

# KLEIBERIT 304.5

## 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 finger joints, tenons, board joints and lamination of window frames

### Properties of the bond:

- KLEIBERIT 304.5 with KLEIBERIT 808.0 hardener corresponds to DIN EN 204, stress group D4  
- see i.f.t. test report no.20-002110-PR01 from December 14th, 2020
- KLEIBERIT 304.5 with KLEIBERIT 808.0 hardener tested according to WATT 91  
- see i.f.t. test report No. 20-002110-PR02 from December 14th, 2020. Very high bond strength, also with hard and exotic woods.

### Properties of the adhesive:

**Base:** EPI system  
**Chalking point:** +1 °C  
**Viscosity at 20 °C**  
**Brookfield RVT sp.6/ 20 rpm:** 8,000 ± 2,000 mPa·s

### Properties of the mixture:

**Addition of hardener:** 10 parts by weight of KLEIBERIT hardener 808.0  
**Density, 20 °C:** approx. 1.3 g/cm<sup>3</sup>  
**ph-value:** approx. 7  
**Colour:** cream  
**Consistency** medium viscosity  
**Pot life (20 °C):** up to 120 mins  
**Identification:**  
 304.5: see our safety data sheet  
 808.0: see our safety data sheet

### Application tools:

- Manually, using a brush, spatula or glue roller
- Glue spreader
- Glue application devices for joints and tenons

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

### Preparation of the adhesive

304.5 + 10 parts by weight 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. 120 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.

**Wood moisture for window frame production: 10 - 15 %**

**Wood moisture for interior use: 8 – 12 %**

**Application quantity: 120 – 200 g/m<sup>2</sup>**

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 - 10 minutes**

depending on application amount and processing conditions

**Pressure: 0.4 – 0.7 N/mm<sup>2</sup>**

### Press times:

Application	Temperature	Press time
Joint bonding	20 °C	from 60 min
Joint bonding	30 °C	from 45 min
Joint bonding	50 °C	from 30 min

## KLEIBERIT 304.5

### 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.

### Packaging:

#### KLEIBERIT 304.5:

plastic canister, 5 kg net

plastic bucket, 28kg net

#### KLEIBERIT Hardener 808.0

plastic canister, 1.5 kg net

carton with 4 canisters, 1.5kg net each

metal canister, 4.2 kg net

plastic canister, 28 kg net

metal drum, 250 kg net

Additional packaging sizes 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. + 5 °C.

Protect from frost!

Version 02.02.2023 al; 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.