Application Areas:

Reactive polyurethane (PUR) hot melt adhesive developed for profile wrapping of interior MDF, particleboard, and solid wood profiles, door jambs, skirtings, and decorative mouldings with PVC foils, CPL, finish foils, and natural wood veneers.

Provides high initial green strength to overcome foil memory and contour spring-back along deep recesses and tight edges. Not designed for flat edgebanding.

Characteristics & Directions for Use:

Applies cleanly via slot nozzle or roller coater, generating a smooth, uniform adhesive layer on profiled mouldings.

Crosslinks with ambient moisture into a bond of extreme heat resistance (> 150 °C) and moisture durability. Stays elastic to accommodate wood movement.

Processing Parameters:

Process Parameter	Specification / Condition
Recommended Operating Temperature	130 – 150 °C (Slot nozzle: 135 – 145 °C)
Viscosity (Brookfield @ 140°C)	37,500 ± 7,500 mPa·s (Spindle 29 / 20 rpm)
Recommended Line Speed	20 – 60 m/min (Profile wrapping lines)
Quantity Applied	60 – 100 g/m² (Slot nozzle application)
Open Time Window	approx. 15 – 22 seconds
Full Chemical Cure Time	2 – 4 days (Humidity dependent)

Technical Data:

Technical Parameter	Specification Value
Chemical Base	Moisture-Curing Reactive Polyurethane (PUR)
Density (@ 20°C)	approx. 1.10 ± 0.03 g/cm³
Softening Range / MFT	Before cure ~60 °C / After full cure > 150 °C
Solids Content	100 % (Solvent-free reactive solid)
Dry Film Appearance	Light Yellow Opalescent / 100% Water-Resistant Joint
Water & Heat Resistance Class	DIN EN 204 D4 & WATT 91 (> 7 N/mm²) Certified

Performance Ratings:

Profile Edge Green Strength		**98 / 100**
Heat Resistance (> 150°C)		**96 / 100**
Water & Steam Resistance (D4)		**98 / 100**
Slot Nozzle Application Cleanliness		**97 / 100**
Contour Flexibility		**95 / 100**

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Cleaning:

Flush system with Mayer PUR Cleaning Wax (MT-CL 700).

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:

Ensure primer compatibility on wrapping foils.

Protect strictly from atmospheric moisture.

Mayer Adhesive Engineering & Quality Standards:

ISO 9001:2015 certified QA.

Profile wrapping line calibration audit.

Solvent-free high-performance PUR.

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