

KLEIBERIT 343.3

Formaldehyde free veneer adhesive

Field of use

- Veneer bonding on wood-based panels

Advantages

- Formaldehyde-free according to ISO 15373 method A
- Ready for use
- Discolouration free
- Suitable for hot and cold bonding
- Hard elastic adhesive joint
- No glue penetration through the veneer
- Moisture resistant
- After a hot pressing process (> 100°C), the bonds can be further processed immediately (surface treatment is possible just 24 hours after bonding)
- The composition of KLEIBERIT 343.3 complies with FDA Guideline 21CFR § 175.105
- **No VOC emission**

Properties of the adhesive

Base: Synthetic polymer
Density at 20 °C: approx. 1.10 g/cm³
pH-value: approx. 5
Colour of glue: beige
Consistency: medium viscous
Viscosity at 20 °C
- Brookfield RVT Sp 6/20 rpm: 14,500 ± 2,500 mPa·s
Chalk point: approx. +5°C

Identification:
 KLEIBERIT 343.3: see safety data sheet

Application methods

- Brush, spatula or glue roller
- Glue spreading machines

Application devices must be made from V2A steel or synthetic materials.

Application techniques

The materials to be glued must be free from dust, oil and grease, and be acclimatised.

The most favourable working temperature is 18 - 20 °C and the moisture content of the wood should range between 8 – 10 %.

Do not process below +10 °C!

Application quantity: 80 – 100 g/m²
 The optimum application quantity must be determined by the user by means of preliminary tests.

Open time: 5 – 8 min.
 The open time is influenced by the quantity of glue applied, absorbability of the materials, temperature and the moisture content of the wood and air.

Pressure: 0.25 – 0.5 N/mm²

Press times:
 Orientation for 0.6 mm thick veneer on chipboard with an adhesive application quantity of 80 g/m²:

Temperature	Press time
20 °C	from 10 minutes
100 °C	from 30 seconds
120 °C	from 25 seconds

Cleaning

Application devices, machines and containers can be cleaned with water

Packaging

KLEIBERIT 343.3:
 plastic canister, 10 kg net

Additional packaging sizes available upon request.

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Storage

KLEIBERIT 343.3 can be stored for approx. 12 months at 20 °C and in the original sealed container. Due to its special application, it is advised to protect the glue from frost.

Before use, gently warm to room temperature and stir well.

Version 08.05.2025 lz; replaces previous version

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.