Swift®therm 2003NA

Swift®therm 2003NA is a fast setting, polyurethane reactive hot melt adhesive used for industrial assembly and automotive interior applications. It will adhere to a variety of substrates and has a relatively short open time making it ideal for manual attachments and small pieces. 2003NA is a single-component hot melt adhesive that cross-links through a chemical reaction with moisture found in the surrounding air and substrates. 2003NA is especially effective for automotive interior trim applications. Additionally, the intrinsic chemical nature of wood and wood products makes 2003NA ideal for bonding soft woods, hard woods, particle board, MDF, papers and wood veneers. It bonds equally as well to EPS, PU foam, aluminum, steel and various steel coatings, including epoxy/phenolic coatings, and various plastics, such as PP, PVC, ABS, and SMC.

Technology / Base	Polyolefin
Type of Product	APAO hot-melt
Appearance / Color	Transparent yellow
Consistency	Viscous Liquid (Solid at Room Temperature)

Features and Benefits

- Medium to short open time
- High green strength
- High heat resistance, cold resistance, moisture resistance and good chemical resistance
- High strength, flexibility, adhesion and toughness
- Polyolefin thermoplastic material which is able to bond to untreated polyolefin substrates like polypropylene
- Suitable substrates include: Bonding of EPDM, wires and carpets to wood, aluminum, PP, fiberboard, Lignotock, Fibrit, etc.

Technical Data

Property	Typical Value	Test Method
Specific Gravity	0.93	at 20°C
Softening Point	Approx 294°F	Mettler - ASTM D3641-76
Brookfield viscosity at 350°F	6,500 ± 1,500 cPs	
Application Temperature	280°F to 350°F	
Open time (4mm bead @ 200°C application temp)	Approx. 10 seconds	
Green Strength Build	50 psi in 30 sec	
Tensile Strength	400 psi	ASTM D638
Elongation to Break	800%	ASTM D638
2% Secant Modulus	1,450 psi	
Cure Time	Approximately 7 days	77 °F and 50% R.H.

Typical Applications

Swift®therm 2003NA is used in lamination and assembly applications in the automotive industry, industrial assembly, panel lamination, woodworking, and furniture production.

Typical Packaging

Swift®therm 2003NA is available in mini-pillows packed in 14kg boxes. Contact your H.B. Fuller representative for other options.

Storage and Shelf Life

Store material in original unopened packaging at temperatures between 15°C to 35°C (59°F to 95°F). Protect from sun, dust, moisture and high temperatures in clean and dry storage conditions. Material is frost resistant. Shelf life is 3 months when stored as recommended.

Safety and Disposal

Prior to working with this or any product consult product label and Safety Data Sheet (SDS) for necessary health and safety precautions and disposal considerations.

General Instructions

INSTRUCTIONS FOR USE:
Application temperature: 280°F – 350°F
Take note of the open time in the technical data table.

The structure of the substrates and working conditions will influence adhesive bonding. Adhesive trials with substrates under customer conditions are necessary.

Due to the high softening point and melting temperature quick melting and application of adhesive is recommended. Avoiding too long heat exposure of adhesive in the pre-melter prevents from thermal degradation and decreasing of bonding quality.

REMARKS:
Prolonged exposure to high temperature should be avoided since this may be lower the bonding performance. Usually, this adhesive is not suitable for plastics containing monomeric plasticizers: plasticizer migration can cause degradation of the adhesive film. Applications like this have to be tested for compatibility.

CLEANING INSTRUCTIONS:
While the product is hot a preliminary cleaning should be done by scraping with a spatula. Please contact your local Sales Office for available cleaning solutions.

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