

KLEIBERIT 525.4

2C-PUR-Moulding Compound

Fields of application

- Manufacture of filters with self-supporting end caps made of **compact** and **hard setting** PUR
- Bonding of filter end caps.

Advantages

- Good resistance to various materials
- Hard setting
- Good flowing properties

Properties of the moulding compound (before and during processing)

Two-component system

Base:	Polyurethane
Component A:	KLEIBERIT 525.4
Component B:	KLEIBERIT 578.0
Mixing ratio:	
Comp. A : Comp. B	3.0 : 1, parts by weight or 2.1 : 1, parts by volume

Specific weight at 20° C:

Comp. A	1.76 ± 0.03 g/cm ³
Comp. B	1.24 ± 0.02 g/cm ³
Mixture	1.58 ± 0.05 g/cm ³

Colour: Beige, others possible

Viscosity at 20° C

Brookfield, sp. 5/ 20 rpm:

Comp. A	16.000 ± 4,000 mPa s
Comp. B	300 ± 70 mPa s

Pot Life at 20° C (100 g of mixture in container):

5 ½ minutes (cured)

Identification:

Component B: subject to identification according to EU regulations contains 4.4' diphenyl methane diisocyanate (see our safety data sheet).

Properties of the bonded system

Hardness, Shore D (DIN 53 505)

approx. 85 in initial state

approx. 80 after 30 days in PER

Bond Strength (similar to DIN 53 283):

approx. 14 MPa in initial state

When used as an adhesive –

approx. 14 MPa after 30 days in PER

Test strip of electrolytically galvanised metal:

approx. 11 MPa after 30 days in water (RT)

approx. 12 MPa after 30 days in petroleum

approx. 8 MPa after 30 days in water at 50° C

Please take into consideration linear and physical shrinkage when making the moulds.

Reason: Cooling down of the reaction and mould temperature to room temperature.

It is advisable to test this beforehand.

Application techniques

The application of the moulding compound is done by means of two-component mixing and dosing devices. Upon request we can provide you with names and addresses of machine manufacturers.

Homogenise component A well before use.

The best application temperature is 20-25° C. Higher temperatures accelerate and lower temperatures delay the setting process.

When used as a moulding compound, insert the mixture into a mould that has been sprayed with release agent. Pre-heated moulds (to approx. 40° C) will ensure uniform hardening and constant cycle times. Insert the **dry** filter paper while still liquid. Please test the time for removal from the mould for yourself.

When used as an adhesive, dosing is made into the end cap which must be **free from oil and grease**.

Attention: When mixed manually (sample processing) mix components thoroughly and quickly and pour out immediately.

Cleaning

Tools and two-component mixing and dosing devices can be cleaned and rinsed with KLEIBERIT 820.0. Please follow the instructions given by the machine manufacturer.

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Packaging

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Component A:
metal can, 37 kg
metal drum, 260 kg net

KLEIBERIT 578.0

Component B:
metal can, 37 kg
metal drum, 250 kg net

KLEIBERIT 820.0:

metal can, 22 kg net

Storage

The best storage temperature is at 15-25°C. Both components must be kept well sealed and be protected from humidity.

Component A is hygroscopic and the quality of the mixture can be affected by the absorption of humidity (resulting in bubbles or foam). Component B forms a skin upon exposure to humidity. Both components can be stored at room temperature in factory sealed containers for approx. 6 months. Open containers should be used as soon as possible.

Version 20/10/2020 ga; replaces previous version

Waste Disposal

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.