



Swift®lock 2U340

2U340 is a single-component, fully reactive hot melt adhesive that cross-links through a chemical reaction with moisture found in the surrounding air and substrates, to produce a thermoset adhesive. 2U340 was specifically formulated for difficult to bond plastics, such as ABS and vinyl, to a wide variety of metals. 2U340 was designed to give good balance of properties. The rheology of the product gives excellent release from roll coaters and no stringing of adhesive. The open time of three minutes is adequate for assembly of a wide variety of applications. Green strength development of greater than 50 psi in 15 seconds holds difficult substrates together after combining. Long term aging studies show excellent retention of adhesive properties.

Technology / Base	Reactive Hot Melt Adhesive
Type of Product	Polyurethane
Components	One component
Curing	Moisture cure
Appearance / Color	Off White
Consistency	Viscous Liquid (Solid at Room Temperature)

Features and Benefits

- High heat resistance (passes B4 boil test), cold resistance, moisture resistance and good chemical resistance
- Very high peel strength
- High green strength
- High strength bonds and great flexibility ideal for differential substrate assemblies
- Good adhesion to a variety of substrates, core stocks and skins including ABS, vinyl, and wide variety of metals
- Longer open time accommodates many industrial assembly applications
- Good low temperature performance

Technical Data

Property	Value	Condition/Method
Rheology		
Viscosity	19,000 cPs	at 250 °F
Material Properties		
Shelf Life at 25°C	6 months	unopen original container
Solids Content	100%	
Open Time	180 sec	
Green Strength Build	>50 psi at 15 sec	77 °F and 50% R.H.
Tensile Strength	4500 psi	ASTM D638
Elongation to Break	800%	ASTM D638
2% Secant Modulus	16,000 psi	
Softening Point	150 °F	prior to full cure
Cure Rate	75% in 24 hours	dependent on moisture and temperature



Application and Cleaning Information

Product is ready to use as received; do not dilute hot melt adhesive.

Confirm compatibility before making hot melt adhesive changes.

Please contact your local Sales Office for processing and application information.

To clean up spilled adhesive, allow the adhesive to cool to room temperature and scrape off heavy deposits with a putty knife. Any uncured residual film may be wiped clean with a common polyurethane solvent (toluene, MEK). Clean up the adhesive before it cures.

Storage Conditions

To ensure maximum stability, product should be stored in the original closed container in an interior location capable of maintaining a constant temperature and a cool dry environment.

Safety and Disposal

Please refer to the SDS for product safety and disposal instructions.

Use with local exhaust ventilation to remove MDI (isocyanate) vapors anywhere heated product is exposed to air including adhesive un-loaders, pre-melters, and application areas. Local exhaust ventilation may be required to maintain exposures at safe levels. Users of reactive hot melt polyurethane adhesives should maintain an ongoing industrial hygiene program which should include employee training, monitoring of MDI levels, and ongoing verification of ventilation system performance.

See Safety Data Sheet (SDS) for additional safety and handling information.

Typical Packaging

Please contact your local Sales Office for available packaging options.

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