



KLEIBERIT®

ADHESIVES • COATINGS

Clean solutions –

adhesives and moulding compounds for

filter manufacturing



Decades of Experience • Best Delivery Performance • Comprehensive Service • Reliable Quality

Competence **PUR**

Adhesives and moulding compounds for filter manufacturing



Filters are required in many processes, e.g. to remove impurities or harmful substances. Consequently, only the most reliable and high-quality materials should be used in filter manufacturing. KLEIBERIT filter adhesives and filter moulding compounds have set standards in this field and made a large impact on filter technology engineering. This filter guide provides an overview of filter types and their applications and properties.

FASTteam

Filter-Automotive-Sandwich-Textile





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Company



KLEIBERIT - a leading brand for almost 70 years in the world of adhesives for industry and handicraft.

KLEIBERIT adhesives have become indispensable in many areas of the modern world. Today the company is one of the most modern international research and development centers in the world of adhesives.

The product range is tailored to exactly meet customer requirements. Worldwide availability is ensured with an intelligent logistics concept.

KLEIBERIT Adhesives employs approx. 600 employees worldwide - [filter.kleiberit.com](https://www.filter.kleiberit.com)

Innovations

Working together with customers, ideas become new solutions. At the **KLEIBERIT** Technical Center in Weingarten, Germany, customers from all over the world regularly meet with research, development and application technology specialists to develop new possibilities and to prepare for future requirements.

Leading filter manufacturers have been using **KLEIBERIT** adhesives for many decades.

Our Filter Expert Team offers comprehensive advice and works side by side with customers, from the idea stage up to the final integration of the bonding solutions and processes according to international standards.



KLEIBERIT®

ADHESIVES • COATINGS



Customer Satisfaction

Every customer is number one with us.

With our worldwide network of Sales Engineers, and our presence in all markets worldwide, we provide our customers solutions and offers which are designed to meet their specific demands. Almost every national language is spoken within our on-site Sales Administration and Customer Consultation Centre in Weingarten. We cooperate with leading material and machine manufacturers to offer full solutions that comply with international standards such as the FDA standard for food contact and EU standard 10/2011.

Our Quality, Environmental and Energy Standard

KLEIBERIT places high value on product quality, customer service and sustainability. We have these requirements confirmed on an annual basis by an external and independent audit team according to ISO 9001, ISO 50001 and ISO 14001.



Environmental Management
ISO 14001
Quality Management
ISO 9001
Energy Management
ISO 50001

Automotive Filters



Application	Product	Product group	Characteristics
Diesel filter / Engine oil filter / AdBlue filter	512.0	2C PUR moulding compound	Long-term stability in aqueous urea solution (32.5%)
	541.6	2C PUR moulding compound	Suitable for manual processing
	571.1	2C PUR moulding compound	Compact
	576.1	2C PUR moulding compound	Foamed
	599.0	2C PUR moulding compound	For end plates without end caps
	703.5	Reactive PUR hotmelt	Low fogging grade; very good metal adhesion
	704.1	Reactive PUR hotmelt	Engine oil and diesel fuel resistant, very short open time; especially for temperature-sensitive media
	791.0	PES hotmelt	Engine oil and diesel fuel resistant; processing via extruders



Diesel filter



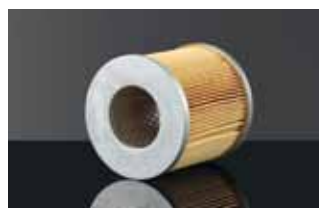
Cabin filter



Engine air filter



Engine air filter



Engine oil filter

Application	Product	Product group	Characteristics
Cabin filter	521.1	2C PUR moulding compound	For closed moulds
	522.1	2C PUR moulding compound	For closed moulds; TL848 compliant
	549.1	2C PUR moulding compound	Compliant with EU 10/2011 and FDA 21 CFR § 177.1680 food regulations; good tear resistance; B component must not be stored below 15°C.
	549.5	2C PUR moulding compound	Accelerator 549.2 must be mixed with component A prior to processing (acceleration speed can be varied); low fogging grade; B component must not be stored below 15°C
	703.8 725.5/.7/9 796.1	Reactive PUR hotmelt PO hotmelt PES hotmelt	Low fogging grade; very good plastic adhesion Low fogging grade Processable in melters
Engine air filter	521.1	2C PUR moulding compound	For closed moulds
	522.1	2C PUR moulding compound	For closed moulds; TL848 compliant
	526.0	2C PUR moulding compound	For open moulds
	547.1	2C PUR moulding compound	Compact, flexible moulding compound
	576.1	2C PUR moulding compound	Foamed
	704.1	Reactive PUR hotmelt	Engine oil and diesel fuel resistant, very short open time; especially for temperature-sensitive media
	791.0	PA hotmelt	Engine oil and diesel fuel resistant; processing via extruders
	796.1	PES hotmelt	Processable in melters

Building/Industrial Filters



Room filter



Pocket filter



Bag filter

Product	Product group	Characteristics
425.3	Special dispersion	Fiber coating
425.6	Special dispersion	Fiber coating
523.3	2K PUR gasket foam	For foam-in-place gaskets
524.5	2C PUR moulding compound	High pressure equipment; F1 fire behaviour (according to DIN 53438); contains internal separating agents
525.1	2C PUR moulding compound	High pressure equipment
525.7	2C PUR moulding compound	Low pressure equipment; F1 fire behaviour (according to DIN 53438); contains internal separating agents
541.1	2C PUR moulding compound	Good resistance to various media; compliant with FDA regulation 21 CFR § 177.1680
542.4	2C PUR moulding compound	Good resistance to various media; compliant with EU 10/2011 food regulations
545.5	2C PUR moulding compound	Compact, flexible, good tear resistance
547.1	2C PUR moulding compound	Compact, flexible
549.1	2C PUR moulding compound	Compliant with EU 10/2011 and FDA 21 CFR § 177.1680 food regulations; good tear resistance; B component must not be stored below 15°C.
549.5	2C PUR moulding compound	Accelerator 549.2 must be mixed with component A prior to processing (acceleration speed can be varied); low fogging grade; B component must not be stored below 15°C
549.6	2C PUR moulding compound	Compliant with FDA regulation 21 CFR § 177.1680; good tear resistance; B component must not be stored below 15°C.
572.0	2C PUR moulding compound	Suitable for water penetration (pre-processed filters)
574.4	2C PUR moulding compound	Light-fast, transparent, bacteriostatic and fungistatic
575.0	2C PUR moulding compound	Bacteriostatic and fungistatic; suitable for water penetration (pre-processed filters)
575.8	2C PUR moulding compound	Self-thixotroping; bacteriostatic and fungistatic
703.2	Reactive PUR hotmelt	Compliant with food regulations EU 10/2011, and FDA 21 CFR § 177.105 and § 177.1680
708.8	Reactive PUR hotmelt	Compliant with EU 10/2011 food regulations
719.2	EVA hotmelt	Bacteriostatic and fungistatic



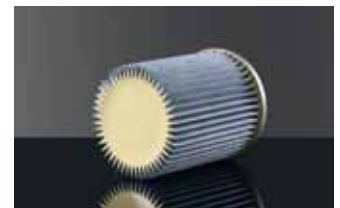
Hydraulic Filters



Hydraulic filter



Hydraulic filter



Decontamination filter

Product	Product group	Characteristics
525.3	2C PUR moulding compound	Good resistance to various media, especially hydraulic oils
525.4	2C PUR moulding compound	Good resistance to various media, especially hydraulic oils
525.5	2C PUR moulding compound	Good resistance to various media, especially hydraulic oils; self-thixotropic
525.8	2C PUR moulding compound	Good resistance to various media, especially hydraulic oils
531.1	2C EP moulding compound	Bonding filter end caps, good adhesion to non-ferrous metals
531.4	2C EP moulding compound	Slightly thixotropic for longitudinal seam bonding, good adhesion to non-ferrous metals
531.8	2C EP moulding compound	Transparent (yellowish)

Other filters



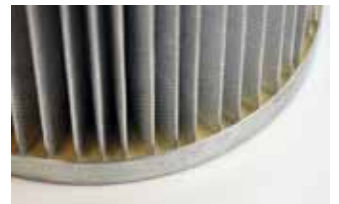
Product	Product group	Characteristics
523.3	2C PUR moulding compound	For foam-in-place gaskets
541.1	2C PUR moulding compound	Good resistance to various media; compliant with FDA regulation 21 CFR § 177.1680
541.6	2C PUR moulding compound	Suitable for manual processing
542.4	2C PUR moulding compound	Good resistance to various media; compliant with EU 10/2011 food regulations
545.5	2C PUR moulding compound	Compact, flexible, good tear resistance
547.1	2C PUR moulding compound	Compact, flexible
549.1	2C PUR moulding compound	Compliant with EU 10/2011 and FDA 21 CFR § 177.1680 food regulations; good tear resistance; B component must not be stored below 15°C.
549.5	2C PUR moulding compound	Accelerator 549.2 must be mixed with component A prior to processing (acceleration speed can be varied); low fogging grade; B component must not be stored below 15°C
549.6	2C PUR moulding compound	Compliant with FDA regulation 21 CFR § 177.1680; good tear resistance; B component must not be stored below 15°C.
703.2	Reactive PUR hotmelt	Compliant with food regulations EU 10/2011, and FDA 21 CFR § 177.105 and § 177.1680
708.8	Reactive PUR hotmelt	Compliant with EU 10/2011 food regulations
715.5	PE hotmelt	-



Metal edge filter



Air filter



Dust filter

KLEIBERIT 2C moulding compounds and adhesive for filter

		Product comp. A	comp. B	Viscosity (Brookfield RVT) Comp. A (mPa·s) at 20 rpm and 20 °C	Viscosity (Brookfield RVT) Comp. B (mPa·s) at 20 rpm and 20 °C	Density comp. A (g/cm ³)	Density comp. B (g/cm ³)	Mixing ratio		Pot life at 20 °C in		Hardness Shore A		
								Parts by weight	Parts by volume	50g cup	100g cup	A	D	00
2C PUR moulding compound/adhesive	Foamed, elastic	521.1	521.2	approx. 2,800	approx. 200	approx. 1.15	approx. 1.19	100:38	100:36.7	approx. 75 s	-	approx. 20-25 ¹	-	-
		522.1	522.0	approx. 1,400	approx. 280	approx. 1.04	approx. 1.22	100:40	100:34.1	approx. 90 s	-	approx. 26 ²	-	-
		523.3	523.6	approx. 28,000	approx. 250	approx. 1.19	approx. 1.19	100:20	100:20	approx. 150 s	-	-	-	approx. 45
		526.0	526.6	approx. 4,500	approx. 250	approx. 1.32	approx. 1.19	5.5:1	5:1	approx. 90 s	-	approx. 20 - 25 ³	-	-
	Compact, flexible	545.5	547.6	approx. 5,000	approx. 300	approx. 1.32	approx. 1.18	5:1	4.4:1	-	approx. 90 s	approx. 57	-	-
		547.1	547.2	approx. 2,800	approx. 200	approx. 1.23	approx. 1.22	4.5:1	4.5:1	-	approx. 2 min	approx. 60	-	-
		549.1	549.3	approx. 2,500	approx. 160	approx. 1.09	approx. 1.21	100:25	100:22.6	-	approx. 2-3 min	approx. 66	-	-
		549.5	549.3	approx. 3,100	approx. 160	approx. 1.11	approx. 1.21	100:16	100:14.7	-	approx. 180 ⁴ s	approx. 45	-	-
		549.6	549.3	approx. 2,500	approx. 160	approx. 1.09	approx. 1.21	100:27	100:24.3	-	approx. 2-3 min	approx. 65	-	-
		574.4	574.5	approx. 1,900	approx. 200	approx. 1.1	approx. 1.13	100:100	100:97	-	approx. 2.5 min	approx. 75	-	-
	Foamed, hard	524.5	524.6	approx. 2,200	approx. 320	approx. 1.04	approx. 1.23	100 : 120	100 : 101	approx. 39 s	-	-	-	-
		525.1	525.4	approx. 580	approx. 330	approx. 1	approx. 1.24	100:75	100:62	approx. 95 s	-	-	-	-
		525.7	578.0	approx. 2,300	approx. 280	approx. 1.04	approx. 1.24	100:120	100:101	approx. 2 min	-	-	-	-
		576.1	576.2	approx. 4,000	approx. 300	approx. 1.51	approx. 1.24	100:25	100: 30	approx. 95 s	-	-	-	-
	Compact, hard	525.3	525.2	approx. 5,000	approx. 300	approx. 1.73	approx. 1.24	3:1	2.1:1	-	approx. 2,5 min	-	approx. 85	-
		525.4	525.2	approx. 16,000	approx. 300	approx. 1.76	approx. 1.24	3:1	2.1:1	-	approx. 5,5 min	-	approx. 85	-
		525.5	525.2	approx. 16,000	approx. 300	approx. 1.76	approx. 1.24	3:1	2.1:1	-	approx. 3,5 min	-	approx. 85	-
		525.8	525.2	approx. 16,000	approx. 300	approx. 1.76	approx. 1.24	3:1	2.1:1	-	approx. 3 min	-	approx. 85	-
		541.1	541.5	approx. 11,000	approx. 300	approx. 1.59	approx. 1.24	4:1	3.1:1	-	approx. 7 min	-	approx. 82	-
		541.6	541.7	approx. 30,000	approx. 150	approx. 1.59	approx. 1.23	4:1	100:32.4	-	approx. 45 min	-	approx. 80	-
542.4		542.5	approx. 22,000	approx. 20	approx. 1.63	approx. 1.2	100:26	100:35	-	approx. 7,5 min	-	approx. 80-85	-	
571.1		571.2	approx. 18,000	approx. 150	approx. 1.71	approx. 1.24	5.5:1	4:1	-	approx. 3 min	-	approx. 70	-	
575.8		575.9	approx. 1,200	approx. 130	approx. 1.1	approx. 1.23	100:50	100:45	approx. 7-8 min	-	-	approx. 57	-	
599.0		578.0	approx. 12,000	approx. 280	approx. 1.6	approx. 1.24	100:35	100:45	-	approx. 90 s	-	approx. 83	-	
Compact, tough and hard	512.0	519.5	approx. 5,600	approx. 27	approx. 0.93	approx. 1.22	100:50	100:38.1	-	approx. 8 min	approx. 96	approx. 47	-	
	572.0	574.6	approx. 2,500	approx. 300	approx. 1.33	approx. 1.23	4:1	3.7:1	-	approx. 3 min	approx. 85	-	-	
	575.0	575.1	approx. 1,000	approx. 65	approx. 1.1	approx. 1.2	100:55	100:50	-	approx. 5 min	approx. 90	-	-	
2C EP moulding compound	Compact, hard	531.1	531.2	approx. 60,000	approx. 115,000	approx. 1.75	approx. 1.44	3:1	2.5:1	-	approx. 75 min	-	approx. 90	-
		531.4	531.2	approx. 100,000	approx. 115,000	approx. 1.75	approx. 1.44	3:1	2.5:1	-	approx. 75 min	-	approx. 90	-
		531.8	531.9	approx. 6,000	approx. 500	approx. 1.16	approx. 1.03	1.5:1	100:74.6	-	approx. 60 min	-	approx. 75-80	-

¹ The measurements were performed on specimens with a raw density of 330 - 350 kg/m³

² The measurements were performed on specimens with a raw density of approx. 415 kg/m³

³ The measurements were performed on specimens with a raw density of approx. 565 kg/m³

⁴ Measured with 0.2% accelerator (549.2) added to component A



production

Raw density in 50 g cup (kg/m³)		Comments	Applications
free-foamed	foam-moulded		
approx. 250	-	For closed moulds	Frames and sealing lips of cabin filters and engine air filters
approx. 385	-	For closed moulds; TL848 compliant	Frames and sealing lips of cabin filters and engine air filters
approx. 190	-	-	Production of free-foamed polyurethane foam seals
approx. 450-500	approx. 550	For open moulds	Moulding end caps and sealing lips of engine air filters
-	-	-	Production of air filter end caps and other compact sealing lips
-	-	-	Production of air filter end caps, frames and other compact sealing lips
-	-	Compliant with EU 10/2011 and FDA 21 CFR § 177.1680 food regulations; good tear resistance; B component must not be stored below 15°C.	Production of air filter end caps and other compact sealing lips; dust filter elements used in the food sector
-	-	Accelerator 549.2 must be mixed with component A prior to processing (acceleration speed can be varied); low fogging grade; B component must not be stored below 15°C	Moulding compound for moulding end caps, frames and sealing lips of cabin filters and industrial dust removal filters
-	-	Compliant with FDA regulation 21 CFR § 177.1680; good tear resistance; B component must not be stored below 15°C.	Production of air filter end caps and other compact lip seals; dust filter elements used in the food sector
-	-	Light-fast, transparent, bacteriostatic and fungistatic	Repair compound for HEPA / ULPA filters
approx. 200	approx. 450 - 600	High pressure equipment; F1 fire behaviour (according to DIN 53438); contains internal separating agents	Production of pocket filter frames
approx. 410	approx. 450 - 550	High pressure equipment	Production of cartridge filters
approx. 225	approx. 500 - 600	Low pressure equipment; F1 fire behaviour (according to DIN 53438); contains internal separating agents	Production of pocket filter frames
approx. 775	-	Process under low pressure	Bonding filter end caps in engine air filters, diesel fuel and engine oil filters (metal and plastic end caps)
-	-	Good resistance to various media, especially hydraulic oils	Production of filters with self-supporting end caps made of compact and hard-setting PUR; bonding filter end caps
-	-	Good resistance to various media, especially hydraulic oils	Production of filters with self-supporting end caps made of compact and hard-setting PUR; bonding filter end caps
-	-	Good resistance to various media, especially hydraulic oils; self-thixotropic	Longitudinal seam bonding of filter elements
-	-	Good resistance to various media, especially hydraulic oils	Production of filters with self-supporting end caps made of compact and hard-setting PUR; bonding filter end caps
-	-	Good resistance to various media; compliant with FDA regulation 21 CFR § 177.1680	Industrial dust removal filters; production of filters with self-supporting end caps made of compact and hard-setting PUR; bonding filter end caps
-	-	Suitable for manual processing	Production of filters with self-supporting end caps made of compact and hard-setting PUR; bonding sheet metal end caps for oil, diesel fuel and kerosene filters
-	-	Good resistance to various media; compliant with EU 10/2011 food regulations	Industrial dust removal filters; production of filters with self-supporting end caps made of compact and hard-setting PUR; bonding filter end caps
-	-	-	Bonding filter end caps in engine air filters, diesel fuel and engine oil filters (metal and plastic end caps)
-	-	Self-thixotropic; bacteriostatic and fungistatic	Production of industrial filters (e.g. HEPA, ULPA filters)
-	-	For end plates without end caps	Hard moulding compound for casting metal-free end caps for oil filters
-	-	Long-term stability in aqueous urea solution (32.5%)	Production of filter end caps for AdBlue Filters
-	-	Suitable for water penetration (pre-processed filters)	For the production of industrial filters (e.g. HEPA, ULPA)
-	-	Bacteriostatic and fungistatic; suitable for water penetration (pre-processed filters)	For the production of industrial filters (e.g. HEPA, ULPA)
-	-	-	Bonding end caps; production of filter elements for hydraulic and fuel filters
-	-	Slightly thixotropic	Bonding end caps; production of filter elements for hydraulic and fuel filters
-	-	Transparent (yellowish)	Bonding end caps; production of filter elements for hydraulic and fuel filters

KLEIBERIT hotmelts and dispersions for filter pleat bonding

	Product	Base	Viscosity (Brookfield bei 10 rpm in mPa·s) at		Density (g/cm ³)	Processing temperature (°C)	Softening temperature (°C; ring + ball)
Non-reactive hotmelts	715.5	PE	180 °C: approx. 55,000 200 °C: approx. 35,000		approx. 0.95	180 - 210	approx. 110
	719.2	EVA	140 °C: approx. 17,000 160 °C: approx. 9,000		approx. 1	140 - 160	approx. 120
	725.5	PO	180 °C : approx. 40,000 200 °C: approx. 25,000		approx. 0.95	160 - 180	approx. 160
	725.7	PO	160 °C: approx. 35,000 180 °C: approx. 16,000		approx. 0.92	180 - 200	approx. 135-150
	725.9	PO	160 °C: approx. 40,000 180 °C: approx. 20,000		approx. 0.92	160 - 180	approx. 125
	791.0	PA	180 °C: approx. 13,000 200 °C: approx. 6,000		approx. 0.95	180 - 200	approx. 170
	796.1	PES	180 °C: approx. 40,000 200 °C: approx. 24,000		approx. 1.25	180 - 200	approx. 160
PUR hotmelts	Product	Base	Viscosity (Brookfield bei 10 rpm in mPa·s) at 120 °C	Viscosity (Brookfield bei 10 Upm in mPa·s) at 140 °C	Density (g/cm ³)	Processing temperature (°C)	
	703.2	PUR	approx. 28,000	approx. 17,000	approx. 1.1	100 - 120	
	703.5	PUR	approx. 11,000	approx. 6,000	approx. 1.1	120 - 140	
	703.8	PUR	approx. 48,000	approx. 23,000	approx. 1.1	120 - 140	
	704.1	PUR	approx. 25,000	approx. 16,000	approx. 1.1	110 - 140	
	708.8	PUR	approx. 10,000	approx. 5,000	approx. 1.1	120 - 140	
Dispersions	Product	Base	Viscosity (Brookfield RVT) at 20 °C	Density (g/cm ³)	pH value		
	425.3	Special dispersion	approx. 2,200	approx. 1.25	approx. 6		
	425.6	Special dispersion	approx. 1,500	approx. 1.2	approx. 6.5		



Open time (determined on a 2mm bead on phenolic resin filter paper) at an application temperature of:	Remarks	Applications
210 °C: approx. 28 s		Pleat bonding and pleat fixation of HEPA and ULPA filters for vacuum cleaners
160 °C: approx. 16 s	Bacteriostatic and fungistatic	Pleat bonding and pleat fixation of HEPA and ULPA filters
200 °C: approx. 20 s	Low fogging grade	Production of cabin filters; edge banding, pleat bonding and pleat fixation
200 °C: approx. 20 s	Low fogging grade	Edge banding and pleat fixation of cabin filters
160 °C: approx. 22 s	Low fogging grade	Production of passenger compartment filters; edge banding, pleat bonding and pleat fixation
210 °C: approx. 28 s	Engine oil and diesel fuel resistant; processing via extruders	Filter paper bonding in automobile filter production; pleat bonding and pleat fixation
210 °C: approx. 30 s	Processable in melters	Filter paper bonding in automobile filter production; pleat bonding and pleat fixation
Open time (determined on a 2mm bead on phenolic resin filter paper) with an application temperature of 140°C:	Remarks	Applications
approx. 10 s	Compliant with food regulations EU 10/2011, and FDA 21 CFR § 177.105 and § 177.1680	Bonding filter pleats; pleat fixation and bonding banderoles
approx. 30 s	Low fogging grade; very good metal adhesion	Longitudinal seam bonding of fuel and diesel filters; edge banding and bonding banderoles
approx. 30 s	Low fogging grade; very good plastic adhesion	Edge banding and bonding banderoles in cabin filters
approx. 3 s	Engine oil and diesel fuel resistant, very short open time; especially for temperature-sensitive media	Filter paper bonding in automobile filter production; pleat bonding and pleat fixation
approx. 80 s	Compliant with EU 10/2011 food regulations	Bonding pleats (filter tips) and banderoles of industrial dust removal filters (Compact Filter Elements, CFE)
		Applications
		Pleat bonding and pleat fixation of HEPA and ULPA filters, fiber binding agents for filter mats
		Pleat bonding and pleat fixation of HEPA and ULPA filters, fiber binding agents for filter mats



KLEIBERIT® Adhesives worldwide

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Weingarten/Germany

KLEIBERIT Adhesives UK

Coalville, Leicestershire, UK

KLEIBERIT Chimie S.a.r.l.

Reichstett, France

KLEIBERIT Adhesives USA Inc.

Waxhaw, North Carolina, USA

KLEIBERIT Adhesives of Canada Inc.

Toronto, Ontario, Canada

KLEIBERIT AUSTRALIA Pty Ltd.

Sydney, Australia

KLEIBERIT Russia

Moscow, Russia

KLEIBERIT Adhesives Japan

Osaka, Japan

KLEIBERIT Adhesives Beijing Co., Ltd.

Beijing, China

KLEIBERIT Adhesives Asia Pte. Ltd.

Singapore, Singapore

KLEIBERIT Adhesives India Private Ltd.

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