Application Areas:

Two-component (2K) high-performance PVAc wood adhesive achieving DIN EN 204 D4 and WATT 91 (> 7 N/mm²) water and heat resistance standards upon adding 5% Mayer D4 Isocyanate Hardener.

Engineered for outdoor garden furniture, wooden window frames, exterior entry doors, saunas, and structural components directly exposed to weather and moisture.

Characteristics & Directions for Use:

Provides an 8-hour pot life after homogeneous hardener incorporation. Meets EN 204 D3 standards even without hardener addition.

Delivers outstanding boiling water, weather, and UV resistance. Suitable for both cold press and heated cycle presses.

Processing Parameters:

Process Parameter	Specification / Condition
Mixing Ratio (A : B)	100 parts MT-WB 410 + 5 parts Mayer D4 Hardener
Viscosity (Brookfield @ 20°C)	11,000 ± 2,000 mPa·s (RV Spindle 6 / 20 rpm)
Pot Life (Working Life)	approx. 8 hours (at 20°C)
Applied Quantity	130 – 190 g/m²
Open Time Window	5 – 8 minutes
Pressing Time (@ 20°C)	20 – 30 minutes (Heated press 70°C: 3 – 5 min)

Technical Data:

Technical Parameter	Specification Value
Chemical Base	PVAc Dispersion + Isocyanate Crosslinker
Density (@ 20°C)	approx. 1.11 ± 0.02 g/cm³
Solids Content	49.0 ± 1.0 %
Minimum Film Temp (MFT)	approx. +7 °C (pH mixed: 3.2 ± 0.3)
Dry Film Appearance	Clear Transparent Fully Water-Resistant Joint
Water Resistance Class	DIN EN 204 D4 & WATT 91 (> 7.0 N/mm²) Certified

Performance Ratings:

Exterior Water Resistance (D4)		**100 / 100**
Heat & Boiling Resistance (WATT 91)		**98 / 100**
Joint Strength		**99 / 100**
Pot-Life Stability		**92 / 100**
Window & Exterior Suitability		**99 / 100**

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Cleaning:

Wash uncured mix with warm water. Cured product must be removed mechanically.

Storage & Shelf Life:

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

Packaging:

30 kg Plastic Pails + 1.5 kg Hardener Bottles.

Important Remarks & Legal Notice:

Use mixed adhesive within 8 hours.

Use stainless steel or plastic tools.

Mayer Adhesive Engineering & Quality Standards:

ISO 9001:2015 certified QA.

EN 204 D4 & WATT 91 accredited test report.

Low-VOC eco-conscious formulation.

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