

KLEIBERIT 303.2

Aqueous PVAC Adhesive for water-resistant bonding in accordance with DIN EN 204 Stress Group D3/D4 (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 demanding requirements
- Suitable for hot and cold bonding
- Short press times

Properties of the bond

- KLEIBERIT 303.2 meets the requirements of stress group D3 according to DIN EN 204 (see test certificate no. 555 27399 issued by the "Fenster Institut Rosenheim", dated 28.08.2003)
- KLEIBERIT 303.2 with 5% Hardener KLEIBERIT 303.5 meets the requirements of stress group D4 (see test report Nr. 14-002990-PR03 issued by the "Fenster Institut Rosenheim" dated 25.11.2014)
- KLEIBERIT 303.2 mit 5% Hardener KLEIBERIT 303.5 has been tested acc. to WATT91 (see test report Nr. 14-002990-PR04 issued by the "Fenster Institut Rosenheim", dated 25.11.2014)
- High bond strength, also with hard and exotic timbers
- Glue line (single-component glue): tough elastic, colourless
- Glue line (two-component glue), tough elastic, slighty yellow)

Properties of the glue

Base: PVAC dispersion
Mixing ratio (weight or volume): Comp. A : Comp.B = 20 : 1 (i.e. 5 % hardener added)
Density at 20 °C: Comp. A = approx. 1.10 g/cm³
 Comp. B = approx. 1.13 g/cm³

pH-value: approx. 3.0
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: approx. 24 hrs with hardener added
Open time (at 20 °C): 6-10 minutes
Chalk point: approx. +5°C

Identification - Glue: Identification not required according to EU regulations. (See our safety data sheet)

Identification - Hardener: Identification is required according to EU regulations. Protect hands and eyes! Wash off splashes immediately with water. (See our safety data sheet.)

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!

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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

Thoroughly stir in the prescribed amount of hardener until a good mixture is achieved. Following expiry of the pot life, any glue remaining may be used as D3 glue or re-mixed with hardener to attain a D4 bond.

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

Press times:

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

When used as a two component glue, the times shown should be increased 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 D3 or D4 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 303.2:

plastic pail, 10 kg net

plastic pail, 28 kg net

plastic drum, 130 kg net

disposable plastic container, 1000 kg net

Hardener 303.5:

carton with 12 metal bottles at 0.7kg net each
metal canister, 5 kg net

Additional packaging sizes available upon request.

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 4/12/2018 XI; replaces previous versions

Adhesives and Waste Disposal

Waste code adhesive 080410

Waste code hardener 080501

Disposal of contents and/or containers should comply with all applicable federal, state and local regulations.

Our containers are made of recyclable material.

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.