

KLEIBERIT 525.3

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 media
- Fast setting
- Good flowing properties

Properties of the moulding compound (before and during application)

Two-component system

Base:	Polyurethane
Component A:	KLEIBERIT 525.3
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	1.73 ± 0.03 g/cm ³
Comp. B	1.24 ± 0.02 g/cm ³
Mixture	1.58 ± 0.05 g/cm ³
Colour:	Beige, other colours also possible on demand

Viscosity at 20° C

Brookfield, sp. 5, 20 rpm:

Comp. A	5,000 ± 1,000 mPa s
Comp. B	300 ± 70 mPa s

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

2 1/2 minutes (rigid)
Component B is subject to identification according to the German hazardous substances regulations GefStoffV, contains 4.4' diphenyl methane diisocyanate (see our safety data sheet)

Identification:

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 (N/mm²) in initial state

When used as an adhesive:

approx. 14 MPa (N/mm²) after 30 days in PER

Test strip of electrolytically galvanised metal

approx. 11 MPa (N/mm²) after 30 days in water (RT)

approx. 12 MPa (N/mm²) after 30 days in petroleum

approx. 8 MPa (N/mm²) after 30 days in water at

50° C

Please take into consideration linear and physical contraction when making the mould. 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 manufacturers' names and addresses.

Homogenise component A well before use. The most favourable application temperature is 20-25°C.

Higher temperatures accelerate and lower temperatures retard 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 of 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 in 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.

KLEIBERIT 525.3

Cleaning

Tools and 2-component mixing and dosing devices can be cleaned and rinsed with KLEIBERIT 820.0. Please follow the instructions given by the machine manufacturer.

Packaging

KLEIBERIT 525.3 (Comp. A):

37 kg metal pail, 260 kg drum

KLEIBERIT 578.0 (Comp. B):

37 kg metal pail, 260 kg drum

KLEIBERIT 820.0:

metal drum, 26 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 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 up as soon as possible.

Version 20/10/2020 ga, replaces previous data sheets

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.