

Water Resistant Bonding

with KLEIBERIT Adhesives



Surface and joint bonding | Profile wrapping | Edge banding



Water Resistant Bonding with KLEIBERIT Adhesives



Surface and joint bonding

KLEIBERIT 303.0

gluing qualities:

D3 according to DIN EN 204

D4 according to DIN EN 204 with hardener KLEIBERIT 303.5

WATT 91 (DIN EN 14257) > 7 N/mm²

application methods:

brush, glue roller, trowel, roller, nozzle system

Base:	PVAC dispersion
Density:	approx. 1.1 g/cm ³
Colour:	white
Viscosity at 20°C	
(Brookfield Sp. 6/20 Upm):	12,000 ± 2,000 mPa·s
Pot life:	with 5% KLEIBERIT 303.5 approx. 24 hours
Open time at 20°C:	6 - 10 minutes

KLEIBERIT 304.4

gluing qualities:

D4 according to DIN EN 204 with hardener KLEIBERIT 808.0

WATT 91 (DIN EN 14257) > 7 N/mm²

application methods:

brush, glue roller, trowel, roller, nozzle system

Base:	polymer dispersion
Density:	approx. 1.3 g/cm ³
Colour:	brown
Viscosity at 20°C	
(Brookfield Sp. 6/20 Upm):	7,000 ± 1,500 mPa·s
Open time at 20°C:	20 - 25 minutes

KLEIBERIT 501.0

gluing qualities:

D4 according to DIN EN 204

WATT 91 (DIN EN 14257) > 7 N/mm²

application methods:

brush, glue roller, trowel, roller, nozzle system

Base:	polyurethane
Density:	approx. 1.3 g/cm ³
Colour:	brown
Viscosity at 20°C	
(Brookfield Sp. 6/20 Upm):	7,000 ± 1,500 mPa·s
Open time at 20°C:	20 - 25 minutes

KLEIBERIT 510.3.30

gluing qualities:

D4 according to DIN EN 204

WATT 91 (DIN EN 14257) > 7 N/mm²

application methods:

brush, glue roller, trowel, roller, nozzle system

Base:	polyurethane
Density:	approx. 1.13 g/cm ³
Colour:	vanilla
Viscosity at 20°C	
(Brookfield Sp. 4/20 Upm):	approx. 18,500 mPa·s
Open time at 20°C:	20 - 25 minutes



accoya® and tricoya® are registered trademarks of Accsys Technologies PLC. Both are highly resistant, chemically modified materials for durable, dimensionally stable end products, suitable for outdoor use. accoya® stands for refined solid wood, mostly used as profile materials. tricoya® stands for refined wood fiber materials, mostly used in form of board materials. Longevity is achieved by modifying the naturally grown wood, usually a wood species with little resistance, through acetylation so that the molecular structure of the previously hygroscopic material is changed in such a way that moisture absorption and moisture binding is greatly reduced. As a rule, the acetylation of wood is achieved by impregnation with an acetic anhydride solution. This causes the hygroscopic hydroxyl groups of the wood cell walls to be esterified. The original hygroscopicity or moisture absorption and moisture binding is thus considerably reduced. Infestation by microorganisms can also be excluded.

The KLEIBERIT adhesives listed in this product brochure have been extensively tested for their suitability for both materials. They have in-house test certificates as well as performance certificates from independent, renowned testing institutes. Besides chemically reactive polyurethane adhesives, a selected PVAC dispersion and an EPI system are available. The processing of both adhesives, which are liquid in the processing state, is similar to the known solid wood gluing processes. Due to the modified water absorption capacity of accoya® and tricoya®, slightly longer pressing times may be necessary. If, on the other hand, a moisture-reactive PUR adhesive is chosen, whether in the form of a liquid prepolymer or as a hotmelt, the addition of moisture may be required for the usual quick setting reaction due to the low to non-existent moisture on the surface of the acetylated material. The optimal processing conditions when using accoya® and tricoya® have to be determined in the form of test runs, as with all other materials that undergo a bonding process. The advantages offered by these wood-based materials quickly outweigh the test effort.

KLEIBERIT 706.0.09

gluing qualities:
 highly heat resistant, watertight, extremely cold resistant and durable bond is attained

application methods:
 roller, slot nozzle

Base:	polyurethane
Density:	approx. 1.10 g/cm ³
Colour:	milky white
Auftragstemperatur:	120°C
Viscosity at 20°C	
(Brookfield HBTD 10 Upm):	120 °C: 12,000 mPa·s ± 3,000 mPa·s
	140 °C: 6,000 mPa·s ± 2,000 mPa·s
Open time:	1 - 3 minutes

KLEIBERIT 706.1.50 ME

gluing qualities:
 highly heat resistant, watertight, extremely cold resistant and durable bond is attained; IMO FTP Code part 5

application methods:
 roller, slot nozzle

Base:	polyurethane
Density:	approx. 1.10 g/cm ³
Colour:	yellowish
Auftragstemperatur:	120-130 °C
Viscosity at 20°C/40% RH	
(Brookfield HBTD 10 Upm):	120 °C: 18,000 mPa·s ± 4,000 mPa·s
	140 °C: 9,000 mPa·s ± 2,000 mPa·s
Open time:	< 8 minutes

Edge banding

KLEIBERIT 707.9.40

gluing qualities:
highly heat and moisture resistant when using suitable plastic edges
(e.g. ABS, PP, PVC, etc.)

application methods:
roller, slot nozzle

Base: polyurethane
Density: approx. 1.10 g/cm³
Colour: ivory
Application temperature: 120°C -140°C
Viscosity
(Brookfield HBTD 10 Upm): 140 °C: approx. 35,000 mPas

KLEIBERIT 707.9.58

gluing qualities:
highly heat and moisture resistant when using suitable plastic edges
(e.g. ABS, PMMA, PP, PVC, etc.)

application methods:
roller, slot nozzle

Base: polyurethane
Density: approx. 1.10 g/cm³
Colour: ivory
Application temperature: 140°C -160°C
Viscosity
(Brookfield HBTD 10 Upm): 140 °C: approx. 80,000 mPas
160 °C: approx. 45,000 mPas

Profile wrapping

KLEIBERIT 704.6

gluing qualities:
weather-resistant, if plastic films suitable for outdoor use are used

application methods:
slot nozzle

Base: polyurethane
Density: approx. 1.10 g/cm³
Colour: transparent
Application temperature: 120°C -140°C
Viscosity
(Brookfield HBTD 10 Upm): 120 °C: approx. 60,000 mPas
140 °C: approx. 35,000 mPas

Would you like expert advice or do you need more detailed information? Contact us directly by email, phone or visit our website.

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