

## PARQUET PRODUCTION AND INSTALLATION



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2-LAYER PARQUET

3 -LAYER PARQUET

ADHESIVES FOR  
PARQUET INSTALLATIONFULL SURFACE BONDING  
OF PARQUET FLOORS

### 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 702 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 glue 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. PVAc dispersions or EPI systems are frequently used. However, modern system concepts rely on PUR hotmelts, which can significantly reduce throughput times.



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## ADHESIVES FOR INSTALLING 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

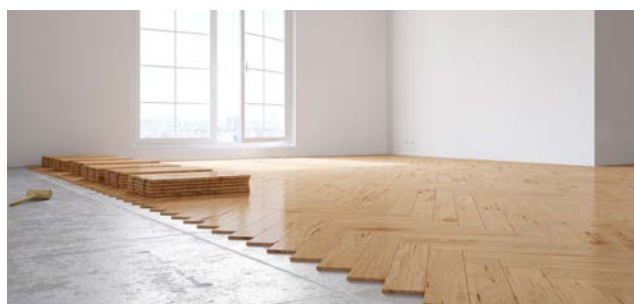
When laying parquet flooring over the entire surface, it is important to work cleanly and use the right adhesive. Several factors determine the choice of the right parquet adhesive. In general, a distinction is made between absorbent and non-absorbent subfloors. A true all-rounder is a parquet adhesives based on STP - **KLEIBERIT 583.5**. This adheres to almost all materials without pre-treatment and provide excellent results. It is easy to process and has impact sound absorbing properties. Furthermore, it is considered very low-emission according to GEV Emission and has the EC 1 Plus seal of approval as well as the emission class A+ according to French VOC regulations.



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### FULL-SURFACE BONDING ON MINERAL SURFACES

Screed is considered an absorbent subfloor. For top results, the synthetic resin dispersion **KLEIBERIT 350.0** should be used. **KLEIBERIT 350.0** can be used pure for bonding small and mosaic parquet. In some cases, sealing the screed provides even better results. For this purpose, the 1C PUR coating product **KLEIBERIT 555.3** should be used. It is even easier with our STP adhesive **KLEIBERIT 583.5**. Pre-coating is usually not necessary with these products.



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### 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 PUR systems as well as low-emission STP systems. The choice of adhesive depends on the individual circumstances, requirements and personal preferences.

Product	Base	Advantages	Certificates	Applications
<b>KLEIBERIT 555.3</b>	PU	easy to apply water barrier against rising dampness		sealing and strengthening of concrete, cement screed, etc.
<b>KLEIBERIT 350.0</b>	synthetic resin dispersion	very good brushability, paste-like consistency		for the installing of small and mosaic parquet, diluted also suitable as a primer with a high yield
<b>KLEIBERIT 351.0</b>	PVAc	colorless glue line, can be used as 1C directly from the bottle	D3	tongue and groove bonding of parquet elements for floating installation
<b>KLEIBERIT 303.0</b>	PVAc	for waterproof glue joints	D3, D4 with hardener, Watt 91, IMO, FDA	for the production of multilayer parquet
<b>KLEIBERIT 583.5</b>	STP	very low emission, simple application	EC1 Plus, A+	for installing parquet on absorbent and non-absorbent substrates
<b>KLEIBERIT 583.6</b>	STP	all-round adhesive for parquet installation, simple application		for installing parquet on absorbent and non-absorbent substrates
<b>KLEIBERIT 304.4 + 808.0 hardener</b>	EPI	suitable for cold, hot and HF bonding	D4 with hardener	production of multilayer parquet, highest moisture resistance with hardener 808.0
<b>KLEIBERIT 304.5 + 808.0 hardener</b>	EPI	very long pot life of approx. 120 min, suitable for cold, warm and HF bonding	D4 with hardener	production of multilayer parquet, highest moisture resistance with hardener 808.0
<b>KLEIBERIT 705.7.00</b>	PUR HM	enables shortest pressing times in a continuous process		production of 2-layer parquet in a continuous process
<b>KLEIBERIT 702.8.09</b>	PUR HM	enables shortest pressing times in a continuous process		production of 2-layer parquet in a continuous process