

Assembly Glue 305.0

High quality synthetic resin dispersion glue for universal application

Fields of application

- Assembly bonding
- Frame bonding
- Bonding of laminates
- Bonding in high frequency fields
- Core production
- Veneer joint bonding
- Joint and frame bonding of hard and soft textured woods

Advantages

- High green strength, therefore short pressing times possible
- Favourable open time
- Short setting times with cold and hot bonding
- Good application properties with machines and hand-gluing devices

Properties of the bond

- Good moisture resistance according to DIN EN 204, bond quality D2 (test no. 505 20968 M dated 14.08.1998 from "Fensterinstitut Rosenheim")
- Very high bond strength according to DIN/EN 205
- Tough-elastic glue film that gives a good tool life

Properties of the glue

Base:	PVAC dispersion
Specific gravity:	approx. 1.20 g/cm ³
PH-value:	approx. 7
Colour:	beige
Viscosity at 20°C	
Brookfield RVT spindle 6/20 rpm:	10,000 ± 2,000 mPa s
Consistency:	medium viscosity, good processing properties
Chalk point:	+5°C
Open time:	approx. 10 minutes
Identification:	not required according to the German hazardous substances regulations GefStoffV (see our safety data sheet)

Application methods

- With brush and toothed spatula
- With manual gluing devices (e. g. pressure chamber and pistol)
- With glue spreading machines (2- and 4-roller-systems)

Application techniques

The materials to be bonded must be dry, free from dust, oil and grease and acclimatised.

Moisture content of the wood 8-12 %.

The most favourable processing temperature is at 18-20° C.

Do not process below +10° C.

KLEIBERIT Assembly Glue 305.0 is ready to use. Thinning and addition of fillers alter the glue.

Application quantity:

- 100-150 g/m² when applied with machine
- 150-200 g/m² when applied with manual gluing device

Open time: approx. 10 minutes

The open time is influenced by the quantity applied, the absorption properties of the substrates, the moisture content of the wood, the humidity of the air and the temperature.

Pressure: min. 0.3 N/mm²

Pressing times:

Application	Temp.	Press Time
board joint bonding	20° C	8-12 min.
board joint bonding (preheated on one side)	80° C	3- 5 min.
board joint bonding (in high frequency field)		20-25 sec.
bonding of structural components	20° C	10-12 min.
veneer bonding	20° C	12-15 min.
veneer bonding	80° C	3- 5 min.
surface bonding (HPL-boards)	20° C	20-25 min.
surface bonding (HPL-boards)	50° C	8-10 min.

These guidelines are given without obligation; they are based on bonding wood with a 10 % moisture content. As the different bonding processes are influenced by various factors, exact times must be determined by own trials to be carried out in your factory.

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Cleaning

Machines, applicators and adhesive containers can be cleaned with water.

Packaging

KLEIBERIT Assembly Glue 305.0:

- carton of 12 squeeze bottles, 500 g net each
- plastic pail, 10 kg net
- plastic pail, 33 kg net
- other sizes on request

Storage

KLEIBERIT Assembly Glue 305.0 can be stored in factory-sealed containers at a temperature of 20° C for approx. 1 year. The frost resistance during transport is -15° C.

Bring carefully up to room temperature (20°C) and stir before use.

EX1109; replaces previous versions

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.