Application Areas:

Low-viscosity assembly adhesive formulated exclusively for automatic CNC dowel inserting and drilling machines (Koch, Greda etc.) equipped with high-pressure injection nozzles.

Engineered for precise shot-metered dowel hole injection in flat-pack cabinetry and furniture carcass assembly. Not intended for 3D membrane pressing or solid panel laminating.

Characteristics & Directions for Use:

Ultra-low viscosity (300 mPa·s) guarantees zero nozzle clogging or crust formation inside micro-injection ports during machine standstills.

Wets dowel flutes rapidly to generate high mechanical shear strength inside drill holes. Clean water cleanup.

Processing Parameters:

Process Parameter	Specification / Condition
Recommended Processing Temp	18 – 25 °C
Viscosity (Brookfield @ 20°C)	300 ± 80 mPa·s (Spindle 1 / 20 rpm)
Application Method	Automatic High-Pressure Injection Nozzle
Open Time Window	3 – 5 minutes
Setting Time	10 – 20 minutes
Shot Metering Volume	0.2 – 0.6 ml per dowel hole

Technical Data:

Technical Parameter	Specification Value
Chemical Base	Low-Viscosity Modified PVAc Dispersion
Density (@ 20°C)	approx. 1.07 ± 0.02 g/cm³
Solids Content	46.0 ± 1.0 %
pH Value	5.0 – 6.0
Dry Film Appearance	Clear Transparent Rigid Joint
Water Resistance Class	DIN EN 204 D3 Level

Performance Ratings:

Zero-Clog Nozzle Fluidity		**100 / 100**
Dowel Holding Strength		**97 / 100**
Rapid Shot Dispensing Compatibility		**98 / 100**
Injection Precision		**96 / 100**
Water Washability		**99 / 100**

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Cleaning:

Flush nozzles and lines with water at the end of each shift.

Storage & Shelf Life:

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

Packaging:

30 kg Plastic Pails / 1000 kg IBC Containers.

Important Remarks & Legal Notice:

Maintain machine injector pump pressure at 2 – 4 bar.

Protect strictly from freezing.

Mayer Adhesive Engineering & Quality Standards:

ISO 9001:2015 certified QA.

Dowel machine injection calibration support.

Clog-free low-viscosity polymer technology.

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