## Application Areas:

Reactive polyurethane (PUR) hot melt adhesive engineered for 100% waterproof, steam-resistant, and zero-joint (invisible seam) edgebanding in kitchen, bathroom, laboratory furniture, and fire-rated panels.

Designed for straight edgebanders (Holz-Her cartridge systems or nitrogen-blanketed unloader tanks) bonding 0.4 – 3.0 mm PVC, ABS, PMMA, solid wood, and HPL edgebands with extreme heat resistance (> 150 °C).

## Characteristics & Directions for Use:

Crosslinks chemically with ambient moisture into an insoluble thermoset bond. Produces an ultra-thin, flawless zero-joint line even at low coat weights.

Packaged in moisture-barrier containers. Melt units must be flushed with Mayer PUR Neutralizing Cleaner (MT-CL 700) prior to extended shutdowns.

## Processing Parameters:

| Process Parameter | Specification / Condition |
|---|---|
| **Recommended Operating Temperature** | 120 – 140 °C (At roller: 125 – 135 °C) |
| **Viscosity (Brookfield @ 130°C)** | 55,000 ± 10,000 mPa·s (Spindle 29 / 20 rpm) |
| **Recommended Feed Speed** | 15 – 35 m/min |
| **Quantity Applied** | 80 – 130 g/m² (Ultra-thin zero-line) |
| **Open Time Window** | approx. 15 – 25 seconds |
| **Full Chemical Cure Time** | 2 – 4 days (Humidity and temperature dependent) |

## Technical Data:

| Technical Parameter | Specification Value |
|---|---|
| **Chemical Base** | Moisture-Curing Reactive Polyurethane (PUR) |
| **Density (@ 20°C)** | approx. 1.18 ± 0.03 g/cm³ |
| **Softening Range / MFT** | Before cure ~65 °C / After full cure > 150 °C |
| **Solids Content** | 100 % (Solvent-free reactive solid) |
| **Dry Film Appearance** | 100% Water-Resistant Clear-Matte Zero Joint |
| **Water & Heat Resistance Class** | DIN EN 204 D4 & WATT 91 (> 7 N/mm²) Certified |

## Performance Ratings:

| | |
|---|---|
| **Water & Steam Resistance (D4)** | **100 / 100** |
| **Zero-Joint Invisible Seam Quality** | **99 / 100** |
| **Heat Resistance (> 150°C)** | **98 / 100** |
| **Adhesion Strength (All Edgebands)** | **99 / 100** |
| **Thin Film Homogeneity** | **97 / 100** |


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## Cleaning:

Flush hot with Mayer PUR Cleaning Wax (MT-CL 700). Soften cured residues with MT-CL 710.

## Storage & Shelf Life:

Store in moisture-proof packaging at 15 – 25 °C. PROTECT FROM MOISTURE! Shelf life is 12 months.

## Packaging:

2 kg Aluminum Cartridges / 20 kg Pails / 200 kg Drums.

## Important Remarks & Legal Notice:

Contains isocyanates. Wear protective gloves and goggles.

Curing kinetics depend on ambient relative humidity.

## Mayer Adhesive Engineering & Quality Standards:

ISO 9001:2015 certified QA.

WATT 91 and EN 204 D4 accredited test report.

Zero-VOC reactive PUR chemistry.


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