

# Technical data sheet



Product: 2607-3

Manufacturer: H.B. FULLER

Product group: KLEBSTOFF

Article group: 2-K KLEBSTOFF

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SWIFT COL 2607-3 ®

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### Swift<sup>®</sup> col 2607-3

**Type of Adhesive** Solvent based 2-component adhesive based on Polyurethane.

- Product Characteristics**
- application by spraying
  - low activating temperature
  - process security
  - fully meets the high standards of the automotive industry
  - slightly yellowing under UV radiation

**Typical Applications** This product is suitable for stress as well as for flat surface bonding and edge bonding of foils, carpets, textiles, foams, genuine and artificial leather etc. to fibrous materials, GRP, wood based composites, SMC, etc. for bodywork mouldings, e.g. headlining, door and side panels, pillar covering, rear shelves, etc.

**Suitable substrates** Foils, carpets, textiles, foams, genuine and artificial leather, fibrous materials, GRP, wood based composites, SMC, etc.

#### Typical Properties

Property	Value	
	Component A Swift <sup>®</sup> col 2607-3	Component B Swift <sup>®</sup> hardener 9151 / 9619 / 2541
Base	polyurethane	polyisocyanate
Shelf life	6 months	



### Application Instructions

Laminating technique: Vacuum deep drawing, stamp covering and manual lamination.

The product can be applied by spray gun or by brushing.

#### Surface preparation:

Surfaces should be clean and free from dust, fatty substances and release agent. If necessary plastic carriers have to be pre-treated with primers, sanding, sandblasting, etc.

**Attention:** the surface tension of the substrates to be bonded must be higher than 38 mN/m.

#### Mixing ratio:

- 100 parts by weight of Component A with 6 parts by weight of Component B 9151 or 9619
- 100 parts by weight of Component A with 3 parts by weight of Component B 2541
- Shake hardener well before adding to the adhesive.  
Component B should be added during mixing homogeneously and without foaming into Component A using a mechanical mixing equipment.

Working temperature: between 15°C and 25°C.

- The product could be applied out of a pressure feeding container using a spray gun or by brushing.

Processing time/pot life: between 15°C and 25°C. To be processed at 20°C material temperature within 8 hours upon adding the hardener.

**Attention:** higher temperatures decrease the processing time, i.e. 4 hours at 30°C.

#### Drying conditions:

At room temperature or in a ventilated oven at a maximum temperature of 50°C. The drying time depends on the absorbency of the substrate, the coating weight, the humidity and the ambient temperature.

#### Bonding:

To achieve the best bonding you must consider the cycle time, the temperature of the carrier and of the laminate, the activation temperature and the lamination pressure.

This 2-component adhesive attains its final adhesive properties, e.g. heat resistance, after 3 days (72 hours) after bonding.



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## TECHNICAL DATA SHEET

**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 10°C and below 30°C. Keep away from freezing.

**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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