KLEIBERIT®
ADHESIVES • COATINGS

PARQUET PRODUCTION AND INSTALLATION

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PRODUCTION OF 2-LAYER PARQUET

The production of two-layer parquet is usually carried out in automated production processes. The base layer of the parquet element fulfills purely structural purposes and can consist of solid strips or wood-based panels. The visible layer glued on top is then made of particularly high-quality wood. In addition to other types of adhesives, PUR hotmelt adhesives, which are applied to the top and bottom layers in bead form, are used in particular for excellent and long-lasting bonding results. Due to the bead shape, PUR hotmelts are able to compensate for tolerances.

For the production of 2-layer parquet, we offer our reactive PUR hotmelts in the 705 and 707 product series.

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ADVANTAGES

- Processing/bonding possible inline allowing pressing times in seconds
- Very high temperature and moisture resistance due to the chemical crosslinking process
- Flexible adhesive joint even after crosslinking (no creaking under load, etc.)
- High aging resistance

PRODUCTION OF 3-LAYER PARQUET

In 3-layer parquet production, three material layers are glued together to form a composite. However, since essentially flat materials are bonded together, adhesives should preferably be applied as a closed film. Melamine or urea resin adhesives are classic options for hot press processes. PVAc dispersions or EPI systems are also frequently used. However, modern system concepts rely on PUR hot melts, which can significantly reduce throughput times.

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ADHESIVES FOR LAYING PARQUET (FLOATING INSTALLATION)

In floating installation, the parquet floor is not glued to the subfloor, but laid loosely on the subfloor. The necessary stability is provided by the tongue and groove joints in the parquet elements, which in turn may be glued together. For a long-lasting and visually sophisticated installation of floating tongue and groove parquet, we offer a special adhesive. **KLEIBERIT 351.0** fulfills the stress group D3 according to DIN EN 204, is colorless and results in a hard-elastic glue line. The product has been popular with craftsmen and installers for decades.

FULL-SURFACE BONDING OF PARQUET FLOORING

When laying parquet flooring over the entire surface, it is important to work cleanly and use the right adhesive. Several factors determine the choice of the right parquet adhesive. In general, a distinction is made between absorbent and non-absorbent subfloors. True all-rounders are parquet adhesives based on STP - **KLEIBERIT 583.5** and **KLEIBERIT 583.9**. These adhere to almost all materials without pre-treatment and provide excellent results. They are easy to process and have impact sound absorbing properties. Furthermore, they are considered very low-emission according to GEV Emicode and have the EC 1 Plus seal of approval.

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FULL-SURFACE BONDING ON SCREED

Screed is considered an absorbent subfloor. For top results, the synthetic resin dispersion **KLEIBERIT 350.0** or the 2C PUR parquet adhesive system **KLEIBERIT 546.0** should be used. In some cases, sealing the screed provides even better results. For this purpose, the 1C PUR coating product **KLEIBERIT 555.2** should be used. It is even easier with our STP adhesives **KLEIBERIT 583.5** and **KLEIBERIT 583.9**. Pre-coating is usually not necessary with these products.

FULL-SURFACE BONDING ON WOOD

In some cases, the parquet is also bonded to wood-based panels, such as OSB or chipboard, over the entire surface. For this purpose, we offer synthetic resin dispersions, PUR systems, as well as low-emission STP systems. The choice of adhesive depends on the individual circumstances, requirements and personal preferences.

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FULL-SURFACE BONDING ON STONE

Stone and ceramics are either absorbent or non-absorbent, depending on their nature. With the right parquet adhesives, you can bond both types without any problems. Our 2C PUR parquet adhesive system **KLEIBERIT 546.0**, as well as our STP parquet adhesives **KLEIBERIT 583.5** and **KLEIBERIT 583.9** ensure the best results here, both on absorbent and non-absorbent substrates.

Product	Charachteristics/Applications
350.0	Solvent-free, no embrittlement, pasty, easy to spread
351.0	Bond quality D3 according to DIN EN 204, colorless glue line, solvent-free
546.0	Solvent- and formaldehyde-free, plasticizer/water-free, suitable for underfloor heating, good aging resistance, pot life approx. 55 min
555.2	Sealer and water barrier against rising damp, hardening of screeds
583.5	Glue line harder, higher strength, free of isocyanates and silicone oils, very low emission (EC1 R Plus) according to GEV Emicode Classification
583.9	Glue line elastic through hardening, free of isocyanates and silicone oils, very low emission (EC1 R Plus) according to GEV Emico-de Classification

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