

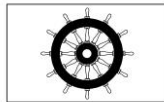
# KLEIBERIT 303.0

## Water-resistant PVAC Adhesive

Adhesive for water resistant bonding according to DIN EN 204, stress group D3/D4 (with hardener)

### Fields of application

- Bonding of windows and doors
  - Surface bonding of HPL-boards
  - Surface bonding of partitions and parts
  - Stair construction
  - Bonding of laminates
  - Bonding of tenon and finger joints
  - Bonding of hard and exotic timbers
  - High frequency bonding
  - Bonding in shipbuilding
- Approval no.: 118225-03  
 Certified application  
 quantity: 150 g/m<sup>2</sup>



### Advantages

- As single component glue – ready to use
  - As two component glue – for highest demands
  - Suitable for hot and cold bonding
  - Short press times
- The composition of KLEIBERIT 303.0 complies with the FDA Guideline 21CFR § 175.105

### Properties of the glue

**Base:** PVAC dispersion  
**Density:** approx. 1.10 g/ cm<sup>3</sup>  
**pH-value:** approx. 3.0  
**Colour of the glue:** white  
**Open time (at 20°C):** 6 - 10 minutes  
*the open time is influenced by the applied quantity, absorbency of the materials, the humidity of the wood and air, and the temperature.*

**Consistency:** medium viscosity  
**Viscosity at 20°C -Brookfield RVT spindle 6/20 rpm:** 12,000 ± 2,000 mPa s  
**Chalk point:** approx. +5°C

By adding of 5% hardener KLEIBERIT 303.5 stress group D4 according to DIN EN 204 will be achieved.

**Pot life with hardener:** approx. 24 hours  
 Stir in the stipulated amount of hardener until it is mixed well. After the pot life has been exceeded, the remainder can be used as D3 glue or as a D4 if hardener is once again added. **Observe the exact mixing ratio!**  
 This process can only be repeated once.

### Identification KLEIBERIT 303.0:

Identification not required according to EU regulations

### Identification KLEIBERIT 303.5:

Identification required according to EU regulations (see our safety data sheet).

### Properties of the bond

- KLEIBERIT 303.0, as a one component glue, meets the requirements of stress group D3 according to DIN/EN 204.  
 Test certificate no. 18-002518-PR01 dated 05/10/2018
- As a two component glue with 5% KLEIBERIT 303.5, meets the requirements of stress group D4  
 test certificate no. 14-002990-PR01 dated 25/11/2014
- KLEIBERIT 303.0 tested according to EN 14257 (WATT 91)  
 KLEIBERIT 303.0: i.f.t. test certificate no. 18-002518-PR02 dated 05/10/2018  
 KLEIBERIT 303.0 + 303.5: i.f.t. test certificate no. 14-002990-PR02 dated 25/11/2014
- High bond strength, even with hard and exotic timbers
- Glue line (single component): tough elastic, colourless
- Glue line (two component): tough elastic, light yellowish
- KLEIBERIT 303.0 complies with IMO FTP-Code Part 5 & Part 2/ approval according to SeeBG (department maritime safety) for international use according to **Module B**  
 Approval number: 118225-03  
 (xxxx = production year)  
 Certified application quantity: 150 g/m<sup>2</sup>

# KLEIBERIT 303.0

## Application methods

- 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 V2A steel or synthetic materials**

## Application techniques

The materials to be glued must be free from dust, oil and grease and be acclimatised.

The best work temperature is between 18-20°C, the favourable moisture content of the wood is between 8-10 % for interior area and 10-14% for window production.

Do not process below +10°C!

Generally single-sided glue application is sufficient. Double-sided application is recommended for hard and exotic timbers!

## Application quantity:

100 -130 g/m<sup>2</sup> for surface bonding

150 - 200 g/m<sup>2</sup> for solid wood

*The application quantity depends on the structure of the surfaces and the application devices used.*

**Pressure:** 0.7 – 1 N/mm<sup>2</sup> when bonding lamella or laminated wood

## Press times:

Application	Temp.	Press time
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%.**

This data is given as a guideline and without obligation at a moisture content of the wood of approx. 10%. Slight foaming of the mixture does not affect the glue quality and can be eliminated by stirring.

Due to the fact that this product can be used in various fields, the result of the bond is influenced by various factors. Please determine your own exact data by means of tests using your own machines and materials.

The final bond strengths D3/D4 according to the stress groups as per DIN/ EN 204 will be achieved after 7 days.

Wood and wood based materials are natural products. Influenced by the regions of the world from which they originate and the characteristics depending on the species of wood, isolated cases of discolouration can occur.

## Cleaning

Application devices, machines and containers can be cleaned with water.

## Packaging

### KLEIBERIT 303.0:

plastic pail, 4.5 kg net

plastic pail, 10 kg net

plastic pail, 28 kg net

carton containing 12 bottles at 0.5 kg net each

### Hardener

#### KLEIBERIT 303.5:

carton with 12 metal bottles at 0.5 kg net each

carton with 12 metal bottles at 0.7 kg net each

Measuring cup is included.

Additional packaging available upon request.

## 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.

Version 17.02.2023 kh; 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.