CONTACT ADHESIVES

WORKING WITH VENEER

FOAMS

		C Part -	1920	4102 H		1 44											100 miles (100 miles (573.8	REMAINT &			820.0 820.0 820.0 820.0 8 8 8 8 8 8 8 8 8 8 8 8 8 8 8 8 8 8	C lat u	6 Brind		HINON Sees	
PRODUCT	114.5 Contact Adhesive	116.0 Contact Adhesive	152.0/.5/.6 Contact Adhesive	410.0/.2/.6 Aqueous Contact Adhesive	322.1 D2 Veneer Glue	871.5 Hot Press Glue	881.1 Hot Press Glue + 881.2 Hardener	535.0 Assembly Foam SupraFoam	536.0 Assembly Foam StairMaster	588.4 Door Foam	540.5 1C Assembly Foam	544.3 1C Mega Foam	544.4 1C Gun Foam	823.0 PUR Cleaner	555.3 Primer for Foams	308.0 Super Lacquer Glue Suprabond	466.0 Edge and Foil Glue	573.8 2C-PUR Adhesive + 870.0 Hardener	851.0/.1 Instant Adhesive High Tack	761.7/.9 EVA & PUR Cleaner	816.0 Cleaner	820.0 Thinner + Cleaner	826.0 PUR Cleaner	827.0 EVA Cleaner	580.1 Acrylate Sealant	590 E Silicone	594 N Silicone
		the bonding of a wide variety	for bonding of wood and wood based materials to each other,	Non-polluting aqueous system		non-flammable A2 boards and other wood based materials, surface bonding	for veneer bonding of interior and exterior doors, water re- sistant chipboard, for interior and external surfaces exposed to moisture	for invisible assembly of door frames, panels etc. with enormous adhesive bonding.	sembly foam. For installation of wooden stairs, window sills	door foam in an aerosol can with a new, practical rotary	filling and installation. Foam- ing in of windows and roller shutters boxes. Universal use	ing PUR foam for filling, insu- lating and assembly of windows and roller blind boxes. Caulking of roofing tiles and walls, insula- tion of pipe conduits and filling of wall cavities and other hollow spaces. Economical use. No	ing PUR foam for filling, insu- lating and assembly of windows	of fresh PUR foam and cleans ing of PUR applicator gun		lacquer and plastic surfaces	the manual bonding of a va riety of edging materials and	a- metals, concrete, and many d plastics (e. g. laminated boards, rigid PVC) to each other as well as wood and lam- inated boards to each other.	bonds, fixes, repairs and assembles with high initial strength. Excellent adhesion to many materials with extremely rapid hardening process for relatively small	melting units, hoses, and application units in which reactive PUR hotmelt adhesives and other non- reactive hotmelt adhesive systems (e.g. based on EVA) are processed.	tion units as well as mixing and dosing plants for two component adhesives. The suitability as a rinsing agen with regards to the resistance	g tion tools which were used to apply solvent adhesives. A thinner for our solvent ad- t hesives on polychloroprene e basis, e.g. KLEIBERIT 114.5	the mechanical application of PUR adhesives and meltin baths which have been use	or To clean mixing heads used for f the mechanical application of g PUR adhesives and melting d baths which have been used for processing PUR adhesives	sealant compound. Sealing of interior joints with little move- ment (concrete, masonry,	cone-based sealant for win- dows, connecting joints in	with integrated primer. Seal-
	+80 °C • highly resistant against	+120 °C • highly resistant against	 high green strength temperature resistant from -20 °C up to +80 °C good ageing resistance, no tendency to embrittlement hardener 801.0: improvement of tempera- ture, water resistance and adhesion properties 		 one component adhesive can be stained or treated with water 	can be avoided to a large extent • long pot life	according to DIN EN 204 • easy to use • long pot life • short press time	(EC1 plus) • formaldehyde-free • no propellants	 very low low-emission (EC1 plus) formaldehyde-free processable fram 10 °C B2 according to DIN 4102 		 very low low-emission (EC1 plus) good ageing and chemical resistance B2 according to DIN 4102 thermal conductivity with value, according to DIN 52612: 0.039 W/(m.K) joint sound insulation: 59 dB Rst,w max 		 very low low-emission (EC1 plus) no curing during breaks good ageing and chemical resistance 	• reliably removes fresh PUR foam	 universally applicable application by means of sealing brush without problems little foaming high resistance cured coating is water and chemical resistant 	resin dispersion, for bond-	PVC, ABS and PMMA		 851.0: suitable for plastics, rubber, metal, fabrics, leather, wood, ceramic, etc. 851.1: suitable for porous materials and for rough or uneven surfaces as well as plastics, ferrite, sintered metal, wood, cork, leather, fabrics, etc. 	application units. Nozzles remain unclogged. • good mixture properties with PUR adhesives • neutralizes the isocyanate		 cleaner and rinsing agent for machines for two component adhesive usage. The suitability as a rinsing agent with regards to the resistance of the seals and pipes, must be checked with the manufacturer of the machinery first 	 clear, "oily" fluid, with a very high flame point 	 clear, "oily" fluid, with a very high flame point 	 paintable high heat, cold and ageing resistance good UV and light resistance 	 good water and weather resistance high heat and cold resistance 	 odor-free curing good water and weather resistance excellent ageing resistance
COLOR	• color: beige	• color: beige	• color: 152.0 beige, 152.5 red, 152.6 blue	• color: 410.0 red, 410.2 white, 410.6 black	• color: white	• color: white		• color: yellowish	• color: light brown	• color: green	• color: beige	• color: beige	• color: yellowish	• color: transparent	• color: yellowish	• color: white, dries yellowish-white	• color: bluish green	• color: mixture - concrete grey	• color: transparent	• color: blue	• color: transparent	• color: transparent	• color: transparent	• color: transparent	• color: white	 color: white, black, grey, light grey, transparent light brown, brown 	 color: white, black, grey, light grey, transparent light brown, brown
BASE	polychloropren	polychloropren	polychloropren	synthetic resin dispersion	special dispersion based on PVAC	urea formaldehyde conden- sation resin	,	2C PUR foam fire class B2 (DIN 4102, part 1)	2C PUR foam fire class B2 (DIN 4102, part 1)			1C PUR foam fire class B2/B3 (DIN 4102, part 1)	1C PUR foam fire class B2 (DIN 4102, part 1)	acetone	primer	synthetic resin dispersion	EVA copolymers	polyurethane	α-cyanacryl acid, 2-ethyl ester	EVA copolymers	ketone	mixture of organic solvent	polyethylene glycol	di-isononylphthalate	1C sealant based on acrylate	acetic acid curing silicone sealant	neutrally cross-linking silicone sealant with built-in primer
PACKAGING	metal canister 4.5 kg		metal pail 24 kg	carton: 4 cans at 0.8 kg each plastic pail 4.5 kg plastic pail 10 kg	plastic pail 10 kg plastic pail 30 kg		PE bag 25 kg net	16 cartridges at 210 ml /	16 plastic cartridges at			carton: 12 bottles at 500 ml each	carton: 12 bottles at 750 ml each	carton: 12 bottles at 500 ml each	carton: 9 bottles at 1 kg each canister 5 kg	12 bottles à 0.5 kg	plastic pail 34 kg	g carton 10 tins at 0.670kg each g metal pail 3.6 kg 870.0 carton: 10 tins at 0.230 kg each	24 bottlesat 20 g each12 bottlesat 50 g each851.1 carton:24 bottlesat 20 g each	6 stand-up pouches at 220 g each 6 aluminium bags in fiber drum at 1.50 kg each PE bag 20 kg 761.9 carton: 6 aluminum cans at 200 g each		metal canister 4.5 kg metal bottle 756 g metal can 22 kg	metal canister 4.5 kg	12 bottles at 700 g each	carton: 24 cartridges at 310 ml each	carton: 25 cartridges at 310 ml each	carton: 25 cartridges at 310 ml each carton: 20 aluminium bags at 600 ml each 20 aluminium bags at 400 ml each
APPLICATION	doctor blade	 brush, notched trowel or doctor blade special roller application machines 	• spray gun • curtain coater • brush	 spray gun notched trowel brush and glue applicators 	U		 notched trowel glue roller glue application machines 	890.0, 890.1	 double cartridge hand gun 890.0, 890.1 beads spot 	 aerosol can with rotary disk activation 	 aerosol can with rotary disk activation 	• application gun 891.0 and 891.1	• application gun 891.0 and 891.1		• sealing brush	 brush, spatula hand roller 	 brush hand roller and spatula 	 spatula mixing and dosing devices 		PE bag 20 kg					 compressed air gun caulking gun cartridges: 894.0, 894.1 flexible tubes: 896.0, 896.1 	 compressed air gun caulking gun cartridges: 894.0, 894.1 	 compressed air gun caulking gun cartridges: 894.0, 894.1 flexible tubes: 896.0, 896.1
COAT WEIGHT		125 - 150 g/m² per side to be bonded	100 - 150 g/m² per side to be bonded		120 - 180 g/m² depending on surface chalking point approx. +7°C		veneering 140-180 g/m² cross banding 160-200 g/m²		depending on application, joint gap up to 15 mm						approx. 100 g/m² per application	150 - 200 g/m² depending on surface	150-200 g/m² edge bonding 80-120 g/m² foil bonding	g 250 - 300 g/m ² as coating approx. 1 kg/m ² , depending on layer thickness							depending on size of joint	depending on size of joint	depending on size of joint
20°C/50% REL.LF	10-15 min depending on temperature join precisely with high	5-10 min depending on temperature join precisely with high	approx. 5 min without hardener, approx. 4 min with hardener depending on temperature join precisely with high	depending on temperature	up to 6 min		10-13 min 0.2 - 0.7 N/mm²	cured after 15-20 min	cured after 20 min	tack-free after approx. 5-10 min cured after 45 min at 2 cm bead strength	cured after approx. 1.5-5 hours				35 ± 8 min The coating is cured after a drying time of approx. 2 days.		80-120 g/m² 3-4 min 150-200 g/m² 10-12 min	approx. 45 min; may be							curing speed: approx. 2 mm / 24 hours	skin forming approx. 15 min curing speed: approx. 2,5 mm / 24 hours at 23 °C / 50 % RH	curing speed: approx. 3 mm / 24 hours
PRESS TIME	contact pressure	contact pressure	contact pressure 0.3 - 0.5 N/mm ² See technichal data sheet	contact pressure 0.6 N/mm ²		, 	,	See technichal data sheet	See technichal data sheet	See technichal data sheet	See technichal data sheet	See technichal data sheet	See technichal data sheet	See technichal data sheet		See technichal data sheet	See technichal data sheet	See technichal data sheet	See technichal data sheet	See technichal data sheet	See technichal data sheet	See technichal data sheet	See technichal data sheet	See technichal data sheet	See technichal data sheet	See technichal data sheet	See technichal data sheet
STORAGE	114.5 12 months at 15-25°C frost resistant to - 5°C	116.0 12 months at 15-25°C frost resistant to - 5°C	152.0 approx. 6 months at 15-25°C frost resistant to - 5°C	protect from frost	322.1 12 months at 20 °C not frost restistant + 5 °C	2 months at 30 °C	6 months at 30 °C				540.5 24 months at +20 °C store in a cool and dry place			823.0 approx. 24 months	555.3 approx. 9 months at +20 °C Do not store below -5 °C			573.8 approx. 12 months at 20 °C store in a cool and dry place	851.0/.1 approx. 12 months at 20 °C store in a cool and dry place		816.0 minimum 12 months	820.0 12 months	826.0 approx. 12 months at 20 °C	827.0 approx. 12 months at 20 °C	protect from frost	570	594 18 months at 5-35 °C store in a cool and dry place
	Stand 02/23; subject to change				protect from frost	must be stored airtight, cool and dry	must be stored airtight, cool and dry										protect from frost								store in a cool and dry place		

Stand 02/23; subject to change

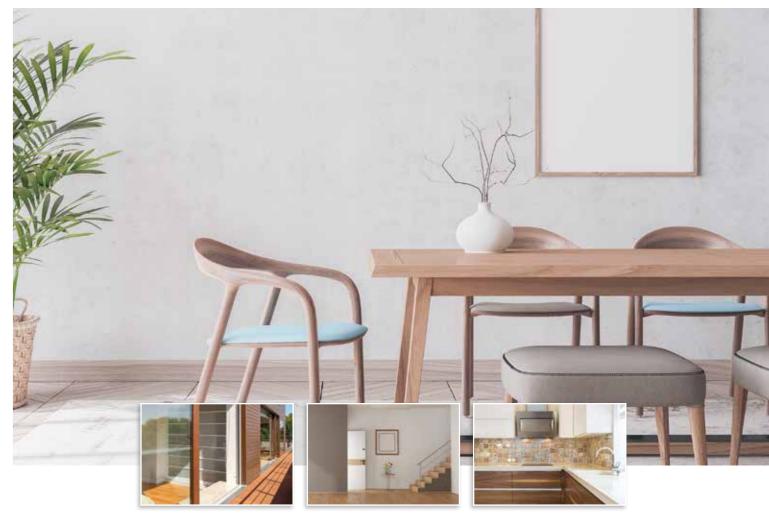
SPECIAL APPLICATIONS AND CLEANER

SEALANTS





Wood Industry **Glues** • Adhesives Sealants • PUR Foams



KLEIBERIT – the adhesives specialists

Competence **PUR**

A	SSEMBLY	ADHESIVES							VAC ADHESIVES									ESIVES			STP ADHESIVE EDGE BANDING D4									
	0			SALO SALO Marina Taranan Taranan						8							0					H H H	TOT 6 TOT 6 TOT 6 Tot 10 Tot 1	TOTASO ME		10 m			and a set	
Se	566.0 PUR Adhesive and Sealant Compound Supracraft	568.0 D4 PUR Adhesive		584.0 STP Assembly Adhesive	600.0 STP Assembly Adhesive transparent	601.1 STP Assembly Adhesive High Tack	601.4 STP Assembly Adhesive	602.1 STP Assembly Adhesive	305.0 1C/D2 Assembly Glue	316.0 PVAC Dowel Glue	323.0 1C/D2 Glue	332.0 D2 Surface Glue	347.0 PVAC dispersion	303.0 1C/D3 Glue + 303.5 ME hardener/D4	304.1 2C Glue + 304.3 hardener/D4			501.4/.6/.8 D4 PUR Adhesive			605.1.20 STP Adhesive D4		707.6 Reactive PUR Hotmelt Adhesive	Hotmelt Adhesive	735.0 Hotmelt Adhesive		Hotmelt Adhesive Hotm		788.3 Itmelt Adhesive	
APPLICATION tion ure sup floc als, wo cer con	on adhesive based on poly- rethane. Bonding of metal upports for double-layer oorings. Bonding of met-	on polyurethane for the bonding of a wide variety o materials, with high wate resistance (DIN EN 204) and temperature resistance DIN EN 14257 (Watt 91)	for the bonding of a wide va- riety of materials, with high water resistance (DIN EN 204) and temperature resistance DIN EN 14257 (Watt 91)	setting adhesive and sealant for interior and exterior use. Humidity curing 1 component system based on silane-termi- nated polymers (STP). Elastic bonding of different materials	sive and sealant for interior and exterior use. Transpar- ent joint, optically invisible bonding and sealing. Elastic bonding of different mate- rials such as wood, glass, a variety of metals, mineral substrates and most plastics.	 bly adhesive for interior and exterior use. Neutral curing 1 component system based on si lane-terminated polymers. Adhe sion to most common construct tion materials such as minera substrates, glass, wood, metal: and various plastics. Bonding or mirrors in accordance with DIM 	d sive for interior and exterior use. Neutral curing 1 component sys- tem based on silane-terminated polymers (STP) with high green c-strength. Elastic bonding of dif- ferent materials such as wood, ls glass, metal, plastic and mineral of substrates.	adhesives; 2 component system based on silane-terminated poly- mers. Elastic bonding of different materials such as glass, metal, plastic and mineral substrates. Controlled curing between none permeable substrates. • fast curing • good initial strength	dispersion for universal use. Assembly and carcass bonding, bonding of laminates, core pro- duction, veneer joint bonding, joint and frame bonding of	components with automati dowelers, dowel banding for frame construction (also harr board), mini dovetail bond ings of wooden frames an knot-sealing machines.	ic wood bonds and HPL. Fo or curing flat lamination. d- d d • bond quality D2	 st types of surface bonding, especially suited for multi-stage pressing, very long open time. Veneer bonding. long open time reliable bonding of all types of veneer 	with very short setting times Particularly suited for fas press processing. Bonding of laminates in a short cycle press. Assembly bonding any joint bonding, bonding of pi laster strips and ledges, bond ing of edges (cold bonding o with heated band), bonding o structural components. • short setting time with cold	 mand bands. Bonding of wire dows, doors and stairs dows, doors and stairs dows, doors and stairs dows, doors and stairs 	 colorless hardener for wate resistant bonding, class D4 Bonding of windows, doors and stairs with hardener 304.3 	er water resistant bonding accoi 1. ing to DIN EN 204. Bonding 5, windows and doors, stairs, H panels, hard and exotic woo Complies with requiremen according to BRL 2339 fing	 adhesive for very strong, bon with high temperature res tance. For bonding windov doors, wood, wood based m terials, exterior joints, mine er building materials, ceramic a e, concrete materials, as well p- hard foams. high heat and weather 	ds strong bonds with high heat re- sistance. For bonding windows, vs, doors, wood, wood based ma- terials, exterior joints, mineral building materials, ceramic and concrete materials, as well as	reaction adhesive based or polyurethane, highly resistan to water and temperature. Wa ter resistance according to DIN EN 204, D4. Bonding windows and doors, wood, wood mate rials, joint bonding for exterio areas, bonding of mineral build ing boards, ceramic and con	bonding of wood components, window and door elements manufacturing, layer bonding of wood based materials, bonding of mineral sheet materials and rigid foams. D4 according to DIN EN 204. • tested according to EN 15425:2017 for the pro- duction of glued laminated timber according to EN	adhesive for manufacturing of wall elements and other non- load-bearing structures made of wood and wooden materials. Manufacture of wood products that are exposed to the weath- er and elemets elements that are subject to high loads or are temporarily exposed to increased moisture.	sive for highly stressed edge bonding with panel materials: ABS, PMMA, PVC and PP edges (with suitable bonding agent), CPL and HPL edges (bonding agent may be required), paper edges and veneer and solid wood edges • heat resistance to 150 °C	sive for solid wood edges, HPL-edges in strips, PVC-edg es, extruded/calandered, as strips or rolls (primed), veneer edges and duroplastic and thermoplastic edges in rolls	, with ABS-, PMMA-, PVC- and PP-edges (with suitable bond- ing agent), CPL- and HPL-edges (may require bonding agent), paper-edges, veneer and solid wood edges	I adhesive for bonding an pre-coating of a variety of edg ing materials	 d of polyester edges, CPL and melamine resin edges, also so called thin edges, PVC and ABS edges (primed), uncompressed resin-impregnated paper edges 	• univers • good melting properties • good w	or edgebanding and edgeb coating. Bonding of melamine resin, PVC edges (pre-treated auncompressed resin ed paper edges, solid reneer edges edges, elow fror il • very ter resistance	anding machines, very open time/pronounced uess and bonding of PVC der edges pre-treated on ack, polyester edges, resin gnated paper edges, ABS	
• r	• restraining effect on vibration • permanently elasticity	non-foaming reduces vibration non-corrosive color: beige	 slightly foaming color: transparent-opaque 	(wet)	• UV and weather resistant • paintable	(wet) • UV and weather resistant • very low emission (EC1 plus) • permanently elastic • paintable • fast and bubble-free curing • processing from +5-30 °C	 UV and weather resistant permanently elastic paintable fast and bubble-free curing processing from +5-35 °C 	 permanently elastic paintable processing from +5-30 °C 	 high green strength good open time fast curing with warm and cold bonds good application prop- erties with machine and hand applicators color: beige 	no incrustation and blockage of the nozzle color: white	• color: white,	• bonded veneers can be	J J J J J J J J J J J J J J J J J J J	• as 2C glue - D4 with	 tough elastic film, gentle on tools temperature resistance 	bonds • short press times when heat added	 stress group D4 according to DIN EN 204 temperature resistance DIN EN 14257 (Watt 91) very well suited for Miner 	 stress group D4 according to DIN EN 204 temperature resistance DIN EN 14257 (Watt 91) 	 very light joint low foaming duroplastic glue joint achieves highest bonding strength very well suited for Miner- gie(A-/P-)Eco, corresponds to 1st priority Eco-BKP colorless 	cross laminated timber (CLT) according to EN 16351 • tested to SANS 10183-4-1: 2009, resp. EN 302-1: 2004	 adhesion to painted surfaces, many plastics and metals, even without sanding paintable processable from 5-30 °C 	 excellent strength, also when exposed to steam very good stability in open melting tanks (with normal climate 20/65 at least 24 hours) color: 707.6.40 natural 	excellent strength, also when exposed to steam ecolor: natural-00, white-10,	excellent strength, also when exposed to steam color: 707.9.50 nature 707.9.51 white 707.9.58 transparent	materials	 no stringing high green strength color: beige-transparent 	 no stringing high green strength also for fast processing machines cold res edge) d color: 779.6.2 	ce pre- stance (depending)) up to approx. 80 °C on a stance (depending on very wn to approx30 °C (dej 79.6.10 white to a	-coated edges at resistance (depending edge) up to approx. 90°C y good cold resistance	
	Csystem based on olyurethane	polyurethane	polyurethane	silane-terminated polymers	silane-terminated polymers	black silane-terminated polymers	silane-terminated polymers	silane-terminated polymers	PVAC dispersion	PVAC dispersion	dries transparent PVAC dispersion	PVAC dispersion	dries transparent PVAC dispersion	dries transparent PVAC dispersion 1C D3 glue (D4 glue with hardener 303.5	dries transparent PVAC dispersion 2C D4 glue)	dries transparent PVAC dispersion	1C PUR adhesive D4	1C PUR adhesive D4	1C PUR adhesive D4	• color: white to yellowish 1C PUR adhesive D4	silane-terminated polymers	707.6.48 transparent polyurethane	vanilla-12 polyurethane	707.9.95 black polyurethane	ivory-20 EVA copolymers	EVA copolymers	779.6.5 EVA copolymers EVA copo		788.3.99 black opolymers	
0.3	2 aluminium cartridges at	carton: 12 plastic cartridges at 0.490 kg each	carton: 12 plastic cartridges at 0.325 kg each	carton: 12 plastic cartridges at 0.325 kg each 0,430 kg 20 flexible tubes at 0.860 kg each	carton: 12 plastic cartridges at 0.300 kg each 20 flexible tubes at 0.600 kg each	carton: 12 plastic cartridges at 0.448 kg each	carton: 12 plastic cartridges at 0.442 kg each	12 plastic cartridges at 0.510 kg each	carton: 12 bottles at 0.5 kg each plastic pail 10 kg net plastic pail 33 kg net	canister 10 kg canister 26 kg	plastic pail 10 kg	g plastic pail 10 kg		plastic pail 10 kg	n plastic pail 9.5 kg	plastic pail 10 kg plastic pail 28 kg	carton: 12 bottles at 0.5 kg eac metal canister 6 k metal can 32 k	carton: th 12 bottles at 0.5 kg each ig metal canister 5 kg ig 501.8 metal canister 6 kg metal pail 30 kg	metal can 30 kg	carton: 6 bottles at 0.8 kg each metal pail 20 kg	• .			carton: 6 aluminium bags in fiber drum at 2.0 kg each pouch pack 20 kg	о 0		carton with 45 cartridges for HOLZ-HER at 310 g each carton with 18 cartridges for Festool Conturo at 107g each pail 3 kg PE bag 20 kg	at 355 g each PE ba	5 kg 1g 25 kg	
• (• compressed air gun • caulking gun cartridges: 894.0, 894.1 flexible tubes: 896.1	 bead, spot or surface caulking gun cartridges: 894.0, 894.1 	 bead, spot or surface caulking gun cartridges: 894.0, 894.1 	 bead, spot or surface caulking gun cartridges: 894.0, 894.1 	 bead, spot or surface caulking gun cartridges: 894.0, 894.1 	 bead, spot or surface caulking gun cartridges: 894.0, 894.1 	 bead, spot or surface caulking gun cartridges: 894.0, 894.1 	• application gun KLEIBERIT 894.6	 brush or notched trowel hand applicators (pressure vessel, gun) glue application machines (2 and 4 roller systems) 	 presses with nozzle injectors for structural bondings 	•	brush or notched trowel glue roller glue application machine	spatula, glue roller and spray bottle • nozzle application device ou	each and 0.7 kg, canister 25 k • brush or trowel • glue roller	glue roller glue application machines applicators for dovetail	 brush or trowel glue roller glue application machine with gluing devices from frame presses and finger jointing units 		 brush or trowel glue roller 	 directly from the packaging trowel or hand roller 	 manually with spatula or hand roller automatically using an application plant 	 brush or trowel glue roller nozzle equipments 		 automated edgebander with roller applicator 	 automated edgebander with roller applicator 	 automated edgebander with roller applicator automated edgebander with spray nozzle line speed from 8 m to ove 25 m/min 	 automated edgebander with roller applicator line speed 10-30 m/min depending on edge width r 	with roller applicator with ro spray n • machin coating • line spr	er applicator or coa zzle • mar s for edge pre- • line	chines for edge pre- iting nual edgebanders e speed from 5 m/min	
COAT WEIGHT	pprox. 250 g/m² for mooth surfaces	150 - 300 g/m² for smooth surfaces	150 - 250 g/m² for smooth surfaces						manual applic. 150-200g/m² machine applic. 100-150 g/m² chalking point approx. +5 °C	Ū	100 - 200 g/m² chalking point approx. +7 °i	manual application C approx. 150 g/m ² machine applic. 100-120 g/m ² chalking point approx. +5 °C	100 - 110 g/m² when applied by machine up to approx. 150 g/m² when applied with	100 - 200 g/m² depends on application chalking point approx. +5 °(100 - 180 g/m² chalking point approx. +3°C	manual application 150 g/m machine application 100 g/n chalking point approx. +10 ° depending on surface	2	100 - 200 g/m²	100 - 200 g/m² depending on material	120 - 350 g/m² depending on material and joint gap	100 - 200 g/m² depending on material				Select coat weight to ensure a uniform adhesive film.	· · · · ·	Select coat weight to ensure a Select coo	weight to ensure a Select	t coat weight to ensure a rm adhesive film.	
OPEN TIME/ ski SKINNING TIME AT 20°C/50% RH POT LIFE at	pprox. 3 mm / 24 hours	approx. 7 min	approx. 10 min	25 ± 10 min curing speed approx. 2 mm / 24 hours at 20 °C / 50% RH	25 ± 10 min curing speed approx. 2 mm / 24 hours at 20 °C / 50% RH		approx. 8 min curing speed approx. 2-3 mm / 24 hours at 20 °C / 50% RH	at 20 °C / 50% RH	approx. 10 min epending on coat weight and processing conditions		5-10 min	up to 25 min	approx. 3 min	6-10 min without hardener with hardener 50% longer joint gluing 20 °C from 15 min pot life 24 hours	4-6 min depending on coat weight and processing conditions joint gluing 20 °C from 20 min pot life 1 week		20-25 min	501.4 approx. 4 min 501.6 approx. 70 min 501.8 approx. 8 min	approx. 15 min	510.3.25 approx. 17 min 510.3.40 approx. 25 min										
	ee technichal data sheet 66.0	> 1 N/mm ² approx. 15-30 min (depending on application) See technichal data sheet 568 0	0,6 N/mm² approx. 60 min (wood bonding) See technichal data sheet	fix for at least 24 hours (depending on temperature and humidity) See technichal data sheet	fix for at least 24 hours (depending on temperature and humidity) See technichal data sheet 600 0	fix for at least 24 hours (depending on temperature and humidity) See technichal data sheet	fix for at least 24 hours (depending on temperature and humidity) See technichal data sheet 601 4	(depending on temperature and humidity)	0.3 - 0.5 N/mm² See technichal data sheet	See technichal data sheet	0.2 - 0.7 N/ mm² See technichal data sheet	0.2 - 0.5 N/ mm² See technichal data sheet	See technichal data sheet 347 O	0.7 - 1.0 N/mm² See technichal data sheet 303 0	0.3 - 0.6 N/mm² See technichal data sheet	0.2 - 0.4 N/mm ² for surface bonding 0.7 - 1.0 N/mm ² for lamina ing and chip board bonding See technichal data sheet 214.2		501.6 6-7 h 501.8 30 min See technichal data sheets	0.6 N/mm ² 20 °C: 45-60 min, 40 °C: 25-30 min 60 °C: 15-20 min See technichal data sheet 507 9	0.6 N/mm ² 510.3.25 50 min 510.3.40 90 min See technichal data sheets 510.3.25, 510.3.40	See technichal data sheet 605.1.20	See technichal data sheets		See technichal data sheets	See technichal data sheet 735 0	See technichal data sheet 773.3	See technichal data sheet See techn 773.8 779.6	chal data sheet See te 788.3	echnichal data sheet	
STORAGE 12			569.0 12 months at +5 °C to 25 °C		approx. 12 months	601.1 approx. 12 months store in a cool and dry place	approx. 12 months	602.1 from 6 months store in a cool and dry place	305.0 12 months 20 °C frost resistant to -15 °C	316.U 12 months at 20 °C protect from frost	323.0 12 months at 20 °C frost resistant to -25 °C	332.0 12 months at 20 °C frost resistant approx30 °C	12 months at 20 °C	303.0 12 months at 20 °C frost resistant to -30 °C	304.1 12 month at 5-25 °C frost resistant to -30 °C	314.3 approx. 6 months at 20 °C protect from frost		501.4, 501.6, 501.8 501.4/.8 6 months at 20°C, frost resistant to -25°C 501.6 12 months at 20°C, frost resistant to -20°C		approx. 12 months at 20 °C frost resistant to -20 °C	approx. 9 months at 20 °C	707.6.40, 707.6.41, 707.6.48 approx. 12 months store in dry place	12 months store in dry place	707.9.50/.51/.58/.95 12 months store in dry place	24 months	24 months	773.8 779.6 24 months 24 month store in a cool and dry place store in a	24 mo	onths	



KLEIBERIT ADHESIVES -THE SPECIALIST AMONGST ADHESIVE MANUFACTURERS



KLEIBERIT adhesives are an now integral part of the world we In the last 25 years, KLEIBERIT has become a global trendsetter live in. Today KLEIBERIT SE & Co. KG is based in Weingarten for PUR adhesive systems and has significantly influenced the Baden (Southern Germany) and also has one of the most mod- market with its innovative product ideas. ern and innovative research and production centres worldwide. Innovative adhesive systems for a wide field of applications are CUSTOMER SATISFACTION - EVERY CUSTOMER IS NUMbeing developed in cooperation with, and produced for inter- **BER ONE WITH US**. national customers. The product range is designed specifically On the road in many markets and all regions of the world, we for customer requirements and worldwide availability is ensured speak almost every national language and are directly on site with an intelligent logistics concept.

CUSTOMERS.

Adhesive bonding is the bonding technology of the future. KLEIBERIT'S strategy is to continue to provide new innovations SOCIAL RESPONSIBILITY - WE LIVE THE PRINCIPLE OF for a wide field of applications. One investment for the future SUSTAINABILITY IN PROCESSES AND PROCEDURES AC-2009. Customer can regularly be found here working closely MANAGEMENT. with KLEIBERIT engineers and technical personnel to develop Responsibility towards the environment and the people in respecific product solutions.

COMPETENCE PUR - RESEARCH AND DEVELOPMENT SECURE THE FUTURE.

velopment, the most modern production, highest product quality ture with sustainable processes and goals. as well as service oriented, customer focused and competent consultation. And this for 75 years.

via a comprehensive service and consulting network. By working closely with machine and material manufacturers, we offer INNOVATIONS - NEW IDEAS DEVELOP TOGETHER WITH practical and innovative adhesive systems which meet a wide variety of international standards and norms.

is the shown by the opening of the TECHNICAL CENTER in CORDING TO CERTIFIED QUALITY AND ENVIRONMENTAL

search, development, production and logistics is one of the main goals at KLEIBERIT. Our demand to combine high product quality with environmental and health and safety of the workforce accompanies our innovation process from the beginning. We The KLEIBERIT trademark stands for innovative research and de- also want to further develop this global responsibility in the fu-

KLEIBERIT[®] ADHESIVES WORLDWIDE:

KLEIBERIT Chimie S.a.r.l. Reichstett, France KLEIBERIT Adhesives UK

KLEIBERIT Adhesives of Canada Inc.

Coalville, Leicestershire, England KLEIBERIT Adhesives USA Inc. Waxhaw, North Carolina, USA

Toronto, Ontario, Canada

Sydney, Australia KLEIBERIT Adhesives Japan

Osaka, Japan

Bejing, China

KLEIBERIT Adhesives Australia

KLEIBERIT Adhesives Asia Pte. Ltd.

Singapore, Singapore

KLEIBERIT Russia Moscow, Russia KLEIBERIT Adhesives India Private Ltd. Bangalore, India KLEIBERIT-UKRAINE LLC. Kiev, Ukraine

lstanbul, Türkiye

KLEIBERIT Adhesives Beijing Co., Ltd. KLEIBERIT Kimya San. ve Tic. A.Ş.

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