



Swift[®] bond 4701

Type of Adhesive Solvent-free two-component adhesive based on polyurethane.

- Product Benefits**
- solvent free
 - one side application
 - with Swift[®] hardener 9530 the adhesive forms at room temperature 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.

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	Swift [®] hardener 9530
Base	polyurethane	isocyanate
Colour	beige	brown
Density at 20°C	approx. 1,50 g/cm ³	approx. 1,22 g/cm ³
Density of mixture at 20°C	approx. 1,45 g/cm ³	
Viscosity (Brookfield) at 20°C	approx. 30.000 mPa*s	approx. 180 mPa*s
Mixing viscosity	approx. 7 000 mPa*s	
Hardening time	approx. 5 to 8 hours at 20 °C – 22 °C approx. 40 to 45 min. at 60 °C approx. 15 to 20 min. at 100 °C	
Shelf life	12 months	



Application Instructions

The pieces to be bonded must be clean and dry. In many cases, mechanical roughening is recommended.

Rigid PVC and ABS should be primed with a polyurethane primer, such as Swift[®] prime 2200. Rubber materials have to be roughened and / or pre-treated with halogenation solution Helmitin[®] T/FL.

- application method: notched trowel
- consumption: 200 – 400 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 amounts mixing by using a hand drill is recommended.

The mixture is applied to one surface to be bonded by means of a notched trowel. The amount depends on the surfaces to be bonded. Bonding can be done during wet life. The connected parts have to be fixed during the setting period. Particular pressure, however, is not required.

Hardening times at increased temperatures obtain to the adhesive film. In the case of thick and well-insulating materials, add the time that is required for the heat to penetrate to the adhesive joint. Heat curing above 60 °C is not recommended for bonding of materials with a great difference in the coefficient of thermal expansion.

This adhesive hardens also at low temperatures. The hardening time, however, will increase considerably, adhesion to metal will be reduced.

The hardening process can be accelerated not only by means of heat, but also by adding 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.



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TECHNICAL DATA SHEET

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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