



Klebit 303

Used successfully by over a million people for water resistant bonding.

Bonding quality:

- 303: Type (EN 204 D3)
- 303 + 5 % hardener 303.5: Type 1 (EN 204 D4)

Fields of application

- Bonding of windows and doors
- Surface bonding of partitions and parts
- Bonding of hard and exotic timbers
- Bonding of laminates
- Bonding of tenon and finger-joints
- High frequency, (20,000kHz), bonding
- Partition construction

Advantages

- Single component glue - no mixing necessary
- Two component glue - for high demands
- Suitable for hot and cold bonding
- Short press times

Properties of the bond

- KLEBIT 303 as a one component glue yields a Type 2 (EN 204 D3) bond quality 91 (see test report 505 21571/1 i.f.t. Rosenheim dated 13.7.99)
- with 5% KLEIBERIT Turbo-Hardener 303.5 it is a two component system having a Type 1 (EN 204 D4) bond quality. (see test report 505 21571/2 i.f.t. Rosenheim dated 13.7.99)
- Meets the requirements of Watt 91 (see test report 505 20756 U i.f.t. Rosenheim dated 17.6.98)
- High bond strength even with hard and exotic timbers
- Glue line (single component): tough elastic, colourless
- Glue line (two components), tough elastic, yellowish

Application methods

- Brush, spatula or glue roller
- Gluing devices fitted to frame presses and dove-tailing machines
- Glue spreaders

Properties of the glue

Base:	PVAC dispersion
Mixing ratio:	Comp. A:Comp.B = 20 : 1
(weight or volume):	(5 % hardener addition)
Specific gravity:	
Comp. A	approx. 1.10 g/cm ³
Comp. B	approx. 1.13 g/cm ³
pH-value, (w/o hardener):	approx. 3.0
Colour:	white
Colour of 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 hrs with hardener
Open time (at 20°C):	6-10 minutes
Chalk point:	approx. +5°C
Identification:	Glue: Identification not required according to German regulation GefStoffV (see our safety data sheet). Turbo-Hardener: Identification required according to German regulation GefStoffV. Contains Isocyanates. Protect hands and eyes! Wash off with water immediately upon contact, (see safety data sheet)

Application techniques

The materials to be glued must be free from dust, oil and grease and be acclimatised. The best working temperature is between 18-20°C, the best 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!



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Application quantity: 120-200 g/m²

Open time: 6-10 min.

Pot life:

approx. 24 hours. Stir in the hardener thoroughly until a good mix is achieved. After the pot life the rest may be used as a Type 2 (EN 204 D3) glue or mixed again with 5 % KLEIBERIT Turbo-Hardener 303.5 to gain a Type 1 (EN 204 D4) bond quality.

Pressure:

0,7-1,0 N/mm² with bonding of laminated plastics and laminated wood

Pressing times:

joint bonding (20°C)	15 min.
joint bonding (pre-heated) (50°C)	5 min.
joint bonding (80°C)	2 min.
surface bonding (HPL-boards) (20°C)	15-20 min.
surface bonding (HPL-boards) (50°C)	5 min.
surface bonding (HPL-boards) (80°C)	1-2 min.

When used as a two component glue, the times given should be extended by approx. 50 %. A slight foaming of the mixture does not affect the glue quality and can be eliminated by stirring.

Windows and similar frame constructions may be removed from the press immediately after temporary fastening with nails. The final bond strength according to the stressing groups according to ASTM for Type 1 or Type 2 (EN 204 D3 or D4) will be achieved after approximately 7 days.

Cleaning

Application devices and machines can be cleaned with water.

Packaging

KLEIBERIT Klebit 303:

box of 12 plastic bottles each with 500 g plastic pail, 4.5 kg/ 10 kg / 28 kg net drums, 220 kg net

KLEBIT Turbo Hardener 303.5:

bottles 0,5 kg / 0,7 kg net
canister 25 kg net
measuring cup for Component B is included.

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 warm up to room temperature and stir.

EX 1001

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.