



# Automotive Interior Trim EIMEA Product Guide



We've got  
you covered

Whether you're vacuum laminating door panels or manually wrapping instrument panels, we've got you covered with unique technologies and are your partner for value-added, high-performance solutions from concept to commercialization.

As a leading global innovator and supplier of interior trim lamination adhesives, H.B. Fuller has technology and products to ensure efficient, reliable manufacturing processes and aesthetically pleasing, durable bonds. Our broad range of high-performance reactive and thermoplastic hot melt, water-based and solvent-based adhesives help address your leather, synthetic or composite bonding challenges.

Our team of experts is committed to the advancement of automotive interior trim adhesives. The demands of lightweighting, safety, durability and comfort come together in the vehicle interior, and H.B. Fuller offers the most complete set of solutions available. Our automotive interior adhesives help you minimize process space, time and complexity, providing tools to reduce costs and maximize return on capital.

Our products are globally recognized and offer a promise of safety, reliability and performance. Low-volatile organic compounds (VOC), high-temperature resistance, short cycle times, low-activation temperatures and adhesion to a broad range of substrates ensure the lowest possible cost in use. State-of-the-art low-VOC and low-isocyanate adhesives keep you ahead of increasing consumer and manufacturer demands for safer, cleaner driving and working environments. Even under extreme heat conditions, our hot melt adhesives for interiors can reduce or even eliminate volatile organic compounds to attain safe, stable levels.



## FLEXIBLE SUBSTRATES

Textile and textile-backed foam  
Natural and artificial leather  
TPO, primed and unprimed  
PVC and PVC-backed foam  
Spacer fabrics  
Foam and felt  
Carpet

## CARRIERS

Wood and composite wood  
Polyurethane honeycomb  
Polypropylene and NFPP  
ABS and PC/ABS





Headliners

Dashboard

Floors

Trunk Trim

Seats

Foams and Felts

Honeycombs

Carpets

## Hot Melt

As a long leader in hot melt technologies, H.B. Fuller offers a full product line of hot melt moisture-curing polyurethane, reactive polyolefin, and reactive and thermoplastic polyolefin hot melts. Our manufacturing and formulating know-how allows us to bring you durable bonding solutions for your most challenging laminations and assemblies. Recent technological advancements have resulted in products that enhance processing speed, worker safety and substrate-specific adhesion-most notably on untreated polypropylene and ABS.

**Swift®lock 2009**, a reactive polyolefin that bonds to untreated polypropylene, sets a new standard in hot melt technology for speed of heat resistance and strength development. Rapid curing gives you the peace of mind to operate in just-in-time mode, knowing that parts have reached the ultimate OEM performance requirements of your OEM customers before they leave your factory.

**Swift®lock 2028/2**, a moisture-cure, polyurethane reactive hot melt, offers all of the benefits of **Swift®lock 2028** and **Swift®lock 2028/1** and adds rapid curing performance to ensure the timely shipment of final goods.

**Swift®lock 2039**, a moisture-curing reactive polyurethane hot melt, provides a long-sought solution for the challenge of reliably bonding PVC foil to ABS carriers. With heat resistance up to 120°C and a very high hydrolysis resistance for this substrate combination, **Swift®lock 2039** is ready for the most demanding interior applications.

**Swift®lock 2682**, another moisture-curing reactive polyurethane hot melt, is used for precision lamination and is especially suited for premium interiors. Excellent spray properties, long open time and high heat resistance make this product a top choice for leather and artificial leather laminated parts when precision lamination and high heat resistance are required. The rapid cure rate of **Swift®lock 2682** gives users the opportunity to ship high-value premium parts more quickly and reduces finished goods inventory.

Regulatory initiatives around worker safety led to H.B. Fuller's development of **Swift®lock 2029**, a low-monomer adhesive hot melt moisture-curing polyurethane. This general-purpose lamination adhesive offers solid, reliable performance while meeting the European H351 label-free standard for isocyanates.

**Swift®therm 2699**, a thermoplastic polyolefin hot melt, is another robust option for bonding untreated polypropylene and ABS. Suitable for both slot die and roll coating, the extended shelf life and easy reactivation make pre-application of **Swift®therm 2699** months in advance of lamination not only a possibility but also an economical choice for high-speed vacuum lamination processes. Best of all, **Swift®therm 2699** is a clean, thermoplastic material with low-VOC emissions.





# Reactive Hot Melt Bonding Solutions

Product	Technology	Vacuum Lamination	Press Lamination	Premium Lamination	Attachments	Description
Swift®lock 2003	Polyolefin Reactive	●	●			Robust performance on untreated polypropylene, general lamination
Swift®lock 2009	Polyolefin Reactive	●	●			Fast curing, with premium performance and strength on untreated polypropylene
Swift®lock 2028	Polyurethane Reactive	●	●			High-initial strength and bonding performance, suitable for high-energy processes
Swift®lock 2028-1	Polyurethane Reactive	●	●			Lower activation temperature than Swift®lock 2028, excellent for low-energy processes
Swift®lock 2028-2	Polyurethane Reactive	●	●			Fast curing version of the Swift®lock 2028/X series
Swift®lock 2029	Polyurethane Reactive	●	●			Low-isocyanate version of Swift®lock 2028, H-351 label-free compliant
Swift®lock 2039	Polyurethane Reactive	●	●			PVC foil to ABS carrier lamination, heat resistance up to 120°C and very high hydrolysis resistance
Swift®lock 2681	Polyurethane Reactive	●	●			Excellent spray properties, high initial strength and bonding performance for high-energy processes
Swift®lock 2682	Polyurethane Reactive		●	●		Excellent spray properties, low-activation temperature, fast curing, low isocyanate
Swift®lock 9823	Polyurethane Reactive	●	●			Balance of performance and economics with short open time
Swift®lock 9825	Polyurethane Reactive		●			Balance of performance and economics with long open time
Swift®lock 2441	Polyurethane Reactive				●	Very high initial strength and optimized open time for attachments
Swift®lock 2689	Polyurethane Reactive		●		●	Label-free reactive polyurethane hot melt with high initial strength for attachments
Swift®lock 2914	Polyurethane Reactive	●	●		●	High initial strength with a very large adhesion spectrum for general purpose

● Recommended    ● Suitable



## Thermoplastic Hot Melt Bonding Solutions

Product	Technology	Vacuum Lamination	Press Lamination	Premium Lamination	Attachments	Description
Swift®therm 2699	Polyolefin Thermoplastic	●	●		●	High heat resistance for untreated polypropylene and ABS, suitable for preapplication, low-VOC emissions
Swift®therm 2003	Polyolefin Thermoplastic	●	●		●	High heat resistance for untreated polypropylene
Swift®therm 2103	Polyolefin Thermoplastic		●		●	Excellent heat resistance for untreated polypropylene with long open time
Swift®therm 2233	Polyamide		●		●	Very high initial strength and heat resistance with short open time
Swift®therm 2399 DEV	Polyester		●		●	Very high initial strength and heat resistance for polar substrates with short open time
Swift®melt 2033	Rubber		●		●	High heat resistance with aggressive tack and high initial strength, pressure sensitive and suitable for foaming processes
Swift®melt 2849	Rubber		●		●	Good heat resistance with very aggressive tack, pressure sensitive and suitable for spraying processes

● Recommended ● Suitable

## Cleaning Materials

Product	Form	Distribution
Swift®clean 2017	Pellets	Purge, hot melt reactives, high viscosity
Swift®clean 9030	Pellets	Purge, hot melt reactives, low viscosity
Swift®clean 9000	Flake	Roll cleaner



## Water-based

Built on the foundation of **ThermoneX® 063-05A**, the industry standard for performance and reliability in interior trim lamination, H.B. Fuller's complete line of water-based dispersions and global manufacturing network has you covered wherever you are. From highly automated vacuum lamination to meticulously constructed manual processes, H.B. Fuller has the right water-based solution for your substrate, performance and manufacturing requirements.

Our spirit of innovation and unwavering focus on better solutions for our customers is evident by our growing product portfolio.

**ThermoneX® 073-05A** represents the beginning of the next generation of laminating adhesives, combining performance and processing advantages to offer unprecedented value for vacuum, press and premium lamination.

Processing speed and performance enhancements are achievable across the entire product line through **ThermoneX®hardener 007B**. The combination of a **ThermoneX®resin** and **ThermoneX®hardener 007B** provides faster curing and higher ultimate strength than other commonly used hardeners when applied and evaluated under the same conditions. Look to the combination of **ThermoneX® 073-05A** and **ThermoneX®hardener 007B**, yielding increased processing speeds and higher performing parts, to see the future of two-component water-based laminating for automotive interiors.

**ThermoneX® 090-05** delivers high heat resistance and low-activation temperature and is suitable for pre-application months before lamination. Further, this one-component product eliminates onsite mixing of hardener, bringing simplicity and consistency to the factory floor by eliminating a process step.

## Water-based Bonding Solutions

Product	Chemistry	Product Type	Vacuum Lamination	Press Lamination	Premium Lamination	Description
ThermoneX® 3820-07A*	Polyurethane	2k	●	●		Premium bonding performance for high-energy processes
ThermoneX® 063-05A*	Polyurethane	2k		●	●	Premium bonding performance for low-energy processes
ThermoneX® 063-12A*	Polyurethane	2k		●	●	Roll-coatable version of ThermoneX®063-05A, optimized for porous substrates with a very high sag resistance
ThermoneX® 090-05	Polyurethane	1k	●	●		Low-activation temperature, suitable for pre-application, simplified handling
ThermoneX® 073-05A*	Polyurethane	2k	●	●	●	New generation 2k, premium performance for all process types
ThermoneX® 110-04A*	Polyurethane	2k	●	●		Silver family, balance of performance and economics, having the anti-squeaking technology
ThermoneX® 3728-01A*	Polyurethane	2k	●	●		Bronze family, extra-balance of performance and economics
ThermoneX® 3428-06A*	Polyurethane	2k		●		Headliners lamination specialist, balance of performance and economics
Swift®tak L52-052**	Neoprene	2k		●		Good heat resistance, bonding untreated polypropylene, no drying step is needed
Swift®tak 2050	Acrylic	1k		●		Good heat resistance for re-workings, pressure sensitive, cold contact

\*Use in conjunction with ThermoneX®hardener for thermosetting performance

\*\*Use only with Swift®hardener 28721 to avoid drying step

● Recommended ● Suitable

## Hardener Portfolio

Product	Description
ThermoneX®hardener 004B	Black, general purpose
ThermoneX®hardener 006B	Blue, general purpose
ThermoneX®hardener 007B	Blue, enhanced speed and performance



## Solvent-based

Whether you are edge folding, priming or laminating in vacuum, press, or premium processes, H.B. Fuller's diverse line of solvent adhesives has the right solution for you. Our polyurethane, neoprene and pressure sensitive products are built on clean solvents that are low emitting and BTX-free. Decades of proven reliability, ease of application, process consistency and high performance characterize our solvent adhesives and primers for interiors.

Application know-how complements our extensive compounding and manufacturing abilities. H.B. Fuller engineers are ready to support you wherever auto parts are made. We'll help you select the optimum adhesive, hardener and primer package to deliver the results you need on TPO, leather, PVC, foams, felts and plastics including untreated and fiber-filled polypropylene, carpets, textiles and spacer fabrics.

An exciting option in the world of solvent-based lamination is **Swift®col 2511**. Based on neoprene and offering the toughness and performance expected of this chemistry, it bonds to untreated polypropylene. This combination of properties yields robust, streamlined performance and processing while eliminating the need for surface pretreatment.

## Solvent-based Bonding Solutions

Product	Chemistry	Vacuum Lamination	Press Lamination	Premium Lamination	Edge Folding	Priming	Attachment	Description
Swift®col 2607-02*	Polyurethane	●	●					BTX-free solution with low-VOC emissions, suitable for high-energy processes
Swift®col 2607-03*	Polyurethane	●	●	●				Versatile, "all-in-one" adhesive, BTX-free, low-VOC emissions
Swift®col 2607-04*	Polyurethane		●	●				BTX-free, "cold-contact", very low-activation energy, low-VOC emissions
Swift®col 2511	Polychloroprene		●	●	●	●	●	BTX-free, high performance on untreated polypropylene, cold contact
Swift®col 2418	Polychloroprene		●		●	●	●	BTX-free, high performance on polar materials, cold contact
Swift®col 2035	Polychloroprene	●	●		●	●	●	BTX-free, very high performance on polar materials, cold contact
Swift®col 4250	Rubber				●		●	BTX-free with good heat resistance for re-workings, pressure sensitive, cold contact

\*Use in conjunction with Swift®hardener

● Recommended ● Suitable



## Primers

Our solvent-based primers offer surface treatment specially developed to provide the highest bonding performance when using the Swift®col and Thermonex® polyurethane products on low surface energy substrate applications, especially untreated polypropylene.

Product	Key Attributes
Swift®prime 2599	High-performance primer for untreated polypropylene
Swift®prime VP 509/51	High-performance primer for coating TPO and PVC foils

## Hardener Portfolio

To obtain better bonding properties, our Swift®col portfolio can be used in addition with a hardener component. No hardener is needed for our one-component neoprene solutions.

Product	Curing Time	Mixing ratio, weight basis
Swift®hardener 9151	Slow	100 parts adhesive : 6 parts hardener
Swift®hardener 9553	Medium	100 parts adhesive : 10 parts hardener
Swift®hardener 2541	Fast	100 parts adhesive : 3 parts hardener
Swift®hardener 2551	Very fast	100 parts adhesive : 5 parts hardener



## Liquid Polyurethane

H.B. Fuller's reactive liquid Polyurethane technology offers the possibility of very high daily production rates for the Interior trim lamination processes. Both the solvent-free and low emitting, BTX-free, solvent-based **Swift®bond** portfolio give proven reliability and high performance bondings. Formulations are optimized for headliner laminations, acoustic soft trim (AST) laminations, and flocking processes to deliver high efficiency. Using our catalysts selection will also allow the exact adjustment of processing speeds for each specification. Our experienced application engineers will help you fine-tune your bonding process while our global manufacturing capabilities will help simplify your logistics and supply chain.

Lamination process are boosted when using **Swift®bond 2846**, or its black pigmented version **Swift®bond 2845-Black** for dark substrates. Extremely high production rates are possible by minimizing the bonding process with the **Swift®bond** technology. Complete curing occurs in a few hours giving the chance of shipping final parts the same day of the production. The high solid content from **Swift®bond 2846** will minimize the overall adhesive consumption.

## Liquid PU Bonding Solutions

Product	Headliners Construction	Headliners Lamination	Press Lamination	Flocking	Description
Swift®bond 2800 PR*	●				Solvent- and catalyst-free. Very fast processing and curing with high stiffness
Swift®bond 2846 PR*		●	●		45% solid content. BTX-free. Extremely fast processing and curing. Black version available
Swift®bond 2701**				●	Flocking adhesives solution

\*To be used with a catalyst

\*\* To be used with Swift®hardener 9532

● Recommended    ● Suitable

## Catalysts

To obtain the speed of the bonding process and curing profile to the exactly needs of each individual circumstance our Swiftbond portfolio could be used in addition of a catalyst component. Catalyst are not making part of the final performance of the bonding.

## Catalyst Portfolio

Product	Description
Swift®hardener 2005	Metallic catalyst
Swift®hardener 2003	Aminic catalyst





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IMPORTANT: It is the user's responsibility to test and determine the suitability of a product for the user's intended use. Any product samples provided for testing are provided in accordance with standard limited warranties as stated on our technical data sheets.

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