For water resistant bonding...

KLEIBERIT 303

KLEIBERIT 303 the millionfold proven water resistant white glue for bonding according to DIN/EN 204 stress groups D3/D4 with 5% Turbo Hardener. Ideal glue for bonding windows, doors and stairs as well as many other applications.

Adhesive for water resistant bonding in accordance to DIN/EN 204
D3 + D4

KLEIBERIT 303

KLEIBERIT 303.0

Bonding in Shipbuilding
(according to IMO FTP Code Part 5 & Part 7/ approval according to BG Transport (Department Maritime Safety) for international use according to Module B) Certificated application quantity: 150 g/m²

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KLEIBERIT 303

waterproof

PVAC glue

with 5% KLEIBERIT 303.5

Turbo Hardener D4 quality

TECHNICAL DATA

APPLICATION METHOD
- With brush, spatula or glue roller
- With gluing devices fitted to frame presses and dove-tailing machines
- With glue spreaders

All application devices must be made of Y2A steel or synthetic materials. Generally single-sided glue application is sufficient. Double-sided application is recommended for hard and exotic timbers!

Application quantity:
- 100-130 g/m² for surface bonding
- 150-200 g/m² for solid wood

Open time:
- 6-10 min. (without hardener)
- The open time is influenced by application quantity, absorbability of the materials, moisture content of wood and air and the temperature.
- The pot life has been exceeded, the remainder can be used as a D3 glue or as a D4 if hardener is once again added. Observe the exact mix ratio! This process can only be repeated once.

Pressure:
- 0.7-1.0 N/mm² when bonding lamella or laminated wood

Pressing times:
- Joint bonding 20 °C from 15 minutes
- Joint bonding (pre-heated) 50 °C from 5 minutes
- Joint bonding 80 °C from 2 minutes
- Surface bonding (HPL panels) 20 °C 15-20 minutes
- Surface bonding (HPL panels) 50 °C approx. 5 minutes
- Surface bonding (HPL panels) 80 °C 1 - 2 minutes

When used as a two component glue, the times given should be extended by approx. 50 %. Slight foaming of the mixture does not affect the glue quality and can be eliminated by stirring. The final bond strength according to DIN/EN 204 will be achieved after 7 days.

CLEANING
Application devices, machines and adhesive packaging can be cleaned with water.

PACKAGING
KLEIBERIT 303:
- plastic pail 4.5 kg net, 10 kg net, 28 kg net
ton
- 12 plastic bottles at 0.5 kg net each

KLEIBERIT 303.5 Turbo Hardener:
- 12 metal bottles at 0.5 kg net each
ton
- 12 metal bottles at 0.7 kg net each

Measuring cup is included.

STORAGE
Both components may be stored for approx. 1 year at 20 °C in factory sealed containers. The glue is frost resistant down to -30 °C. Before use bring up to room temperature and stir well.

SERVICE
Our application department may be consulted at any time without obligation. The statements herein are based on our experience gained to date. They are to be considered as information without obligation. Please test and establish for yourself the suitability of our products for your particular purposes. No liability exceeding the value of our product can be derived from the foregoing statements. This also applies to the technical consultancy service, which is rendered free of charge and without obligation.

IDENTIFICATION
Identification KLEIBERIT 303.5:
- Identification not required according to EU regulations. Identification KLEIBERIT 303.5:
- Identification required according to EU regulations (see safety data sheet). Please see our safety data sheets 303.0 and 303.5.