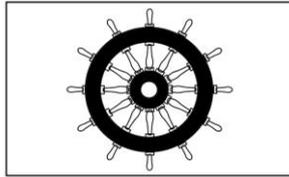


KLEIBERIT 347.0

Aqueous PVAC Adhesive

Fields of application

- Bonding of laminates in a short cycle press
- Bonding of edges (cold bonding or with heated band)
- Assembly bonding and joint bonding
- Bonding of structural components
- Bonding of pilaster strips and ledges
- Post-forming, (see our separate data sheet 347.0 for post-forming)
- Bonding in shipbuilding
KLEIBERIT 347.0 according to IMO FTP-Code Part 5 & Part 2/ approval according SeeBG (department vessel security) for international use according to Module B



Approval No.: 118286-02
 Certified application quantity: 155 g/m²

Advantages

- Short setting time with cold and hot bonding up to 90 °C
- Short open time, the glue is intended for fast press processing
- High yield

Properties of the bond

- Tough-elastic glue film, gives a good tool life
- Transparent glue film

Properties of the glue

Base:	PVAC dispersion
Specific weight:	approx. 1.08 g/cm ³
ph-value:	approx. 5
Colour:	white, transparent when dry
Viscosity at 20 °C	
- Brookfield RVT, spindle 6/20 rpm:	14.000 +/- 2.000 mPa·s
Consistency:	high viscosity, good application properties, also with machines
Open time:	approx. 3 minutes
Chalk point:	12°C
Identification:	identification required according to EU regulations (see our safety data sheet)

Application methods

- Manually with paint brush, spatula, glue roller and spray bottle
- Nozzle application device out of a pressurised container
- Glue applicator, (2 and 4 roller)

Application techniques

The materials to be bonded must be free from dust, oil and grease and acclimatized. The most favourable working temperature is at 18-20 °C. The best moisture content of the wood is 8-12 %, max. 15%. Do not process below 15 °C.

Application quantity:

100-110 g/m² when applied by machine
 up to approx. 150 g/m² when applied with manual gluing devices

Open time: about 3 minutes.

The open time is influenced by the quantity applied, the absorbability of the substrates, the moisture content of the wood, the humidity of the air and the temperature.

KLEIBERIT 347.0

Press times:

Application	Temp.	Press time
joint bonding	20 °C	3-5 minutes
joint bonding one sided	70 °C	1-2 minutes pre-heated
structural component bonding	20 °C	4-5 minutes
veneer edges bonding	80 °C	1-1.5 minutes
ledges bonding	20 °C	1-3 minutes
surface bonding (HPL-boards)	20 °C	4-5 minutes
surface bonding (HPL-boards)	50 °C	1-2 minutes
surface bonding (HPL-boards)	60 °C	approx. 1 minute

Heating accelerates the setting process considerably. In case of short press times, please wait some time before further processing of the parts. Pay attention to a good joint fit.

This data provides only an approximate value and is given without obligation. It is based on a moisture content of the wood of approx. 10 % and an application quantity of glue of 100 g/m².

As the different bonding processes are influenced by various factors, exact press times must be determined your own trials to be carried out in your factory.

Cleaning

Machines, application devices and glue containers can be cleaned with water.

Packaging

plastic pail, 10 kg net
 plastic pail, 32 kg net
 plastic canister, 5 kg net
 plastic canister, 22 kg net
 plastic barrel, 130 kg net
 disposable container, 1000 kg net

Additional packaging available upon request.

Storage

KLEIBERIT 347.0 can be stored at 20 °C for approx. 1 year in factory sealed containers.

The glue is frost resistant to -30 °C. However, due to its special field of application, it is recommended that the glue be protected from frost.

Bring to room temperature (20 °C) before use and still well.

Version 17/02/2023 al; replaces previous versions

Adhesive and Waste Disposal

Waste Code 080410

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.