Windows, doors and laminate boards

KLEIBERIT has reacted to the requirements of the market with new products and developments for all 3 adhesive systems

KLEIBERIT 303.0
Universal usable dispersion based on PVAC for window corner bonds and laminate boards.
- 1 component
- High water resistance with test certificate D3 in accordance to DIN/EN 204
- With hardener bond quality D4 in accordance to DIN/EN 204
- High temperature resistance in accordance to DIN/EN 14257 > 7 N/mm²
- Very high frequency bond
- Colourless glue line
- Good relationship between open time and press time
- No loss of adhesive

The adhesive can be used for bond quality D3 after the end of the pot life when mixed with hardener 303.5. Adding additional hardener will achieve bond quality D4.

KLEIBERIT 303.3
Dispersion on PVAC basis for bonding of solid timber.
- Joint filling characteristics
- Tolerance adapting
- Bond quality D3

In the production of windows and doors made from solid wood the adhesives have gained more and more importance when using European as well as Asian timber. In general the following bond qualities are required:
- Water resistance D3 or D4 in accordance to DIN/EN 204
- High temperature resistance tested in accordance to DIN/EN 14257; with a recommended minimum value of > 7 N/mm²

To achieve these requirements the following adhesive systems are required:
- PVAC-dispersions (with or without hardener)
- PVAC-copolymer dispersion - without hardener
- with hardener also called EPI systems
- 1C PUR adhesive
KLEIBERIT windows and doors

### 1C PUR adhesive

1C PUR adhesive are used for highest quality requirements. It is a water-free adhesive system, a chemical cross-linking is achieved by the aid of the substrate or ambient humidity. 1C PUR adhesives can be used in a wide variety of different production processes for example through adjusting of the open time.

### KLEIBERIT 304.1

- High water resistance D4 in accordance to DIN/EN 204
- Various open times available
- High temperature resistance in accordance to DIN/EN 14257 > 9.5 N/mm²
- Joint filling

### KLEIBERIT 304.4

- 2C PVAC dispersion for the production of window edges, window corners and laminate boards.
- High water resistance D4 in accordance to DIN/EN 204
- Very high temperature resistance in accordance to DIN/EN 14257 > 8 N/mm²
- Very high frequency bond
- Long pot life, several days

### KLEIBERIT 569.0 / KLEIBERIT 568.0

1C PUR construction adhesive for different materials such as wood, plastics, metal and mineral materials
- Extreme high bond strength
- Water resistance D4 in accordance to DIN/EN 204
- High fill volume
- Short open time
- Short press time

---

### KLEIBERIT 304.1 EPI

2C PVAC dispersion adhesive on PVAC-copolymer basis to produce high quality bonds of local and exotic timber
- High water resistance D4 in accordance to DIN/EN 204
- Exceptionally high temperature resistance in accordance to DIN/EN 14257 > 12 N/mm²
- Applied via 2C mixer and dosing applicators
- Accurate dosing
- Good mixing with appropriate hardener

### KLEIBERIT 304.4 EPI

- Good mixing with appropriate hardener
- Accurate dosing
- Applied via 2C mixer and dosing applicators
- Exceptionally high temperature resistance
- High water resistance D4

### KLEIBERIT 501.0

- Tried and tested for over 10 years. For strong bonds, suitable for a wide variety of applications.
- High water resistance D4 in accordance to DIN/EN 204 with test certificate
- Excellent bond to many exotic timbers

### KLEIBERIT 502.8

- High water resistance D4 in accordance to DIN/EN 14257 > 8 N/mm²
- Exceptionally high temperature resistance
- High water resistance D4

### KLEIBERIT 502.8 + 808.2

- High water resistance D4 in accordance to DIN/EN 204
- Various open times available
- High temperature resistance in accordance to DIN/EN 14257 > 9.5 N/mm²
- Joint filling

### KLEIBERIT 304.1 + 304.3

- High water resistance D4 in accordance to DIN/EN 204; very high temperature resistance in accordance to DIN/EN 14257; excellent high frequency bond; long pot life; several days

### KLEIBERIT 304.5 + 808.2

- High water resistance D4 in accordance to DIN/EN 204; DIN/EN 14257; 12.6 N/mm²; application with 2C mixing and dosing devices; excellent mixing; good mixing ratio with the hardener

---

### Properties of KLEIBERIT products

- **Viscosity** [mPa·s]
- **Open time** [min 20 °C]
- **Ref.**
- **Bond quality**
  - DIN/EN 204
  - DIN/EN 14257
- **Remarks**