Application Areas:

Economical, general-purpose filled EVA hot melt adhesive developed for edgebanding on low to medium speed edgebanders (10 – 25 m/min) for particleboard and MDF panels.

Recommended for bonding 0.40 – 2.0 mm PVC, melamine, and impregnated paper edgebands in standard furniture and cabinetry production.

Characteristics & Directions for Use:

Offers extended open time, providing high bonding tolerance on slower feed machines. Melts evenly in standard glue pots, creating a consistent joint layer.

Well-balanced viscosity fills porous board core edges effectively. Reduce pot temperature during extended machine pauses.

Processing Parameters:

Process Parameter	Specification / Condition
Recommended Operating Temperature	180 – 200 °C (At roller: 180 – 190 °C)
Viscosity (Brookfield @ 200°C)	55,000 ± 8,000 mPa·s (Spindle 29 / 20 rpm)
Recommended Feed Speed	10 – 25 m/min (Standard workshop lines)
Quantity Applied	200 – 280 g/m²
Open Time Window	approx. 12 – 15 seconds (at 20°C)
Recommended Wood Moisture	8 – 10 %

Technical Data:

Technical Parameter	Specification Value
Chemical Base	Ethylene Vinyl Acetate (EVA) + Mineral Fillers
Density (@ 20°C)	approx. 1.45 ± 0.05 g/cm³
Softening Point (Ring & Ball)	98 ± 4 °C (ASTM E28 / DIN EN 1238)
Solids Content	100 % (Solvent-free solid granulate)
Appearance & Color	Natural Beige / Light Yellowish Granules
Heat Resistance	approx. 75 – 80 °C

Performance Ratings:

Initial Hot Tack		**90 / 100**
Open Time Tolerance		**95 / 100**
Core Gap Filling Ability		**96 / 100**
Heat Resistance		**78 / 100**
Cost Efficiency		**98 / 100**

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Cleaning:

Scrape off warm residues mechanically from the glue pot.

Storage & Shelf Life:

Store in a dry, cool area (15 – 25 °C). Shelf life is 24 months.

Packaging:

25 kg PE Bags.

Important Remarks & Legal Notice:

Consult the MSDS for comprehensive safety guidelines.

Data represent standard laboratory test averages.

Mayer Adhesive Engineering & Quality Standards:

Quality Management: ISO 9001:2015 certified production standard.

Technical Support: Feed rate and roller gap setup assistance.

Environmental Standards: Heavy metal-free, safe formulation.

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