

INTERCOLL D 3481

Technical Information

Area of application

INTERCOLL D 3481 is a water based polychloroprene/acrylate hybrid adhesive for 2-component spray application. The product can be applied by using air-mix spray guns as well as with suitable low-pressure airless guns. The adhesive can be used for the production of mattresses, upholstered furniture, office chairs and for foam conversion. It is suitable for bonding absorbent and non-absorbent substrates, such as polyurethane foams, latex foam, textiles, felt, suitable plastics and wood.

Characteristics

INTERCOLL D 3481 is a sprayable 2-component product which is used in combination with INTERCOLL D 3437 Activator. The adhesive forms an elastic and aging-resistant adhesive joint. It can be used both on one side and in the contact bonding process and shows high initial tack and can therefore be used for high tension bonds.

Technical data

Raw material base:	Polymer dispersion
Solids Content: (WPV 1 T2)	approx. 50 %
Density: (WPV 27 T2)	approx. 1,06 g/ml
Brookfield-Viscosity RVT (WPV 23 T1, 20 rpm, Sp. 1)	approx. 25 mPas
Consumption:	approx. 60 – 150 g/m ² Deviations possible depending on application
Storage temperature:	+5 °C to +30 °C, sensitive to frost
Storage:	max. 6 months at +20 °C in the unopened original container
Danger Classification:	none (according to GGVS/ADR)
Approvals:	



Instructions for use

Dilution:	The adhesive will be delivered as a ready-for-use product. No dilution will be necessary for normal use. The adhesive must not be blended with other adhesives.
Substrate preparation:	Bonding surfaces have to be free of dirt, dust and grease.
Product supply:	from pressure vessel or membrane pump. All parts in contact with the adhesive have to be made of stainless steel or plastic to avoid coagulation. Pressurised systems may only be operated under supervision and must be depressurised after work has finished.
Spray-Mix-Processing:	INTERCOLL D 3481 is mixed with INTERCOLL D 3437 Activator
Adhesive application:	On both parts or on one side only Non-absorbent surfaces can be pre-sprayed with a thin layer to improve adhesion Air assisted guns, spraying pressure approx. 1,5 - 2,5 bar Airless guns, pressure of product: approx. 4 - 6 bar
Cleaning:	With water when fresh, with INTERCOLL L 1815 Löser 31 after drying. Do not use cleaning agents containing substances that interfere with adhesion like silicones, oils or similar.
Safety instructions:	Do not inhale the spray mist. Therefore, it is necessary taking care of using an exhausting system and if necessary personal protective equipment (breathing mask).
Processing temperature:	more than +15 °C
Airing time:	none
Open time:	Contact bonding: Approx. 20 minutes depending on adhesive amount, temperature and humidity of surrounding air. One side bonding: Assemble directly after the adhesive has been applied. Ensure sufficient quantity of adhesive and careful pressing so that a transfer to the other part to be joined can take place.

Important

We guarantee the uniform high quality of our products. All data is based on tests and many years of practical experience. The variety of materials used and the different work conditions, which lie beyond our control, preclude any claims based on this data. We therefore recommend performing sufficient tests or a pilot run. We gladly provide technical advice.

This Technical Information of 17.11.2025 supersedes all previous versions.