

KLEIBERIT 300.0

Industrial glue for water-resistant bonding in accordance with DIN EN 204 Stress Group D3 (with hardener)

Fields of use

- Bonding windows and doors
- Surface bonding of HPL boards
- Surface bonding during partition and element manufacture
- Bonding hard and exotic timbers, e.g. for the construction of stairs
- Suitable for veneers
- High frequency bonding

Advantages

- As a single component glue - ready for use
- As a two component glue - for highest demands
- Suitable for hot and cold bonding
- Short press times

Properties of the glue

Base:	PVAC dispersion
Mixing ratio:	Comp A : Comp B: 20 : 1 (i.e. 5% hardener added)
Density at 20 °C :	Comp A = approx. 1.10 g/cm ³ Comp B = approx. 1.13 g/cm ³
pH-value:	3 ± 0.5
Colour of glue:	white
Colour of mixture:	white
Consistency:	medium viscous
Viscosity at 20°C	
- Brookfield RVT Sp 6/20 rpm:	12,000 ± 3,000 mPa·s
Pot life:	with hardener approx. 24 hours

Open time (at 20°C):	6-10 minutes
Chalk point:	approx. +5°C
Identification KLEIBERIT 300.0:	See our safety data sheet
Identification KLEIBERIT 305.0 ME:	See our safety data sheet

Properties of the bond

- When used as a single-component glue KLEIBERIT 300.0 meets the requirements of stress group D3 according to DIN EN 204
- As a two component glue with 5% KLEIBERIT 303.5 ME meets the requirements of stress group D4; according to DIN/EN 204 AIDIMME test certificate n. 221.C.2301.048.DE.01

Restricted to professional users

- from 01/24/2023
- KLEIBERIT 300.0 with KLEIBERIT 303.5 ME tested according to EN 14257 (WATT 91) AIDIMME test certificate n. 221.C.2301.048.DE.01 from 01/24/2023
- High bond strength, also with hard and exotic timbers
- Glue line (single-component glue): tough elastic, colourless
- Glue line (two-component glue): tough elastic, light yellowish

Application methods

- Brush, spatula or glue roller
- Gluing devices fitted to frame presses and dovetailing machines
- Glue spreading machines

Application devices must be made from V2A steel or synthetic materials.

Application techniques

The materials to be glued must be free from dust, oil and grease, and be acclimatised. The most favourable working temperature is 18-20° C and the moisture content of the wood should range between 8-10 % for indoor areas and 10-14 % for window production. Do not process below +10° C! In most cases, single-sided glue application is sufficient. Double-sided application is recommended for hard and exotic timbers!

Application quantity:

100-130 g/m² for veneer work.
150-200 g/m² when bonding solid wood.
The application quantity is dependent upon the structure of the surface and the application devices used.

Open time:

6-10 min.
The open time is influenced by the quantity of glue applied, absorbability of the materials, temperature and the moisture content of the wood and air.

Pot life:

approx 24 hours
Stir in required amount of hardener until good mixture is achieved. Upon expiry of the pot life the left over glue can be used as D3 adhesive or to achieve D4 bonding further hardener can be added.

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Pressure: 0.70-1.00 N/mm² for laminated plastics and laminated wood

Press times:

Application	Temp.	Press Time
Joint bonding	20°C	from 15 min.
Joint bonding (pre-heated)	50°C	from 5 min.
Joint bonding	80°C	from 2 min.
Surface bonding HPL boards	20°C	15-20 min.
Surface bonding HPL boards	50°C	approx. 5 min.
Surface bonding HPL boards	80°C	1-2 min.

If used as two component glue the specified extend the specified times by approx. 50%.

Slight foaming of the mixture will not affect the glue quality and can be eliminated by stirring.

Final bond strength which meets the requirements of DIN/EN 204 stress groups will be reached after 7 days.

Wood and wooden materials are natural products. Influenced by the region of the world from which they originate, as well as the differing pre-treatment methods to which they have been exposed, isolated cases of discolouration, (e.g. Birch, Cherry and Sugar Maple) can occur. The same can happen when bonding wood which contains tannin (e.g. Oak) and when it makes contact with iron (due to an unsuitable pressing plant).

Cleaning

Application devices, machines and containers can be cleaned with water

Packaging

KLEIBERIT 300.0:

Plastic pail, 10 kg net
 Plastic pail, 28 kg net
 Plastic drum, 130 kg net
 Disposable plastic container, 1000 kg net

Hardener 303.5 ME:

Carton with 12 metal cans, at 0.7kg net each
 Metal canister, 5 kg net

Storage

Both components can be stored for approx. 1 year at 20° C in the original factory sealed containers.

The glue is resistant to frost and temperatures down to approx. -30° C. Before use, warm to room temperature and stir well.

Version 02.05.2023 xi; replaces previous versions

Adhesives and Waste Disposal

Waste code adhesive 080410

Waste code hardener 080501

Our containers are made of recyclable material. Well drained containers can be recycled.

Service

Our application department may be consulted at any time without obligation. The statements made 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.