Application Areas:

Single-component, water-resistant PVAc dispersion wood adhesive complying with DIN EN 204 D3 standards. Formulated for solid wood edge gluing, finger-jointing, chair/table frame assembly, door core pressing, and mortise-and-tenon joints.

Ideal for kitchen, bathroom, and indoor furniture components exposed to high humidity and water splashes. Not intended for packaging or 3D membrane pressing.

Characteristics & Directions for Use:

1-component system ready to use without hardener addition. Delivers rapid setting in cold, heated, and high-frequency (HF) presses.

Dries to an invisible, transparent, tool-friendly glue line that won't dull cutting blades. Optimal wood moisture is 8 – 12%.

Processing Parameters:

Process Parameter	Specification / Condition
Recommended Processing Temp	18 – 25 °C (Substrate & room temp > 15 °C)
Viscosity (Brookfield @ 20°C)	12,500 ± 2,500 mPa·s (RV Spindle 6 / 20 rpm)
Applied Quantity	120 – 180 g/m² (By roller, brush, or nozzle)
Open Time Window	6 – 9 minutes (at 20°C room temp)
Pressing Time (Cold Press @ 20°C)	15 – 25 minutes (Solid wood: 20 – 30 min)
Recommended Press Pressure	0.4 – 0.8 N/mm²

Technical Data:

Technical Parameter	Specification Value
Chemical Base	Polyvinyl Acetate (PVAc) Dispersion
Density (@ 20°C)	approx. 1.10 ± 0.02 g/cm³
Solids Content	50.0 ± 1.0 % (Gravimetric)
Minimum Film Temp (MFT)	approx. +5 °C (pH: 3.0 ± 0.5)
Dry Film Appearance	Colorless Transparent Tough Film
Water Resistance Class	DIN EN 204 / D3 Certified

Performance Ratings:

Water Resistance (EN 204 D3)		**96 / 100**
Bond Strength (100% Wood Tear)		**98 / 100**
Pressing Speed		**92 / 100**
Tool-Friendly Trimming		**95 / 100**
Heat Resistance (WATT 91)		**88 / 100**

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Cleaning:

Clean uncured glue with warm water. Use Mayer Dispersion Cleaner for dried residues.

Storage & Shelf Life:

Store in original containers at 15 – 25 °C. PROTECT FROM FROST AT ALL TIMES! Shelf life is 12 months.

Packaging:

30 kg Plastic Pails / 1000 kg IBC Containers.

Important Remarks & Legal Notice:

Avoid contact with ferrous metals to prevent blue discoloration; use stainless tools.

Keep away from frost.

Mayer Adhesive Engineering & Quality Standards:

ISO 9001:2015 certified manufacturing.

EN 204 D3 accredited test report compliance.

Low-VOC, formaldehyde-free water-based system.

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