

# KLEIBERIT 304.4

## EPI-System

### Fields of application:

- Window, door, bonded wood panel and element production, garden furniture and decking from coniferous deciduous and exotic woods

### Types of gluing

- Warm, cold and high-frequency bonding of dovetail, tenon and similar joints and general board joints

### Properties of the bond:

- KLEIBERIT 304.4 with KLEIBERIT 808.0 hardener corresponds to DIN EN 204, stress group D4  
-see i.f.t. test report no.20-004459-PR01 from December 14th, 2020
- KLEIBERIT 304.4 with KLEIBERIT 808.0 hardener tested according to WATT 91  
- see i.f.t. test report No. 20-004459-PR02 from December 14th, 2020
- KLEIBERIT 304.4 with KLEIBERIT 808.0 meets the requirements according to BRL 2339 for bonding layers for scantling manufacturing for non-load bearing applications of the wood types spruce, pine and larch.  
(Product certificate number 33331)
- Very high bond strength, also with hard and exotic woods
- Corresponds with JAIA F\*\*\*\*- Nr. 005693

### Properties:

**Base:** polymer dispersion  
**Addition of hardener:** 15 parts by weight of hardener KLEIBERIT 808.0 to 100 parts by weight KLEIBERIT 304.4

**Density of the mixture:** approx. 1.3 g/cm<sup>3</sup>

**ph-value of the mixture:** approx. 7

**Colour of the mixture:** cream coloured

**Consistency of the mixture:** medium viscosity

**Viscosity at 20°C (on the day of production)**

**Brookfield RVT sp.6/ 20 rpm:**  
**304.4:** 10.000 ± 2.000 mPa s

**Pot life (20°C):** approx. 60 minutes

**Chalk point:** + 1 °C

### Identification:

304.4: see our safety data sheet

808.0: see our safety data sheet

### Application tools:

- Manually, using a brush, spatula or glue roller
- Glue application machine
- Gluing assembly for tongue and groove joints

**Application devices must be made of V2A-steel or synthetic materials.**

### Application:

Stir KLEIBERIT 304.4 before use

#### Preparation of the adhesive:

**100 ppw 304.4 + 15 ppw 808.0**

For mixing purposes, use a hand drill or stirring device fitted with a stirring paddle or dispersion disc.

**It is not possible to use the adhesive without hardener.**

**Pot life (20°C): approx. 60 minutes**

Higher glue temperatures will shorten the pot life

**Application temperature: 18-20°C**

Do not process at temperatures below + 10°C

The materials to be bonded must be free of dust, oil and grease and acclimatised to the immediate surroundings.

# KLEIBERIT 304.4

## Wood moisture for window frame

production: 10 - 15 %

Wood moisture for interior use: 8 – 12 %

## Application quantity: 120 – 200 g/m²

In most cases single-sided glue application is sufficient. When working with hardwood or other types of wood which are more difficult to bond, application to both sides is recommended in order to improve the bonding strength. In this case, a longer open time is also achieved.

## Open time: 8 - 12 minutes

depending on applied amount and processing conditions

Pressure: 0,4 - 0,7 N/mm²

## Press times:

| Application   | Temp. | Press Time      |
|---------------|-------|-----------------|
| Joint bonding | 20°C  | from 45 minutes |
| Joint bonding | 30°C  | from 30 minutes |
| Joint bonding | 50°C  | from 20 minutes |

**Final setting time: approx. 90 minutes**

## General information:

The press times shown above can vary according to different room temperatures, air humidity and moisture of the wood, and also to the region of the world in which the trees were grown and felled. The bond will reach its final strength (to comply with DIN/EN 204) after 7 days storage at 20°C.

Avoid allowing the glued areas to be exposed to iron, as this could cause discolouration.

Wood and wood based materials are natural products. Natural differences in the characteristics may in rare cases cause discolouring, depending upon the areas in which the trees were grown.

## Cleaning:

Application devices, machines and containers can be cleaned with water as long as the glue is not cured.

## Packaging:

### KLEIBERIT 304.4:

plastic canister, 10,0 kg net  
 plastic pail, 10 kg net  
 plastic canister, 28,0 kg net  
 plastic pail, 28 kg net  
 plastic drum, 130 kg net  
 container, 1,000 g net

### KLEIBERIT 808.0 Hardener

plastic canister, 1.5 kg net  
 carton with 4 canisters at 1.5 kg net each  
 metal canister, 4.2 kg net  
 plastic canister, 28 kg net  
 metal drum, 250 kg net

Additional packaging available upon request.

## Storage:

Both components can be stored in factory sealed containers at 20°C for approx. 9 months.

The resistance to temperature during transport is approx. - 30°C.

Before use bring carefully up to room temperature (20°) and stir well.

Version 27.07.23 Iz; replaces previous versions

### Disposal of containers and contents

#### Waste disposal key 080410

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.