Application Areas:

Filled EVA hot melt adhesive specially developed for straight edgebanding on automatic and high-speed edgebanders (Homag, IMA, Biesse, Brandt etc. at feed speeds of 25 – 50 m/min) for particleboard, MDF, and solid core panels.

Engineered for bonding 0.40 – 3.0 mm PVC, ABS, Acrylic (PMMA), melamine, solid wood lippings, and primed veneer edges. Not designed for manual or curved contour edgebanding.

Characteristics & Directions for Use:

Exhibits rapid melt rates and superior thermal stability in the glue pot, preventing charring, skin formation, and nozzle clogging. Delivers clean cutoff without stringing on roller applicator systems.

Provides outstanding initial hot tack to hold heavy thick plastic bands securely under tight press roller pressure at high line speeds. Substrates must be clean, dry, and dust-free. During temporary line stoppages, drop pot temperature to 140 – 150 °C.

Processing Parameters:

Process Parameter	Specification / Condition
Recommended Operating Temperature	190 – 210 °C (At application roller: 190 – 200 °C)
Viscosity (Brookfield @ 200°C)	65,000 ± 10,000 mPa·s (Spindle 29 / 20 rpm)
Recommended Feed Speed	25 – 50 m/min (High-speed automatic lines)
Quantity Applied	180 – 250 g/m² (Substrate porosity dependent)
Open Time Window	approx. 7 – 10 seconds (at 20°C room temp)
Recommended Wood Moisture	8 – 10 % (Board surface temp > 18°C)

Technical Data:

Technical Parameter	Specification Value
Chemical Base	Ethylene Vinyl Acetate (EVA) + Mineral Fillers
Density (@ 20°C)	approx. 1.40 ± 0.05 g/cm³
Softening Point (Ring & Ball)	105 ± 4 °C (ASTM E28 / DIN EN 1238)
Solids Content	100 % (Solvent-free solid granulate)
Appearance & Color	Natural Light Beige Granules
Heat Resistance	approx. 85 °C (Tested under standard static load)

Performance Ratings:

Initial Hot Tack		**98 / 100**
Heat Resistance		**85 / 100**
High Line Speed Suitability		**99 / 100**
Thermal Melt Stability		**92 / 100**
Machining & Trimming Cleanliness		**95 / 100**

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Cleaning:

Scrape off hot residues from the glue pot and roller while warm. For periodic maintenance and char removal, use Mayer Hot Melt Cleaning Granules.

Storage & Shelf Life:

Store in tightly closed original packaging in a cool, dry place (15 – 25 °C). Protect from direct sunlight and moisture. Shelf life is 24 months.

Packaging:

25 kg PE Bags (1000 kg per stretch-wrapped pallet).

Important Remarks & Legal Notice:

Refer to the Material Safety Data Sheet (MSDS) for detailed safety handling. Molten adhesive causes severe burns; always wear heat-resistant gloves and eye protection.

Data represented are average values from standardized laboratory tests. Processors should verify suitability on specific edgebands and panel substrates under operational conditions.

Mayer Adhesive Engineering & Quality Standards:

Quality Management: ISO 9001:2015 certified manufacturing with batch-wise viscosity validation.

Technical Field Support: Roller calibration, feed speed optimization, and coat-weight analysis.

Environmental Compliance: Low-emission, solvent-free, and heavy-metal-free formulation.

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