

# KLEIBERIT 522.5

## 2-Comp. PUR Foam

### Field of application

- Manufacture of air filters, essentially when using closed moulds.

### Advantages

- Good flow properties
- Fine-pored structure
- Short demoulding time

### Properties of the foam

Two component system, solvent free

**Base:** polyurethane

**Comp. A:** KLEIBERIT 522.5

**Comp. B:** KLEIBERIT 522.2

#### Mixing ratio:

Comp. A : Comp. B 100 : 30 parts by weight

#### Specific weight:

Comp. A 1.04 ± 0.02 g/cm<sup>3</sup>

Comp. B 1.22 ± 0.02 g/cm<sup>3</sup>

#### Viscosity at 20°C/ Brookfield RVT

##### spindle no. 3 at 20 rpm:

Comp. A 1,400 ± 500 mPa s

##### spindle no. 1 at 20 rpm:

Comp. B 45 ± 15 mPa s

**Colour of the mixture:** orange

**Reaction time (50 g in a laboratory cup, tack free surface):** 90 ± 10 seconds

**Process times:** Time for inserting approx. 20 seconds  
Time for removal approx. 7 minutes

**Identification:** see our safety data sheet

### Physical properties of the foam

Apparent density, in free-foamed condition, approx. 425 kg/m<sup>3</sup>

Hardness Shore A:

-Sample from the cup (50 g): ca 25

-Sample from the filter: ca 30

### Application techniques

#### Homogenise component A in the container before use.

This moulding compound with foaming effect is processed using a two-part mixing and dosing plant fitted with a dynamic mixing head. The storage container for component A must be fitted with a stirring device and an air supply at the base. Alternatively, a two-component plant fitted with an aeration unit and a facility for the recirculation of components A + B can also be used. We would be pleased to supply you with information regarding manufacturers of such plants upon request.

In order to obtain a fine-pored and uniform structure, component A must be aerated with 3-5% (max.) atomised air. This aeration procedure must be performed every time the storage tank for component A is refilled, or following a prolonged interruption of work. The degree of aeration is determined by measuring the specific gravity with a Pyknometer.

**Dry air only may be used for aeration, and for the compressed air supply for cleaning and transferral purposes to and from the storage tank. In this case, 'dry air' is understood to be air which has been dried by means of a refrigeration dryer or an absorption dryer.**

**Maximum water content of the compressed air used = 5 g/m<sup>3</sup> at 6 bar pressure.**

**If the water content (fluid or gaseous) is too high, it will alter the product!**

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The most favourable working temperature range is between 20-25°C. Higher temperatures will accelerate, and lower temperatures will reduce the time required for setting.

The surface of the mould must be free of any residues and must always be finely sprayed with a separating agent before being used each time. To ensure uniform setting, it is recommended that the mould be pre-warmed to 40-45°C. The mould is filled evenly with the foam and the filter inserted immediately afterwards. If a closed mould system being used, replace the cover.

### Cleaning

We recommend the use of KLEIBERIT Cleaner 820.0 to clean tools and to flush out the mixing and dosing plant. Any recommendations made by the manufacturers of the equipment used must be complied with.

### Packaging

#### KLEIBERIT 522.5, Comp. A

metal pail, 10 kg net  
metal pail, 30 kg net

#### KLEIBERIT 522.2, Comp. B

plastic canister, 10 kg net  
metal can, 35 kg net

#### KLEIBERIT Cleaner 820.0:

metal can, 22 kg net

Additional packaging available upon request.

### Storage

KLEIBERIT Air Filter Foam 522.5, Comp. A, and KLEIBERIT Air Filter Foam 522.2, Comp. B, can be stored in the original factory sealed containers for approx. 12 months.

Do not store comp. B below +10°C!  
Protect from moisture and humidity.

Version 12.10.23 lz; replaces previous versions

#### Adhesive and Waste Disposal

**Waste Code 080410 - Component A**  
**Waste Code 080501 - Component B**

Our containers are made of recyclable material. Well drained containers can be recycled.

#### 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.