:** approx. 8 hours
- **Application:** spray gun
- **Drying time:** 60 minutes at normal temperature; depending on material and amount
- **Activation temperature:** 50 - 60°C, depending on material
- **Heat resistance:** 80 - 100°C, depending on material and amount of hardener
- **Setting time:** approx. 72 hours

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TECHNICAL DATA SHEET

Storage: Approx 6 months. Store out of direct sunlight between 10 - 25 °C.

Sensitivity to cold: Adhesive can no longer be stored at temperatures below 10°C. Rotate the stock every month.

Instructions for Use: Adhesive can no longer be stored at temperatures below 10°C. Rotate the stock every month.

Mix adhesive and hardener carefully.

Applicate the mixture with spray gun on the carrier material.

After drying time approx. 60 minutes (can be accelerated by warmnes), the adhesion can be done with activation by deep drawing.

Sealing time depends on thermal conductivity of the material. It is approx. 10 - 20 minutes.

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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