

KLEIBERIT 523.3

2C PUR Foam

Field of application

- Manufacture of foam-in-place polyurethane gaskets

Advantages

- Good memory
- Very small compression set
- Fine-pored structure
- Short setting time

Properties of the foam

Two component system

Base:	polyurethane
Comp. A:	523.3
Comp. B:	523.6
Mixing ratio:	
Comp. A : Comp. B	100 : 20 parts by weight
Specific weight:	
Comp. A	1.19 ± 0.02 g/cm ³ (no aeration)
Comp. A	1.10 ± 0.03 g/cm ³ (with aeration)
Comp. B	1.19 ± 0.02 g/cm ³
Viscosity at 20° C/ Brookfield RVT spindle no. 5 at 20 rpm:	
Comp. A	28,000 ± 8,000 mPa s
spindle no. 5 at 2.5 rpm:	
Comp. A	125,000 ± 25,000 mPa s
spindle no. 1 at 20 rpm:	
Comp. B	140 ± 90 mPa s
Colour of the mixture:	black
Consistency:	slightly pasty - thixotropic
Reaction time at 20°C (50 g in beaker, lab stirrer 2,000 rpm):	
-start time	40 ± 5 seconds
-hard	150 ± 20 seconds
-raw density	190 ± 20 kg/m ³
Identification:	see our safety data sheet

Physical properties of the foamed bead

Raw density:	260 ± 20 kg/m ³
Hardness Shore 00:	45 ± 10
Tensile strength:	approx. 0.18 N/mm ²
Elongation at break:	170 – 190%
Compression set, 30 minutes after decompression	
-at 70°C, 24 hours, compression 50%	approx. 8 %
-at 90°C, 24 hours, compression 25%	approx. 20 %
Water absorption:	
-according to DIN EN ISO 62:2008, procedure 1	approx. 25 %

Application techniques

Homogenise component A in the container before use.

This product 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 5-10% (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 pycnometer.

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/m³ at 6 bar pressure.

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

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.

Cleaning

We recommend the use of KLEIBERIT 820.0 to clean tools and to flush out the mixing and dosing

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plant. Any recommendations made by the manufacturers of the equipment used must be complied with.

Packaging

KLEIBERIT 523.3, Comp. A:

metal pail, 25 kg net
metal drum, 200 kg net
container, 1,000 kg net

KLEIBERIT 523.6, Comp. B:

plastic canister, 25 kg net
metal can, 25 kg net
metal drum, 200 kg net
container, 1,000 kg net

Cleaner

KLEIBERIT 820.0:

metal canister, 4.5 kg net
metal can, 22 kg net
metal bottle at 800 g net each

Additional packaging available upon request.

Storage

KLEIBERIT 523.3 component A can be stored in the original factory sealed containers for at least 9 months.

KLEIBERIT 523.6 component B can be stored in the original factory sealed containers at 15 – 25 °C for at least 9 months.

Don't store component B under -5 °C

Bring both components to room temp. of 20–25 °C before processing.

Protect both components from moisture.

Version 05/07/2022 lz; replaces previous versions

Disposal of containers and contents

Component A - waste disposal key **080410**

Component B - waste disposal key **080501**

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.