Application Areas:

Single-component (1K) moisture-curing reactive polyurethane structural adhesive certified under IMO Resolution MSC.307(88)-(FTP-Code 2010) Annex 1, Part 5 (Item Number MED/3.18e) for shipbuilding, mega-yacht, boat manufacturing, and marine engineering.

Engineered for structural bonding of hard timbers (Teak, Oak, Mahogany), HPL/CPL panels, galvanized steel, stainless steel, aluminum, stone, and expanded polystyrene (EPS/XPS) sandwich panels.

Characteristics & Directions for Use:

Free of solvents and formaldehyde. Offers extreme resistance to salt water, permanent submersion, UV exposure, and vibration. Holds IMO Wheelmark 0736 approval.

For marine elements requiring fire safety compliance, the maximum application amount of 150 g/m² must not be exceeded. Applied by notched trowel, spatula, or roller.

Processing Parameters:

Process Parameter	Specification / Condition
Recommended Operating Temp	> +10 °C (Optimal 18 – 25 °C)
Viscosity (Brookfield @ 20°C)	8,000 ± 2,000 mPa·s (RV Spindle 4 / 20 rpm)
Maximum Application Amount	max. 150 g/m² (For IMO fire compliance)
Open Time Window	approx. 35 ± 5 minutes (at 20°C / 50% RH)
Pressing Time (at 20°C)	105 – 120 minutes (Humidity dependent)
Recommended Press Pressure	> 0.6 N/mm²

Technical Data:

Technical Parameter	Specification Value
Chemical Base	Moisture-Curing 1K Polyurethane Prepolymer
Density (@ 20°C)	approx. 1.16 ± 0.03 g/cm³
Solids Content	99.5 ± 0.5 % (Solvent-free)
Heat Resistance After Cure	> 150 °C (High thermal structural integrity)
Dry Film Appearance	Light Beige / 100% Saltwater-Proof Tough Joint
Certifications & Compliance	IMO Wheelmark 0736 / DIN EN 204 D4 & WATT 91

Performance Ratings:

Saltwater & Moisture Resistance		**100 / 100**
IMO Fire Retardant Compliance		**100 / 100**
Structural Bond Strength		**99 / 100**
Extended Open Time (35 min)		**94 / 100**
Vibration & Impact Damping		**95 / 100**

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Cleaning:

Clean uncured product with Mayer Solvent Cleaner (MT-CL 710). Cured adhesive must be removed mechanically.

Storage & Shelf Life:

Store at 15 – 25 °C in moisture-proof containers. Protect from temperatures below +5 °C. Shelf life is 12 months.

Packaging:

1 kg Bottles / 5 kg Pails / 25 kg Drums / 200 kg Drums.

Important Remarks & Legal Notice:

Do not exceed 150 g/m² for IMO fire safety compliance.

Lightly mist non-porous substrates with water for faster cure.

Mayer Adhesive Engineering & Quality Standards:

ISO 9001:2015 certified QA.

IMO Wheelmark MED/3.18e marine approval.

Solvent-free and formaldehyde-free 1K PUR.

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