

KLEIBERIT 571.1/571.7/571.8

2C-PUR-Adhesive

Identification: Fields of application

Bonding of:

metal end caps to papers impregnated with phenolic resins

felt rolls and other materials used in the filter industry for the production of diesel fuel, motor oil and air filters

Advantages

Short overhead setting time, therefore processing is possible after a short period

Easy processing by means of all commonly used mixing and dosing devices

Properties of the adhesive

Two component system

Rase: Polyurethane

Component A: KLEIBERIT Filter Adhesive 571.1 Component A: KLEIBERIT Filter Adhesive 571.7 Component A: KLEIBERIT Filter Adhesive 571.8 Component B: KLEIBERIT Filter Adhesive 870.0

Colour: 571.1 = natural colour

571.7 = black571.8 = white

Mixing ratio:

Comp. A: comp. B 5.5: 1 parts by weight Comp. A: comp. B 4.0: 1 parts by volume

Specific weight:

Comp. A $1.71 \pm 0.02 \text{ g/cm}^3$ Comp. B $1.24 \pm 0.02 \text{ g/cm}^3$ Mixture $1.60\pm0.02~g/cm^3$

Viscosity Brookfield RVT sp. 6 at 20° C:

comp. A

at 2.5 rpm $50,000 \pm 15,000 \text{ mPa s}$ $18,000 \pm 5,000 \text{ mPa s}$ at 20.0 rpm

comp. B

at 20.0 rpm 150 ± 50 mPa s Consistency: Good flow properties

Pot life of 100 g mixture

at 20° C: cured after approx. 3 min.

Time for placing the filter paper:

up to 1 minute;

cured after approx. 5 min. (approx. 2 mm layer thickness at 20°C please test yourself)

Hardening/Curing: The adhesive cures at normal

Restricted to professional users

temperature within the times

indicated. Heat addition reduces the curing time. Comp. B is subject to

identification according to the German hazardous

substances regulations GefStoffV, contains 4.4' diphenyl methane

diisocyanate

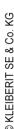
(see our safety data sheet)

Properties of the bond **Bonding strength**

Tested tensile strength following DIN 53 283 with test strips of electrolytic galvanised sheet metal and sendzimir, (hot galvanised) sheet metal = average values in Mpa.

Electrolytic galvanised sheet metal	Sendzimir, (hot galvanised) sheet metal
20	8.5
20	12
17	14
8.0	7.0
4.0	3.5
3.5	2.0
3.0	1.5
19*	14*
	galvanised sheet metal 20 20 17 8.0 4.0 3.5 3.0

RT* test piece was stored at 100°C for 1 hour and acclimatised for 3 hours at room temperature.





KLEIBERIT 571.1/571.7/571.8

Frontal peel strength

Tested in accordance with the recommendations of the Daimler Benz delivery specifications.

Initial state:	0.9
After 48 hours in diesel fuel at 60°C:	8.0
After 100 hours in ASTM no. 2 oil at 135°C:	8.0
After 72 hours in super fuel (gasoline)	
and 6 hours drying:	0.35
After 10 temperature intervals of	
each 4 hours at -20°C and 110°C:	1.2

Average values in MPa.

These values are influenced by the metal quality of the end caps and how they were pre-treated. The above test data is provided without obligation

Application techniques

It is recommended to process this PUR system with two-component mixing and dosing devices in continuous serial production. Details of the manufacturers of such machines are available upon request.

As the filter end caps are usually coated with drawing grease or similar, it is recommended to clean them before bonding. The filter end caps must be clean, dry and free from grease.

Setting characteristics before turning the first end cap: after 5-8 minutes (For correct adjustment please perform your own tests)

Cleaning

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

Packaging

KLEIBERIT Filter Adhesive 571, comp. A:

metal pail, 48 kg net metal drum, 260 kg net container, 1,400 kg net

KLEIBERIT Filter Adhesive 870.0, comp. B:

metal can, 35 kg net metal drum, 250 kg net **KLEIBERIT 820.0**: metal can, 22 kg net

Storage

Suitable for storage in original factory sealed containers:

KLEIBERIT Filter Adhesive 571 (component A): approx. 6 months

KLEIBERIT Filter Adhesive 870.0 (component B): approx. 12 months

Protect both components from humidity. Both components are frost resistant to -20°C. Bring to room temperature before use.

Version 19/10/2020 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.

Restricted to professional users