

## Swift<sup>®</sup> tak 4014

**Type of Product** PVAc dispersion-based adhesive.

**Product Benefits**

- produces very resistant and elastic bonds
- medium viscosity appropriate for assembly
- meets the requirement of D2 according to EN 204

**Typical Applications** For furniture assembly.

**Suitable substrates** Wood, chipboard, ect.

### Typical Properties

Property	Value
Base	PVAc dispersion
Colour	white
pH	approx. 6.5
TMF	approx. +6°C
Viscosity(Brookfield RV, at 20°C)	approx. 12 000 mPa.s
Shelf life	6 months

**Application Instructions**

The parts should fit exactly and be free from dust and grease. Apply in a thin, uniform film to one side, by means of a glue spreading machine as a glue roller, toothed spatula, etc. Join the parts within the open time and press until a sufficient initial strength is obtained. Apply as much pressure as necessary to ensure overall close contact between the surfaces.

## Working conditions:

- room, material and glue temperature: 18 – 20°C
- wood moisture content: 8 – 10%
- air relative humidity: 60 – 70%

## Glue consumption:

- assembling works: 160 – 180 g/m<sup>2</sup>
- laminating works in short cycle press: 80 – 100 g/m<sup>2</sup>

## Open time:

- for 100 g/m<sup>2</sup>: approx. 1.5 – 2 minutes
- for 180 g/m<sup>2</sup>: approx. 6 minutes

Working pressure: 2 – 5 kg/cm<sup>2</sup>

## Minimum pressing times:

- assembly gluings at room temperature: from 3 minutes
- one side coating with pre-heating: from 45 seconds
- laminating at 70°C: from 30 seconds

The above values should be considered as indicative. Preliminary tests should be done to determine the optimal working conditions. The open and setting times are dependent on workshop conditions such as temperature, air humidity, moisture content of wood, glue coating weight, porosity of the materials, etc.

This product does not cause any discoloration of the wood. Iron, however, can react with the tannin in the wood, especially oak, and produce a dark stain.

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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 protected from sun, dust, moisture and high temperatures in clean and dry conditions. This adhesive is sensitive to cold, so storage at low temperatures should be avoided.

**Disposal Advice**

Please refer to the MSDS for disposal instructions.

**Safety Advice**

Please refer to the MSDS for safety advice.

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