

Swift[®]lock 4780

Type of Product Polyurethane based reactive hot melt.

Product Characteristics

- short open time
- fast setting
- high initial strength
- after curing a high cold, heat and humidity resistance will be achieved
- the cross-linked product has high mechanical properties

Typical Applications Suitable for coating of PVC window profiles with PVC foils.

Suitable substrates PVC, aluminium, wood materials and others with usual profiles with different decorative films, veneers and other films on profile lamination machines.

Typical Properties

Property	Value
Base	polyurethane-prepolymer
Colour	milky-white
Consistency	solid
Softening point (R&B)	approx. 75°C
Density	approx. 1,10 g/cm ³
Viscosity (Brookfield Thermosel – Sp29, at 120°C)	approx. 38 000 mPa.s
Shelf life	9 months

Application Instructions

Application temperature: 120°C – 140°C

Open time: approx. 20 – 40 seconds, depending on temperature, amount and substrate.

Good results will be achieved if the following conditions are observed:

- Room and material temperature: 18°C – 20°C
- Moisture content of wood: 8 – 10%
- Relative humidity: 40 – 60%

Because of the low application temperature, the thermal stress of heat sensitive materials is low. The physical and chemical curing is affected by the specific temperature of the PVC-profiles.

The surfaces of the substrates must be clean, dry and free from oil and grease.

The temperature of the substrates must not be below +18°C during coating as lower temperatures deteriorate adhesion of glue and shorten open time.

PVC and Alu-profiles should be heated to about 45°C – 55°C.

After physical curing bonded parts are quickly ready for further processing.

PVC profiles must be pre-treated with primer.

The adhesive can be applied by nozzle-, roller- and spray equipment.

As a matter of principle, care has to be taken that melting and application equipment is protected against incoming moisture. This can be reached by applying dry nitrogen or dry air.

Final strength is achieved after 1 – 3 days depending on availability of moisture and temperature.

Please care for exhaust of vapours occurring during application.

Due to the variety and diversity of the market materials, it is necessary to do own tests for the use of this product.

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Cleaning Instructions	Please contact your local Sales Office for available cleaning solutions.
Typical Packaging	Please contact your local Sales Office for available packaging options.
Storage Conditions	In original sealed packaging, clean and dry conditions above -25°C and below +35°C. Sensitive to humidity.
Disposal Advice	Please refer to the MSDS for disposal instructions.
Safety Advice	Please refer to the MSDS for safety advice.

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