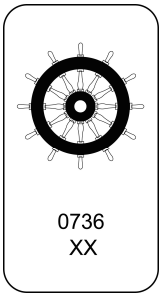
KLEIBERIT 303.0 D3/D4 Glue
according to DIN EN 204

Industrial glue for water resistant bonds, highest demands

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 (according to IMO FTPC Part 5 & Part 2/ approval according to SeeBG for international use according to **Module B**) Approval number: 118.219 (XX = production year)



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

Properties of the bond
- KLEIBERIT 303.0, as a one component glue, meets the requirements of stress group D3 according to DIN/EN 204. (See test certificate of "Fensterinstitut Rosenheim" no. 505 21571/1 dated 13.07.1999)
- As a two component glue with 5% KLEIBERIT Turbo-Hardener 303.5, meets the requirements of stress group D4 (See test certificate of "Fensterinstitut Rosenheim" no. 505 21571/1 dated 13.07.1999)
- KLEIBERIT 303.0 tested according to EN 14257 (WATT 91). (See test certificate of "Fensterinstitut Rosenheim" no. 505 20756 U dated 17.6.1998)
- High bond strength, even with hard and exotic timbers
- Glue line (single component): tough elastic, colourless
- Glue line (two component): tough elastic, light yellowish

Properties of the glue

Base:	PVAC dispersion
Mix ratio:	Comp. A : Comp.B = 20:1
(weight or volume)	5% hardener addition
Specific gravity:	
Comp. A	approx. 1.10 g/ cm³
Comp. B	approx. 1.13 g/ cm³
pH-value (w/o hardener):	approx. 3.0
Colour of the glue:	white
Colour of the mixture:	white
Consistency:	medium viscosity
Viscosity at 20°C -Brookfield RVT spindle 6/20 rpm:	13,000 ± 2,000 mPa s
Pot life:	approx. 24 hours with hardener
Open time (at 20°C):	6 – 10 minutes (without hardener)
Chalk point:	approx. +5° C

Identification glue:
Identification not required according to GefStoffV (see our safety data sheet).
Identification Turbo Hardener:
Identification required according to GefStoffV (see our safety data sheet).

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!

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KLEIBERIT 303.0 D3/D4 PVAC Glue according to DIN EN 204

Application quantity:
100 -130 g/m² for surface bonding
150 - 200 g/m² for solid wood
The application quantity depends on the structure of the surfaces and the application devices used.
Open time: 6 - 10 min.
(without hardener)
The open time is influenced by application quantity, absorbability of the materials, moisture content of wood and air and the temperature.
Pot life: approx. 24 hours
(with hardener)
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 a D3 glue or as a D4 if hardener is once again added.
(Observe the exact mix ratio!)
This process can only be repeated once.

Pressure: 0.7 – 1 Nmm² 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	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

KLEIBERIT Turbo-Hardener 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.

EX0610; replaces previous versions

Waste Disposal
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.

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