



TECHNICAL DATA SHEET

Version 1
04/10/2012

Swift®tak 4337

Swift®tak 4337 is a two-component dispersion adhesive for the lamination of leather with polyurethane and PVCfoils,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 4547or 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

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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

Our Focus is Clear. Perfecting Adhesives.

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Australia
Tel: +61 1800 423 855
customer.service@hbfuller.com
China & Hong Kong
Tel: +86 20 82068291
cs.china@hbfuller.com
Indonesia
Tel: +62-21-5307232/33

Korea
Tel: +82 2 786 8296
cskorea@hbfuller.com
Malaysia
Tel: +603 3345 5200
New Zealand
Tel: +64 800 555 072
customer.service@hbfuller.com

Philippines
Tel: +63 2 5194073
Taiwan
Tel: +886 2 26033385
Thailand
Tel: +66 2 3757442
Vietnam
Tel: +84 8 2225588





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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

Mix adhesive and hardener carefully.

Mix the hardener forcefull but slowly into the adhesive.

Applicate the mixture with spray gun on the carrier material.

After drying time approx. 60 minutes (can bei 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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Australia
Tel: +61 1800 423 855
customer.service@hbfuller.com
China & Hong Kong
Tel: +86 20 82068291
cs.china@hbfuller.com
Indonesia
Tel: +62-21-5307232/33

Korea
Tel: +82 2 786 8296
cskorea@hbfuller.com
Malaysia
Tel: +603 3345 5200
New Zealand
Tel: +64 800 555 072
customer.service@hbfuller.com

Philippines
Tel: +63 2 5194073
Taiwan
Tel: +886 2 26033385
Thailand
Tel: +66 2 3757442
Vietnam
Tel: +84 8 22225588

