

# KLEIBERIT 571.1/571.7/571.8

## 2C-PUR-Adhesive

### 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 setting time, therefore overhead 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

<b>Base:</b>	Polyurethane
<b>Component A:</b>	KLEIBERIT Filter Adhesive 571.1
<b>Component A:</b>	KLEIBERIT Filter Adhesive 571.7
<b>Component A:</b>	KLEIBERIT Filter Adhesive 571.8
<b>Component B:</b>	KLEIBERIT Filter Adhesive 870.0
<b>Colour:</b>	571.1 = natural colour 571.7 = black 571.8 = 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 ± 0.02 g/cm <sup>3</sup>
Comp. B	1.24 ± 0.02 g/cm <sup>3</sup>
Mixture	1.60 ± 0.02 g/cm <sup>3</sup>

#### Viscosity

##### Brookfield RVT

##### sp. 6 at 20° C:

<u>comp. A</u>	
at 2.5 rpm	50,000 ± 15,000 mPa s
at 20.0 rpm	18,000 ± 5,000 mPa s
<u>comp. B</u>	
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

### Identification:

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.

Test temperature	Electrolytic galvanised sheet metal	Sendzimir, (hot galvanised) sheet metal
-20°C	20	8.5
±0°C	20	12
RT	17	14
40°C	8.0	7.0
60°C	4.0	3.5
80°C	3.5	2.0
100°C	3.0	1.5
RT*	19*	14*

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

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### 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:	0.8
After 100 hours in ASTM no. 2 oil at 135°C:	0.8
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.