

Klebit 303.2

Industrial glue for water resistant bonding according to DIN EN 204 Stress group D 3

Fields of application

- Bonding of windows and doors
- Surface bonding of HPL-boards
- Surface bonding of partitions and parts
- Bonding of hard and exotic timbers, e.g. stair construction
- Suitable for veneering
- High frequency bonding

Advantages

- Single component glue - no mixing necessary
- Suitable for hot and cold bonding

Properties of the bond

- KLEIBERIT Klebit 303.2 as a single component glue meets the requirements of stress group D3 according to DIN EN 204
- High bond strength even with hard and exotic timbers
- Good heat resistance
- Fast setting
- Glue line: hard-tough, transparent

Properties of the glue

Base:	PVAC dispersion
Specific gravity:	about 1.1 g/ cm ³
pH-value:	approx. 3
Colour:	white
Viscosity at 20°C	
Brookfield RVT	
spindle 6/20 rpm:	12,000 ± 3,000 mPa s
Open time (at 20°C)	7-8 minutes
Chalk point:	approx. +7° C
Identification:	Identification not 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

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 between 10-14 %. 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: 120-200 g/m² when applied manually.
80-100 g/m² when applied mechanically.
The application quantity depends on the structure of the surfaces and the application devices used.

Open time: 7-8 min. The open time is influenced by application quantity, absorbability of the materials, moisture content of wood and air and the temperature.

Press times: surface bonding (HPL-boards) (20° C) 15-20 min.
surface bonding (HPL-boards) (60° C) 7-9 min.

These data are given as guiding lines and without obligation. They apply to a moisture content of the wood of approx. 10 %. 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 strength D3 according to the stress groups as per DIN/ EN 204 will be achieved after 7 days.

Cleaning

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

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Packaging

plastic pail, 28 kg net
plastic drums, 130 kg net
non-returnable cardboard box, approx. 1000 kg net

Storage

KLEIBERIT Klebit 303.2 may be stored for approx. year at 25°C in factory sealed containers. The glue is frost resistant down to approx. -20° C. Before use bring up to room temperature and stir well.

EX 0300 replaces previous data sheets

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.