Application Areas:

Reactive PUR hot melt adhesive engineered for flat panel lamination lines (Barberan, Bürkle etc.) bonding High-Gloss, Acrylic, PET, PVC, and CPL/HPL decorative sheets onto MDF, particleboard, and plywood cores.

Eliminates orange-peel surface texture, guaranteeing a mirror-smooth optical finish on high-gloss panels. Not intended for edgebanding or packaging.

Characteristics & Directions for Use:

Low application viscosity and exceptional self-leveling prevent roller ribbing or texture telegraphing through high-gloss sheets.

Forms an impermeable, moisture- and heat-resistant bond layer. Balanced flexibility prevents panel bowing or warpage.

Processing Parameters:

Process Parameter	Specification / Condition
Recommended Operating Temperature	120 – 140 °C (At roller: 120 – 130 °C)
Viscosity (Brookfield @ 130°C)	22,000 ± 4,000 mPa·s (Spindle 29 / 20 rpm)
Recommended Line Speed	10 – 30 m/min
Quantity Applied	40 – 70 g/m² (Thin roller transfer)
Open Time Window	approx. 25 – 40 seconds (Extended window)
Calender Roll Pressure	3 – 5 bar

Technical Data:

Technical Parameter	Specification Value
Chemical Base	Moisture-Curing Reactive Polyurethane (PUR)
Density (@ 20°C)	approx. 1.15 ± 0.03 g/cm³
Softening Range / MFT	> 150 °C After Full Cure
Solids Content	100 % (Solvent-free reactive solid)
Appearance & Color	Transparent / Off-White Solid Block
Surface Finish Quality	Mirror Finish (Zero Orange Peel)

Performance Ratings:

Mirror-Smooth Optical Finish		**100 / 100**
Roller Flow & Self-Leveling		**98 / 100**
Extended Open Time Window		**97 / 100**
Moisture & Heat Resistance		**98 / 100**
Panel Flatness Integrity		**95 / 100**

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Cleaning:

Flush roller coater and melter with Mayer PUR Cleaning Wax (MT-CL 700).

Storage & Shelf Life:

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

Packaging:

20 kg Pails / 200 kg Drums (For bulk drum unloaders).

Important Remarks & Legal Notice:

Maintain strict roller cleanliness during high-gloss runs.

Calibrate doctor roll gap regularly.

Mayer Adhesive Engineering & Quality Standards:

ISO 9001:2015 certified QA.

High-gloss optical surface audit support.

Solvent-free high-purity PUR chemistry.

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