

# KLEIBERIT 541.1

## 2C-PUR-Moulding Compound

### Fields of Use

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

### Advantages

- Good resistance to various media
- Rapid curing
- Flows well
- FDA Certificate of Conformity

### Properties of the Moulding Compound

(Before and during processing)

Two-component system, solvent-free

**Base:** Polyurethane

**Component A:** KLEIBERIT 541.1

**Component B:** KLEIBERIT 578.0

**Mixing Ratio:** Comp. A : Comp. B  
4.0 : 1 parts by weight, or  
3.1 : 1 parts by volume

**Specific Weight 20°C:**  
Comp. A =  $1.59 \pm 0.02$  g/cm<sup>3</sup>  
Comp. B =  $1.24 \pm 0.01$  g/cm<sup>3</sup>  
Mixture =  $1.50 \pm 0.03$  g/cm<sup>3</sup>

**Color:** Natural

**Viscosity at 20°C**

**-Brookfield, Sp. 5, 20 rpm:**

Comp. A =  $11,000 \pm 2,000$  mPa·s

Comp. B =  $300 \pm 80$  mPa·s

**Pot Life at 20°C**

**(100 g mixture in a beaker):**

approx. 7 minutes (firm)

**Identification:** Component B requires identification according to EU regulations, contains 4,4'Diphenylmethanediisocyanate (see our safety data sheet)

### Properties of the System when Cured

**Hardness, Shore D (DIN 53 505):**

approx. 82 in initial condition

### Processing

The moulding compound is processed using a 2-component mixing and dosing plant. Detailed information of the manufacturers of such equipment is available upon request.

#### Homogenize component A before use.

The most favorable working temperature is between 20-25°C. Higher temperatures will accelerate, and lower temperatures will reduce the speed of the setting process.

When used as a moulding compound, a quantity of the mixture is injected into the mould (which has been pre-sprayed with separating agent). To ensure uniform hardening and constant cycle times, it is recommended that the mould be warmed to approx 40°C. The **dry** filter paper must be inserted whilst the mixture is still fluid. Perform your own tests to ascertain how long the form must remain in the mould before being removed.

When used as an adhesive, the mixture is applied to the **grease-free** end cap.

#### Attention!

**In the case of mixing by hand (e. g. production of individual samples) the components must be briefly and intensively mixed together and then poured out immediately.**

### Cleaning

For cleaning purposes and to flush out the mixing and dosing plant, we recommend the use of **KLEIBERIT 820.0**.

Please observe the instructions provided by the manufacturers of the equipment used.

### Container Sizes

**KLEIBERIT 541.1,**

**Comp. A:**

steel drum, 250 kg net

**KLEIBERIT 578.0,**

**Comp.B:**

steel drum, 250 kg net

**KLEIBERIT 820.0:**

metal can, 22 kg net

Additional packaging sizes available upon request.

## KLEIBERIT 541.1

### Storage

Both components can be stored in factory sealed containers at room temperature for approx. 6 months. The ideal storage temperature is 15-25°C. Protect from humidity!

Components A and B are resistant to frost, down to a temperature of -20°C.

Before processing, warm slowly to room temperature.

Component A is hygroscopic. If exposed to moisture the quality of the mixture can be affected (bubbles or foam will appear).

Component B will form a skin if exposed to moisture.

The contents of opened containers should be used as quickly as possible.

Version 20/10/2020 ga; replaces previous versions

#### 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.