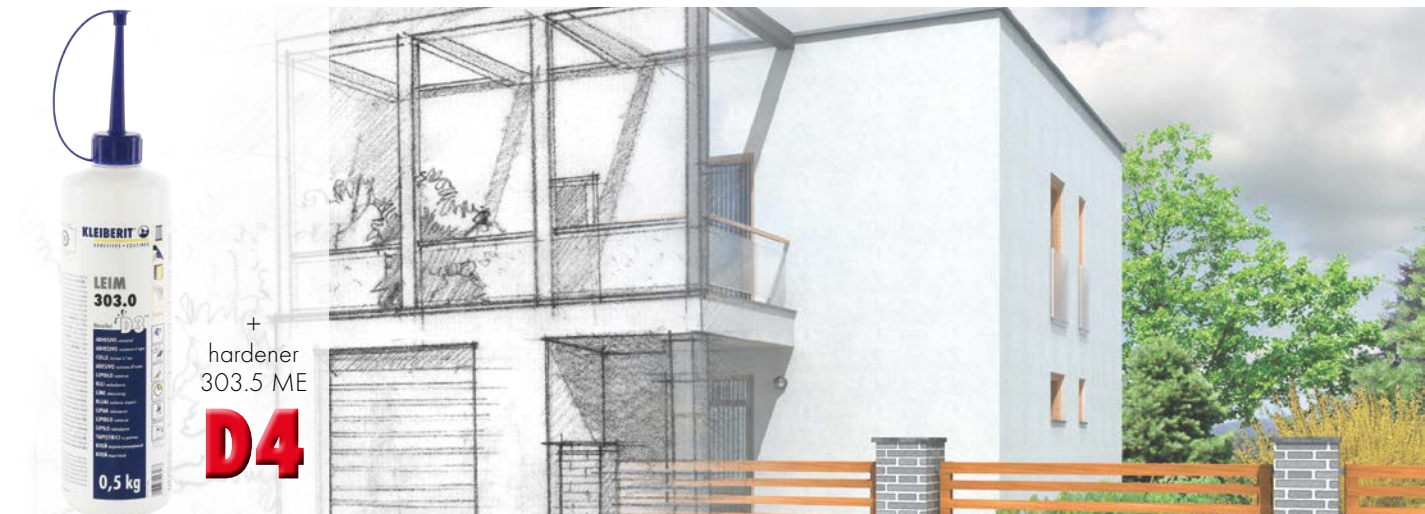


## KLEIBERIT 303.0 PVAC GLUE



### FOR WATER-RESISTANT BONDING

PVAc glues are widely used for processing wood and wood-based materials and have a long tradition. They have thus been the benchmark for all other adhesive system for decades. They are easy to process and application equipment can easily be cleaned of glue residues. Even excess glue residues can be removed from workpieces relatively easily. The stress group that the glue has to meet depends on whether it is used indoors or outdoors.

KLEIBERIT 303.0 is the waterproof PVAC adhesive for gluing according to DIN/EN 204 stress group D3, which has been tried and tested millions of times. By adding 5% KLEIBERIT 303.5 ME hardener, an even higher performance D4 glue can be produced.

#### FIELDS OF APPLICATION

- Bonding of windows and doors
- Stair construction
- Bonding in shipbuilding
- Surface bonding of wood-based panels (e.g. HPL, CPL, etc.)
- General construction bonding (e.g. slot and tenon, finger joints, etc.)
- Suitable for hard and exotic timbers
- Suitable for high frequency bonding
- Very well suited for **Minergie-ECO** and **1st priority ecoBKP**

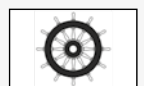


#### ADVANTAGES

- 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

#### KLEIBERIT 303.0 IMO CERTIFIED

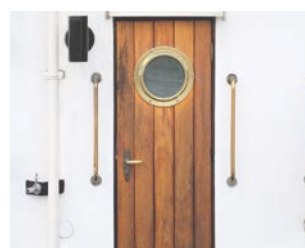
- Bonding in shipbuilding  
Approval no: 118.225-03  
Certified application quantity: 150 g/m<sup>2</sup>



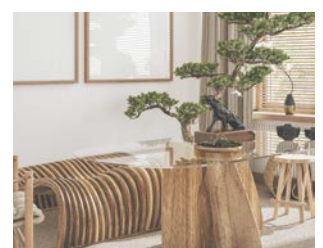
window production



stair construction



shipbuilding



construction bonding

### PROPERTIES OF THE GLUE

- Base: PVAc dispersion
- Mixing ratio (weight or volume): comp. A : comp. B = 20 : 1 corresponds to 5% hardener addition
- Density: comp. A = ca. 1.10 g/cm<sup>3</sup>  
comp. B = ca. 1.13 g/cm<sup>3</sup>
- pH-value: approx. 3
- Colour of the glue: white
- Consistency: medium viscosity
- Viscosity at 20 °C: 12,000 ± 2,000 mPa·s (Brookfield Sp. 6/20 Upm)
- Pot life: with hardener approx. 24 hours
- Open time (at 20 °C): 6-10 min (without hardener)
- Chalk point: approx. +5 °C

**By adding of 5% hardener KLEIBERIT 303.5 ME 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.

### PROPERTIES OF THE BOND

- KLEIBERIT 303.0, as a one component glue, meets the requirements of stress group D3 according to DIN/EN 204 (i.f.t. certificate no. 18-002518-PRO1 vom 05.10.2018)
- As a two component glue with 5% KLEIBERIT 303.5, meets the requirements of stress group D4 (i.f.t.-Prüfbericht Nr. 21-004681-PRO1 dated 11.02.2022)
- KLEIBERIT 303.0 tested according to EN 14257 (WATT 91) (KLEIBERIT 303.0: i.f.t. test certificate no. 18-002518-PRO2 vom 05.10.2018, KLEIBERIT 303.0 + 303.5 ME: i.f.t. test certificate no. 21-004681-PRO2 dated 14.02.2022)
- 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>

### 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

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

### PRESS TIMES

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

**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.

For further information, please refer to our technical data sheet.