



Parquet

Production and laying



ADHESIVES

Parquet Production

Parquet floors, regardless whether solid wood or two or three layer parquet, are subject to high demands. As the parquet has to be seen as a single unit, the adhesive used for producing this parquet must, of course, fulfill the following list of requirements:

- high water and moisture resistance
- good long-term stability – no brittleness of the glue line
- good temperature resistance (important with underfloor heating)
- ability to compensate for swelling and shrinkage of the wood due to seasons and underfloor heating
- solvent resistance

For the production of three layer parquet, mainly melamine or UF resin adhesives are used. For the production of two layer parquet, reactive polyurethane hotmelts are used. Dispersions on PVAC basis are another alternative.

KLEIBERIT PUR hotmelt adhesives for in-line production of 2 layer parquet

In the cooperation of several parquet manufacturers with KLEIBERIT, processes were developed for in-line production of 2 layer parquet.

- very high water and moisture resistance
- very high temperature resistance
- retained flexibility of the glue line, no creaking of the parquet under stress
- very good ageing resistance – no brittleness
- good solvent resistance

2 Layer Parquet with

KLEIBERIT 705/707 PUR

offers multiple advantages:

- in-line production – pressing in seconds
- no formaldehyde, no solvent in adhesive
- no water in adhesive, no swelling or shrinkage of the wood

Processing

Reactive PUR hotmelt adhesives are melted in pre-melters at approx. 120-150°C and are usually applied in beads to the wear layer or the sub layer. Short cycle, in-line or continuous press is possible.

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Adhesives for Parquet Production

KLEIBERIT 303 D3 Glue 

Dispersion on PVAC basis for the production of parquet, middle layers and laminate boards

- One component D3 according to DIN EN 204
- With hardener 303.5, bond quality D4
- High temperature resistance according to DIN EN 14257 (Watt 91)
- Universal use
- IMO certification according to test certificate BG Verkehr

KLEIBERIT 304.4

EPI system for water-proof bonds according to DIN EN 204, bond quality D4, DIN EN 14257 (Watt 91)

- 2 layer parquet, 3 layer parquet
- Windows, doors, laminated wood and construction elements made of softwood, hardwood and exotic wood species
- For non load-bearing wall panels

KLEIBERIT 501.0 PUR 

Liquid adhesive on PUR basis for very strong bonding of wood, metal and plastic.

- Very high water resistance, D4 according to DIN EN 204
- High temperature resistance according to DIN EN 14257 (Watt 91)
- Joint filling
- IMO certification according to test certificate BG Verkehr

KLEIBERIT 881.0 Hot Press Glue

Hot press glue on melamine basis with very high water and moisture resistance

- Emission rating E1
- Well suited for the production of 3-layer parquet

Application

Dispersion adhesives can be processed as a one-component glue for the production of parquet cores. When bonding parquet layers, hardener is usually added to improve water and moisture resistance.

PUR adhesives can be used for 2 and 3-layer parquet. The application is done manually or in beads per nozzles. Block press (cold) or multi-layer press (hot or cold) can be used.

Water resistant **hot press adhesive** for bonding veneer according to DIN 68 705 BFU 100 and DIN EN 204 EN.

Adhesives for Parquet Laying

KLEIBERIT offers a whole range of products for laying of parquet and laminate floors:

KLEIBERIT 351 D3 Parquet Glue

For floating installation (bonding of tongue and groove)

- Colorless glue line
- Bond quality D3 according to DIN EN 204
- Solvent-free and formaldehyde-free
- Elastic glue line

KLEIBERIT 350 Parquet Glue

Synthetic resin dispersion for bonding of parquet to absorbent floors such as cement, anhydrite, screed, concrete, cement based underground, wood or chipboard.

- Solvent-free
- No embrittlement of the glue line
- Pasty, good application

KLEIBERIT 546.0/.4 PUR Parquet Adhesive

2 component PUR adhesive for laying of parquet on absorbent and non-absorbent floors, also ceramic tiles and stone. Pot life 546.0: approx. 55 min, 546.4 approx. 40 min.

- Solvent-free and formaldehyde-free

- Plasticizer-free and water-free
- Good ageing resistance

KLEIBERIT 555.3

1C PUR coating for sealing anhydrite, concrete or cement screed

- one component, ready to use
- universal use
- easy application with standard sealing brushes
- high bond strength

KLEIBERIT 583.5

Solvent-free hybrid adhesive for interior use for laying mosaic, pre-finished, strip parquet and solid wood planks as well as 2 and 3 layer multi-layer parquet (also lacquered parquet) to all conventional absorbent and non-absorbent undergrounds

- Easy processing, no primer needed on conventional undergrounds
- Waterproof bond
- Absorbs footstep noise
- Suitable for underfloor heating
- Emissions tested construction product according to DIBt guidelines
- Complies with DIN EN 14293
- Very low emission (EC1 R plus) according to GEV Emission classification





KLEIBERIT 583.9

Solvent-free hybrid adhesive for laying parquet, e.g. lacquered mosaic, pre-finished and strip parquet as well as laminates to all conventional undergrounds

- Moisture and heat resistant
- Absorbs footstep noise
- Suitable for heated floors
- Emissions tested construction product according to DIBt guidelines
- Complies with DIN EN 14293
- Very low emission (EC1 R plus) according to GEV Emission classification



Parquet Laying

KLEIBERIT Product	Base	Floating (also laminate floors)	on absorbent floors	on non-absorbent floors	Properties
351	PVAC	■			D3 bond quality according to DIN EN 204, colorless glue line, solvent-free
350	Synthetic resin		■		Solvent-free, no embrittlement, pasty, brushable
546.0	PUR		■	■	Solvent-free and formaldehyde-free, plasticizer-free and water-free, suitable for underfloor heating, good ageing resistance, pot life approx. 55 min
546.4	PUR		■	■	Solvent-free and formaldehyde-free, plasticizer-free and water-free, suitable for underfloor heating, good ageing resistance, pot life approx. 40 min
555.3	Epoxy		■	■	Sealant and water barrier against rising moisture Reinforcement of screed
583.5 	Silane terminated-polymers		■	■	Glue line hardness, higher strength, free from isocyanates and silicone oils, very low emissions (EC1 R plus) according to GEV Emission classification
583.9 	Silane terminated-polymers		■	■	Glue line cures elastic, free from isocyanate and silicone oils, very low emissions (EC1 R plus) according to GEV Emission classification