

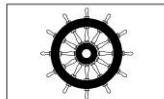
# KLEIBERIT 332.0

## PVAC-Adhesive

### Fields of application

- Surface bonding of laminates (HPL-boards), workboard tops and MDF boards
- Veneer bonding to chip board and laminated plywood
- KLEIBERIT 332.0 complies with IMO FTP-Code Part 5 & Part 2. Approval according to test certificate BG Verkehr (department maritime safety) for international use according to Module B)

Approval No.: 118285-02  
 Certified application quantity:  
 150 g/m<sup>2</sup>



### Advantages

- Single component glue - therefore no mixing and dosing problems
- No pot life problems
- Long open time
- Very good application properties with glue application machines and hand gluers
- Easy cleaning of the application devices

### Properties of the bond

- Secure bonding of all kinds of veneers
- Good moisture resistance - bond quality D2 according to DIN/EN 204
- Tough-elastic glue film, gives a good tool life

### Properties of the glue

Base:	PVAC dispersion
Delivery form:	liquid, ready to use
Specific weight:	approx. 1.1 g/cm <sup>3</sup>
ph-value:	approx. 5
Colour:	beige
<b>Viscosity at 20°C</b>	
<b>Brookfield RVT</b>	
<b>spindle 6/20 rpm:</b>	8,000 ± 2,000 mPa s
<b>Consistency:</b>	medium viscosity, well applicable
<b>Open time at 20° C:</b>	20 - 25 minutes
<b>Chalk point:</b>	+5 °C
<b>Identification:</b>	see our safety data sheet

### Application methods

- With paint brush or spatula
- With manual glueing devices
- With glue application machines

### Application techniques

KLEIBERIT 332.0 is ready for use; simply stir the glue after a long storage time. Good processing properties - no tendency to bleed through if applied sparingly. The materials to be bonded must be free from dust, oil and grease and be acclimatized. The best working temperature is at 18 – 20 °C. The moisture content of the wood ranges between 8 and 12 %. Do not process below +10 °C! KLEIBERIT 332.0 is ready to use; thinning and the addition of fillers alter the glue.

### Application quantity:

80 - 100 g/m<sup>2</sup> when applied mechanically  
 approx. 150 g/m<sup>2</sup> when applied manually  
 depending on the surface quality and absorbability  
 of the substrate.

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**Open time:** up to 25 minutes  
 The open time is influenced by the quantity applied, the absorbability of the substrate, the moisture content of the wood, the humidity of the air and the temperature.

**The higher the room temperature, the shorter the open time.** If a longer open time is required, slightly increase the application quantity but avoid bleed-throughs.

**Stack time:**  
 Do not exceed 2 minutes in order to avoid visible joints at higher application quantities and subsequent higher press temperatures. **The higher the press temperature, the shorter the stack time!**

**Pressure:** 0.2 - 0.5 N/mm<sup>2</sup>

## Press times veneer bonding:

Press Temperature (° C)	Base Time (minutes)	Final Heating Time (min./mm veneer thickness)
20	from 20	-
50	8	2
60	6	2
70	5	1

The total press time consists of the base time and the final heating time.  
 The values indicated are guiding values which may vary slightly depending on the absorbability of the substrates and the application quantity.  
 The exact values should be established in your own factory.  
 Feeding of exceptionally long parts into the press, i. e. pressing staggered, is possible within the open time indicated.

**A waiting period of 24 hours between pressing and subsequent treatment of the surfaces should be observed.**

**Press times for surface lamination:**  
 HPL boards (20 °C) longer than 25 minutes  
 HPL boards (50 °C) longer than 10 minutes

This data is given without obligation and serves as guideline, based on a moisture content of the wood of approx. 10 %. The different bonding processes are influenced by various factors, the exact times must be determined by trials to be carried out in your own factory.

## Cleaning

Application devices, machines and containers can be cleaned with water.

## Packaging

plastic pail, 10 kg net  
 plastic pail, 30 kg net  
 one-way barrel, 130 kg net  
 one-way container, 1,000 kg net

Additional packaging sizes available upon request.

## Storage

KLEIBERIT 332.0 can be stored at 20 °C in factory sealed containers for approx. 1 year.  
 The glue is frost resistant down to -30 °C.  
 Before use bring carefully up to room temperature and stir well.

Version 12.12.25 Iz; 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.