

Tempo 347.0

Artificial resin dispersion glue with very short setting times. Particularly suited for fast press processing.

Fields of application

- Bonding of laminates in a short cycle press
- Bonding of edges (cold bonding or with heated band)
- Assembly bonding and joint bonding
- Bonding of structural components
- Bonding of pilaster strips and ledges
- Post-forming, (see our separate data sheet 347.0 for post-forming)

Advantages

- Short setting time with cold and hot bonding up to 90° C
- Short open time, the glue is intended for fast press processing
- High yield

Properties of the bond

- High bond strength according to DIN EN 205
- Very high moisture resistance
- Tough-elastic glue film, gives a good tool life
- Transparent glue film

Properties of the glue

Base:	PVAC dispersion
Specific weight:	approx. 1.08 g/cm ³
ph-value:	approx. 5
Colour:	white, transparent when dry
Viscosity at 20° C	
- Brookfield RVT, spindle 6/20 rpm:	14.000 +/- 2.000 mPa·s
Consistency:	high viscosity, good application properties, also with machines
Open time:	approx. 3 minutes
Chalk point:	12° C
Identification:	identification not required according to German regulation GefStoffV (see our safety data sheet)

Application methods

- Manually with paint brush, spatula, glue roller and spray bottle
- Nozzle application device out of a pressurised container
- Glue applicator, (2 and 4 roller)

Application techniques

The materials to be bonded must be free from dust, oil and grease and acclimatized. The most favourable working temperature is at 18-20° C. The best moisture content of the wood is 8-12 %, max. 15 %. Do not process below 15° C.

Application quantity: 100-110 g/m² when applied by machine up to approx. 150 g/m² when applied with manual glueing devices

Open time: about 3 minutes. The open time is influenced by the quantity applied, the absorbability of the substrates, the moisture content of the wood, the humidity of the air and the temperature.

Press times:

- joint bonding (20° C) 3-5 minutes
- joint bonding, pre-heated on one side (70° C) 1-2 minutes
- bonding of structural components (20° C) 4-5 minutes
- bonding of veneer edges (80° C) 1-1.5 minutes
- bonding of ledges (20° C) 1-3 minutes
- surface bonding, (HPL-boards) (20° C) 4-5 minutes
- surface bonding, (HPL-boards) (50° C) 1-2 minutes
- surface bonding, (HPL-boards) (60° C) ≥ 1 minute

Heating accelerates the setting process considerably. In case of short press times, please wait some time before further processing of the parts. Pay attention to a good joint fit.

This data provides only an approximate value and is given without obligation. It is based on a moisture content of the wood of approx. 10 % and an application quantity of glue of 100 g/m².

As the different bonding processes are influenced by various factors, exact press times must be determined your own trials to be carried out in your factory.

Cleaning

Machines, application devices and glue containers can be cleaned with water.

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Packaging

KLEIBERIT Tempo 347.0:

- plastic pail, 32 kg net
- plastic barrel, 130 kg net
- disposable container, approx. 1000 kg net

Storage

KLEIBERIT Tempo 347.0 can be stored at 20°C for approx. 1 year in factory sealed containers. Due to its special field of application, it is recommended that the glue be protected from frost.

EX1298, 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.