



**Swift®therm 2103NA**

Swift®therm 2103NA is a longer open time hot melt adhesive developed for industrial assembly and automotive interior applications. It will adhere to a variety of substrates and great for bonding blocked textile into PP and ABS. 2103NA is also recommended for bonding of plastics, ABS, EPDM, wires, carpets, wood, aluminum, PP, fiberboard, Lignotock, and Fibril.

Technology / Base	Hot Melt
Type of Product	APAO Polyolefin
Appearance / Color	Transparent
Consistency	Viscous Liquid (Solid at Room Temperature)

**Features and Benefits**

- Long open time
- High green strength
- High heat resistance
- High strength and flexibility
- Suitable substrates include: Bonding of EPDM, wires and carpets to wood, aluminum, PP, fiberboard, Lignotock, Fibril, etc.

**Technical Data**

Property	Typical Value	Test Method
SG at 20°C	0.93	Ring & Ball
Softening Point	Approx 128°C (263°F)	
Brookfield viscosity at 350°F	4,500 mPa s	
Brookfield viscosity at 300°F	53,00 mPa s	
Application Temperature	150°C to 200°C	
Open time (4mm bead @ 200°C application temp)	Approx. 210 seconds	



## Typical Applications

Swift®therm 2103NA is used in lamination and assembly applications in the automotive industry including:

- Bonding blocked textile
- Polypropylene
- ABS

## Typical Packaging

Swift®therm 2103NA 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 12 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: 150°C – 200°C

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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