

# KLEIBERIT 303.7

## Water resistant PVAC glue

Adhesive for waterproof gluing according to DIN EN 204, stress group D3/D4 (with hardener)

### 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

### 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 glue

<b>Base:</b>	PVAC dispersion
<b>Mix ratio:</b> (weight or volume)	Comp. A:Comp.B = 20:1 5% hardener addition
<b>Specific gravity:</b>	
Comp. A	approx. 1.10 g/ cm <sup>3</sup>
Comp. B	approx. 1.13 g/ cm <sup>3</sup>
<b>pH-value (w/o hardener):</b>	approx. 3.0
<b>Colour:</b>	white
<b>Consistency:</b>	medium viscosity
<b>Viscosity at 20°C</b> -Brookfield RVT spindle 6/20 rpm:	12,000 ± 2,000 mPa s
<b>Pot life:</b>	approx. 24 hours with hardener
<b>Open time (at 20°C):</b>	6 – 10 minutes
<b>Chalk point:</b>	approx. +5° C

**Identification KLEIBERIT 303.7:**  
see our safety data sheet.

**Identification KLEIBERIT 303.5 ME:**  
see our safety data sheet.

### Properties of the bond

- KLEIBERIT 303.7, as a one component glue, meets the requirements of stress group D3 according to DIN/EN 204.
- As a two component glue with 5% KLEIBERIT 303.5, meets the requirements of stress group D4 AIDIMME test certificate n. 221.C.2301.054.DE.01 from 24/01/2023
- KLEIBERIT 303.7 tested according to WATT 91  
KLEIBERIT 303.7 + 303.5 ME: AIDIMME test certificate n. 221.C.2301.054.DE.01
- High bond strength, even with hard and exotic timbers
- Glue line (single component): tough elastic, colourless
- Glue line (two component): tough elastic, light yellowish

### 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!

## KLEIBERIT 303.7

<b>Application quantity:</b>	100 -130 g/m <sup>2</sup> for veneer. 150 - 200 g/m <sup>2</sup> for solid wood The application quantity depends on the structure of the surfaces and the application devices used.
<b>Open time:</b>	6 - 10 min. The open time is influenced by application quantity, absorbability of the materials, moisture content of wood and air and the temperature.
<b>Pot life:</b>	approx. 24 hours
<b>Pressure:</b>	0.7 – 1 Nmm <sup>2</sup> when bonding lamella or laminated wood

**Press times:**  
Joint bonding (20°C) from 15 minutes

Joint bonding  
Preheated (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  
HPL panels (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 %.

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 303.7:

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 303.5 ME:

carton containing 12 metal bottles at 0.5 kg net each

Measuring cup 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 bring up to room temperature and stir well.

Version 02/05/2023 xi; replaces previous versions

#### Disposal of containers and contents

**Waste disposal key glue 080410**

**Waste disposal key hardener 080501**

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.