Application Areas:

Special low-temperature EVA hot melt adhesive developed for manual, contour/curved edgebanders and CNC machining centers (BAZ) operating at 130 – 160 °C.

Engineered to bond thin PVC (0.4 mm), polyester, lightweight decorative foils, and veneer without heat shrink, distortion, or edge burn. Not recommended for high-speed straight edgebanders.

Characteristics & Directions for Use:

Delivers high fluid wetting and adhesive transfer at reduced operating temperatures. Long open time ensures comfortable manual placement and radius wrapping on curved panels.

Protects heat-sensitive plastic foils from deformation and blistering. Provides smooth, clean application.

Processing Parameters:

Process Parameter	Specification / Condition
Recommended Operating Temperature	130 – 160 °C (At roller: 130 – 150 °C)
Viscosity (Brookfield @ 150°C)	35,000 ± 6,000 mPa·s (Spindle 29 / 20 rpm)
Recommended Feed Speed	4 – 15 m/min (Manual & CNC contour lines)
Quantity Applied	160 – 230 g/m²
Open Time Window	approx. 20 – 30 seconds (Long open time)
Recommended Wood Moisture	8 – 10 %

Technical Data:

Technical Parameter	Specification Value
Chemical Base	Low-Melt EVA + Modified Resins
Density (@ 20°C)	approx. 1.35 ± 0.05 g/cm³
Softening Point (Ring & Ball)	86 ± 3 °C (ASTM E28 / DIN EN 1238)
Solids Content	100 % (Solvent-free solid granulate)
Appearance & Color	Light Beige / Off-White Granules
Heat Resistance	approx. 70 – 75 °C

Performance Ratings:

Low-Temp Fluidity		**98 / 100**
Open Time Window (Contour)		**99 / 100**
Thin Foil Protection		**97 / 100**
Adhesion Strength		**88 / 100**
Curved Radius Performance		**99 / 100**

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Cleaning:

Scrape off while warm using a spatula.

Storage & Shelf Life:

Store at 15 – 25 °C away from sunlight. Shelf life is 24 months.

Packaging:

25 kg PE Bags.

Important Remarks & Legal Notice:

Refer to the MSDS for safety instructions.

Ensure uniform press pressure around tight radii.

Mayer Adhesive Engineering & Quality Standards:

Quality Management: ISO 9001:2015 certified process QA.

Technical Support: CNC contour temperature profiling service.

Environmental Standards: Low-VOC, solvent-free formulation.

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