

Windows, doors and laminate boards



KLEIBERIT has reacted to the requirements of the market with new products and developments for all 3 adhesive systems

KLEIBERIT 303.0

Universal usable dispersion based on PVAC for window corner bonds and laminate boards.

- 1 component
- High water resistance with test certificate D3 in accordance to DIN/EN 204
- With hardener bond quality D4 in accordance to DIN/EN 204
- High temperature resistance in accordance to DIN/EN 14257 > 7 N/mm²
- Very high frequency bond
- Colourless glue line
- Good relationship between open time and press time
- No loss of adhesive

The adhesive can be used for bond quality D3 after the end of the pot life when mixed with **hardener 303.5**. Adding additional hardener will achieve bond quality D4.

KLEIBERIT 303.3

Dispersion on PVAC basis for bonding of solid timber.

- Joint filling characteristics
- Tolerance adapting
- Bond quality D3



ADHESIVES

In the production of windows and doors made from solid wood the adhesives have gained more and more importance when using European as well as Asian timber. In general the following bond qualities are required:

- Water resistance D3 or D4 in accordance to DIN/EN 204
- High temperature resistance tested in accordance to DIN/EN 14257: with a recommended minimum value of > 7 N/mm²

To achieve these requirements the following adhesive systems are required:

- PVAC-dispersions (with or without hardener)
- PVAC-copolymer dispersion - without hardener - with hardener also called EPI systems
- 1C PUR adhesive

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KLEIBERIT 304.4 EPI

2C dispersion adhesive on PVAC-copolymer basis to produce high quality bonds of local and exotic timber

- High water resistance D4 in accordance to DIN/EN 204
- Exceptionally high temperature resistance in accordance to DIN/EN 14257 > 12 N/mm²
- Applied via 2C mixer and dosing applicators
- Accurate dosing
- Good mixing with appropriate hardener

KLEIBERIT 304.1

2C PVAC dispersion for the production of window edges, window corners and laminate boards.

- High water resistance D4 in accordance to DIN/EN 204
- Very high temperature resistance in accordance to DIN/EN 14257 > 8 N/mm²
- Very high frequency bond
- Long pot life, several days

- various open times available
- High temperature resistance in accordance to DIN/EN 14257 > 9,5 N/mm²
- Joint filling

KLEIBERIT 502.8

Is an adhesive with a very short open time for high quality solid timber bonds in the window and door manufacturing industry.

- Very high water and humidity resistance
- Very fast cross linking
- Low viscosity of optimal adhesive application

KLEIBERIT 568.0 / KLEIBERIT 569.0

1C PUR construction adhesive for different materials such as wood, plastics, metal and mineral materials

- Extreme high bond strength
- Water resistance D4 in accordance to DIN/EN 204
- High fill volume
- Short open time
- Short press time

1C PUR adhesive

1C PUR adhesive are used for highest quality requirements. It is a water free adhesive system, a chemical cross linking is achieved by the aid of the substrate or ambient humidity. 1C PUR adhesives can be used in a wide variety of different production processes for example through adjusting of the open time.

KLEIBERIT 501.0

Tried and tested for over 10 years. For strong bonds, suitable for a wide variety of applications.

- High water resistance D4 in accordance to DIN/EN 204 with test certificate
- Excellent bond to many exotic timbers



KLEIBERIT windows and doors

Basis	KLEIBERIT Product	Hardener	Viscosity [mPa·s]	Open time min [20 °C]	Pot life	Bond quality		Properties
						DIN/EN 204	DIN/EN 14257	
PVAC Copolymers	KLEIBERIT 303.0	–	13.000	6-10	–	D3	> 7 N/mm ²	1 component; high water resistance with test certificate D3 in accordance to DIN/EN 204; no adhesive loss, high temperature resistance in accordance to DIN/EN 14257 > 7 N/mm ² excellent high frequency bond; colourless glue joint, good relationship between open time and press time.
	KLEIBERIT 303.0+303.5	5 %	13.000	6-10	24 h	D4	> 7 N/mm ²	
	KLEIBERIT 303.3	–	20.000	6-10	–	D3	> 7 N/mm ²	Bond quality D3; joint filling, tolerance regulating
	KLEIBERIT 304.1+304.3	5 %	10.000	4-6	4-7 days	D4	> 8 N/mm ²	High water resistance D4 in accordance to DIN/EN 204; very high temperature resistance in accordance to DIN/EN 14257 > 8 N/mm ² ; excellent high frequency bond; long pot life, several days
EPI	KLEIBERIT 304.4+808.0	15 %	9.000	8-9	60 min	D4	> 12 N/mm ²	High water resistance D4 in accordance DIN/EN 204 - DIN/EN 14257: 12,6 N/mm ² ; application with 2C mixing and dosing devices: accurate metering; good mixing ratio with the hardeners
	KLEIBERIT 304.5+808.2	15 %	9.000	8-10	30 min	D4	> 11 N/mm ²	
1C PUR	KLEIBERIT 501.0	–	7.500	20-25	–	D4	> 9 N/mm ²	High water resistance D4 in accordance to DIN/EN 204; excellent bond to many exotic timber, joint filling
	KLEIBERIT 501.6	–	7.000	70	–	D4	> 8 N/mm ²	Very long open time, up to 70 mins; high water resistance D4 in accordance DIN/EN 204; low viscosity for optimal adhesive application
	KLEIBERIT 501.8	–	7.000	approx. 8	–	D4	> 11 N/mm ²	High water resistance D4 in accordance to DIN/EN 204; excellent bond to many exotic timber, joint filling; short open time
	KLEIBERIT 501.9	–	8.000	13-14	–	D4	> 8 N/mm ²	High water resistance D4 in accordance to DIN/EN 204; excellent bond to many exotic timber, joint filling; short open time
	KLEIBERIT 502.8	–	6.000	6-8	–	D3	no proof	Very high water and moisture resistance; very fast curing; low viscosity for optimal adhesive application
	KLEIBERIT 506.0	–	1600	20-30	–	D4	> 12 N/mm ²	Very low viscous; high water resistance; 1 C PUR adhesive; open time and press time depend on press technology
	KLEIBERIT 568.0	–	posty	5	–	D4	> 9 N/mm ²	Extreme high bond strength; high water resistance D4 in accordance to DIN/EN 204; high filling volume; short open time; short press time
	KLEIBERIT 569.0	–	thixotropic	10	–	D4	> 9 N/mm ²	Extreme high bond strength; high water resistance D4 in accordance to DIN/EN 204; high filling volume; short open time; short press time