

Technical data sheet



Product: 4701

Manufacturer: H.B. FULLER

Product group: KLEBSTOFF

Article group: 1-K PU-KLEBSTOFF

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SWIFT®BOND 4701

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Swift[®] bond 4701

Type of Adhesive

Solvent-free two-component polyurethane adhesive.

Product Benefits

- solvent free
- one side application
- with Härter 414, at room temperature, the adhesive forms a firm, but still slightly flexible film
- after curing, the adhesive is highly resistant against weather conditions as well as against many chemicals, such as gasoline, oils, greases, diluted acids and alkalis
- IMO-MED certified

Typical Applications

Bonding of several substrates in different industrial applications.

Suitable substrates

Polyurethane-, PVC-, phenolic-resin- and polystyrene foams, polyester, thermo-setting plastics, laminated sheets, wood, wood materials, ceramics, concrete, fibrous cement, masonry, aluminium, steel and others.

Typical Properties

Property	Value	
	Swift [®] bond 4701	Härter 414
Base	polyurethane	isocyanate
Colour	beige	brown
Density at 20°C	approx. 1,50 g/cm ³	approx. 1,22 g/cm ³
Viscosity (Brookfield, at 20°C)	approx. 30 000 mPa.s	approx. 200 mPa.s
Mixing Ratio	100 : 20 in weight	
Density of mixture at 20°C	approx. 1,45 g/cm ³	
Mixing viscosity	approx. 7 000 mPa.s	
Hardening time	approx. 5 to 8 hours at 20°C – 22°C approx. 40 to 45 minutes at 60°C approx. 15 to 20 minutes at 100°C	
Shelf life	12 months	



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Application Instructions

The bonding surfaces must be clean and dry. In many cases, mechanical roughening is recommended. Rigid PVC and ABS should be pre-treated with a polyurethane primer, such as Swift® prime 2200. Rubber materials need to be roughened and/or pre-treated with halogenating solution Helmitin® T/FL.

Application: by trowel

Consumption: 200 – 300 g/m², depending on surface

Pot life: approx. 40 minutes

Wet life: approx. 70 minutes

Instructions for use:

Mix the adhesive thoroughly with the hardener. For larger amount we suggest to use a mechanic mixer.

Apply the mixture on one surface to by a notched trowel. The amount depends on the surfaces to bond. Joining can be done during wet life. The parts need to be press while curing take place, even if high pressure is not required.

Higher temperature will reduce the curing time. In the case of thick and well-insulating materials, it is necessary to increase the pressing time to let the heat reach to the adhesive film. Heat curing above +60°C is not recommended for bonding of materials with a great difference in the coefficient of thermal expansion.

This adhesive cures also at low temperatures (not below +5°C). The curing time, however, will be much longer and the adhesion to metal will be reduced.

The curing process can be accelerated not only with heat, but also by adding a catalysts. Appropriate information is available upon request.

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 protected from sun, dust, moisture and high temperatures. Clean and dry conditions above +5°C and below +35°C.

Disposal Advice

Please refer to the MSDS for disposal instructions.

Safety Advice

Please refer to the MSDS for safety advice.

Our Focus is Clear. Perfecting Adhesives.

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