



Swift[®]tak 4002

Type of Adhesive

PVAc adhesive.

Product Benefits

- shows fast setting
- water resistant
- classification according to EN 204, load group D3 as a one-component system (ift, Rosenheim)

Typical Applications

This product can be used for a variety of applications including:

- surface gluing
- high-frequency bonding
- carcass- and assembly gluing
- bonding joints in boards and block gluing

Suitable substrates

Wood and wood based material.

Typical Properties

Property	Value
Colour	white
pH	3.5
Minimum film formation temperature	5°C
Viscosity	Brookfield RVT, Spindle 5, 20 rpm, at 20°C 11 500 mPa.s
Shelf life	9 months



Application Instructions

The material to be joined must be clean and grease free.

The open and drying times strongly depend on the working conditions, namely the wood temperature and humidity, quality of the wood, absorbency of the materials, amounts applied, etc.

The values below should be considered as an indication.

Desirable working conditions:

- Room, material and adhesive temperatures: 18 – 20°C
- Wood humidity: 8 – 10%
- Relative humidity: 40 – 60%

Coat weight of the adhesive:

- Assembly jobs: 120 – 160 g/m²
- Surface bonding: 40 – 100 g/m²

Open time (150 g/m²): 9 – 10 min

Working pressure (depending on type of bonding). 0,1 – 0,8 N/mm²

Minimum pressing time:

- Veneering at +70°C: approx. 45 sec
- High frequency presses: from 15 sec
- Surface gluing of HPL/CPL at +70°C: approx. 45 sec
- Assembly gluings: 8 – 12 min
- Boards- and block gluing: 10 – 15 min

Wood discoloration:

Because of the varied nature of wood components, e.g., depending on the area of growth and the type of pre-treatment, unpredictable discoloration may in some cases appear on different types of wood, such as beech, cherry and others.

The product can thicken a little after pro-longed storage. The adhesive should then be thoroughly mixed and is then ready for use again.



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TECHNICAL DATA SHEET

Cleaning Instructions	Clean machines and tools with water before the adhesive dries.
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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