

KLEIBERIT 308.0

Aqueous adhesive for lacquered surfaces

Fields of application

Bonding of decorative mouldings, wood and wood based materials to

- DD-lacquers
- polyester surfaces
- acid-setting lacquers
- water based lacquers
- nitro lacquers
- melamine resin surfaces and decorative laminates

Bonding of structural components to melamine resin coated and lacquered surfaces.

Bonding on water based lacquers is only possible to a limited extent due to the number of water based lacquer formulas.

Advantages

- Single component glue
- No mixing necessary, no pot life problems
- Excellent adhesion without sanding
- Strength values above 10 N/mm² according to DIN EN 205 possible
- Can be processed in pressurized containers
- Tough-elastic glue film which gives a good tool life

Properties of the glue

Base: synthetic resin dispersion

Specific gravity at 20°C:

approx. 1.0 g/cm³

pH-value: 7,5 ± 0.5

Colour: beige

Consistency: medium viscosity

Viscosity at 20°C

Brookfield RVT,

Sp. 6/20 rpm: 13,000 ± 2,500 mPa·s

Open time at 20°C: 6 - 8 minutes

Chalk point: approx. +5°C

Identification: required according to EU regulations (see our safety data sheet)

Application techniques

When bonding lacquered or plastic surfaces, **one joint face must be absorbent.**

The materials to be bonded must be free from dust, oil and grease and be dry. Check for yourself if gluing of the material is possible.

The best working temperature is at 18 - 20°C.

Process neither material nor glue below +10°C.

Stir before use.

Single sided application is generally sufficient.

Double sided application is recommended for hardwood and exotic woods!

Application quantity: approx. 150 g/m²

The application quantity is dependent on the surface structure and the application unit used.

The glue can be applied with brush, spatula, nozzle applicators or directly from the squeeze bottle.

Open time at 20°C: 6 - 8 minutes

The open time is influenced by the application quantity, absorbability of the materials, temperature and the moisture content of the wood and air.

In order to achieve a good wetting, the glue line should be as moist as possible.

Press time: When bonding wood to wood: minimum 15 minutes.

If one joint face is not moisture absorbent, the setting process will be delayed considerably. Determine the exact time by your own trials. Pre-heating of one face accelerates the setting process. Apply pressure of minimum 0.2 N/mm². (clamping devices, presses)

Final strength is reached after 7 days.

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Important advice:

Due to the number of lacquers and plastics, it is recommended that tests be carried out as to the adhesion properties and durability of the materials in question to be glued.

Wood and wooden materials are natural products. Influenced by the region of the world from which they originate, as well as the differing pre-treatment methods to which they have been exposed, isolated cases of discolouration, (e.g. Birch, Cherry and Sugar Maple) can occur.

The same can happen when bonding wood which contains tannin (e.g. Oak) and when it makes contact with iron (due to an unsuitable pressing plant).

Cleaning

Machines and application tools can be cleaned with warm water.

Packaging

KLEIBERIT 308.0:

carton with 12 bottles of 0.5 kg net each
plastic pail, 9.5 kg net
plastic pail, 28 kg net

Additional packaging sizes available upon request.

Storage

KLEIBERIT 308.0 can be stored in factory sealed containers at 20°C for approx. 9 months.

Do not store below -5°C and above +40° C.

Version 15/07/2020xv; replaces previous versions

Adhesives and Waste Disposal

Waste Code 080409

Our containers are made of recyclable material. Well drained containers can be recycled.

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.