Application Areas:

Unfilled transparent EVA hot melt adhesive engineered to produce virtually invisible joint lines on dark, black, anthracite, and natural woodgrain panels.

Formulated for bonding 0.4 – 2.0 mm PVC, ABS, 3D acrylic, and natural veneer edgebands on automatic edgebanders (15 – 35 m/min).

Characteristics & Directions for Use:

Contains no mineral fillers; melts crystal-clear to eliminate unsightly white or beige glue lines on dark surfaces.

Enables ultra-thin film application, maximizing linear meter yield per kilogram. Excellent thermal stability in the glue reservoir.

Processing Parameters:

Process Parameter	Specification / Condition
Recommended Operating Temperature	190 – 210 °C
Viscosity (Brookfield @ 200°C)	45,000 ± 7,000 mPa·s (Spindle 29 / 20 rpm)
Recommended Feed Speed	15 – 35 m/min
Quantity Applied	140 – 190 g/m² (Thin film transfer)
Open Time Window	approx. 8 – 11 seconds
Recommended Wood Moisture	8 – 10 %

Technical Data:

Technical Parameter	Specification Value
Chemical Base	Unfilled Pure EVA Copolymer
Density (@ 20°C)	approx. 0.98 ± 0.02 g/cm³
Softening Point (Ring & Ball)	100 ± 4 °C (ASTM E28 / DIN EN 1238)
Solids Content	100 % (Solvent-free transparent granulate)
Appearance & Color	Transparent / Translucent Granules
Heat Resistance	approx. 80 – 85 °C

Performance Ratings:

Transparency & Zero-Line Finish		**99 / 100**
Coverage Efficiency (m²/kg)		**97 / 100**
Initial Hot Tack		**92 / 100**
Heat Resistance		**84 / 100**
Clean Application		**95 / 100**

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Cleaning:

Scrape warm residues mechanically. Use Mayer Cleaning Granules for maintenance.

Storage & Shelf Life:

Store in a cool, dry place (15 – 25 °C). Shelf life is 24 months.

Packaging:

25 kg PE Bags.

Important Remarks & Legal Notice:

Refer to MSDS for safety details.

Completely camouflages joint lines on dark surfaces.

Mayer Adhesive Engineering & Quality Standards:

ISO 9001:2015 certified QA.

On-site glue-line calibration support.

Filler-free high-purity formulation.

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