Application Areas:

MT-WB 450 FoilLam is a high-performance vinyl acetate ethylene (VAE) copolymer aqueous dispersion adhesive engineered for the 2D flat lamination of wood, MDF, and particleboard with plastic foils (especially PVC foils), decorative papers, and for wrap-around folded drawer production.

Difficult Packaging Surfaces & Self-Adhesive Properties: Specially formulated for bonding and labelling of packaging materials with difficult surfaces, for instance with UV varnishes or foil lamination. Provides self-adhesive properties to paper, foils, foam and textiles.

Can be used as a high-strength 1-component (1K) system, or as a 2-component (2K) system by adding 5% Mayer WB Hardener (Isocyanate) for maximum water, moisture, and heat resistance.

Characteristics & Directions for Use:

High Setting Speed & Cold Resistance: Rapid film formation, non-brittle in cold operating conditions, and outstanding elastic recovery.

Long Open Time: Facilitates smooth positioning and extended open assembly without premature skinning on wide roller coater lines.

Medium-Low Viscosity & Smooth Leveling: Delivers clean, string-free application with uniform wet coat distribution, eliminating orange peel or telegraphing defects through thin foils.

Enhanced Heat & Moisture Resistance: Adding 5% hardener significantly boosts chemical crosslinking, water resistance, and heat endurance under static loads.

Processing Parameters & Operating Conditions:

Process Parameter	Specification / Operating Condition
Ambient & Material Processing Temp	> 18 °C (Optimal 18 – 25 °C)
Viscosity (Brookfield @ 20°C, DIN EN ISO 2555)	11,500 ± 2,000 mPa·s (Spindle 6 / 20 rpm)
Recommended Substrate Moisture	8 – 12 %
Application Quantity	80 – 140 g/m² (By roller coater or nozzle)
Open Time Window (@ 20°C)	approx. 4 ± 1 minutes (Coat weight dependent)
Pressing Time (Cold Press @ 20°C)	15 – 20 minutes
Pressing Time (Heated Press @ 40°C)	4 – 6 minutes
Pressing Time (Heated Press @ 60 – 70°C)	1 – 2 minutes
Hardener Ratio (Optional 2K System)	100 parts by weight Adhesive : 5 parts by weight Mayer WB Hardener
Mixture Pot Life (@ 20°C)	approx. 2 hours

Physical & Technical Specifications:

Technical Parameter	Test Method & Specification Value
Chemical Base	Vinyl Acetate Ethylene (VAE) Copolymer Dispersion
Appearance & Color	Liquid / Milky White (Dries Transparent-Translucent)
Density (@ 20°C)	approx. 1.30 ± 0.05 g/cm³ (1.30 g/ml)
Solids Content	55.0 ± 2.0 % (Gravimetric)
pH Value	approx. 7.0 ± 0.5 (Neutral)
Minimum Film Forming Temp (MFT)	approx. +1 °C (Superior Low-Temp Flexibility)
Flammability	Non-flammable (Water-Based Eco-friendly System)

Performance Ratings & Quality Scores:

PVC & Foil Adhesion Strength		**98 / 100**
Folded Drawer & Wrapping Fit		**99 / 100**
Setting Speed & Press Efficiency		**95 / 100**
Cold Temperature & Flexibility		**97 / 100**
Heat & Water Resistance (with Hardener)		**96 / 100**

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Mayer Industrial Adhesive Solutions Inc.

Cleaning & Maintenance:

Clean wet adhesive residues and applicator rollers immediately with warm water. Dried adhesive can be removed mechanically or using Mayer Dispersion Cleaner.

Shelf Life & Storage Conditions:

Store in tightly closed original containers in a cool and dry environment (+15 °C to +25 °C). PROTECT FROM FROST AT ALL TIMES! Do not store below +5 °C. Apply FIFO stock rotation. Shelf life is 12 months from manufacture date.

Packaging & Delivery Form:

20 kg Buckets / 1000 kg IBC Containers.

Important Remarks & Legal Disclaimer:

For occupational safety and chemical handling, refer to the Material Safety Data Sheet (MSDS / SDS).

Because foil surface tensions, plasticizers, and wood porosity vary, factory trials under actual production conditions are recommended prior to large-scale runs.

Mayer Adhesive Engineering & Quality Standards:

Quality Management: ISO 9001:2015 & ISO 14001:2015 certified laboratory QA and batch monitoring.

Environment & Safety: Low-VOC, formaldehyde-free, non-hazardous water-based polymer technology.

Field Technical Advisory: On-site roller calibration, coat-weight optimization, and peel strength testing.

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