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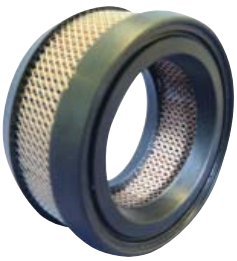
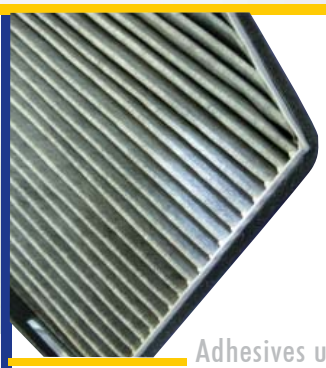
INDUSTRIAL ADHESIVES



COMPETENCEPUR

FILTER GUIDE



Adhesives und Compound for Filter

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Modern Technology, Know-how, Commitment...

Klebchemie M.G. Becker GmbH & Co. KG, Producer of Kleiberit products - modern and future orientated. The company's competence is especially reflected in the tremendous development and productivity in PUR-adhesives, which is why Kleiberit products have become market leaders in this future technology sector - worldwide!

In our modern laboratories, experienced, innovative and highly motivated chemists develop high quality products in accordance to customer requirements. Emphasis is placed on the development of environmentally friendly and ecologically clean adhesives.

Our applications laboratory has an extensive range of machinery, and our qualified technicians and engineers are therefore able to conduct tests under "real life" conditions.

The combination of our inbound quality control, production quality control and the constant product development ensures that our customer will only receive quality products.

... are the components that determine success - today and in the future.

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Quality Control

The combination of our inbound material quality control, production quality control and constant product development ensures that our customers will only receive quality products.





Worldwide many well known companies in the woodworking, plastics and automotive industry are using Kleiberit products.

COMPETENCE **PUR**

- PUR-Adhesive: One and two components
- PUR-Hot Melts, PUR-Glue
- Dispersions: PUR, EVA, PVAc
- Hot Melts: PUR, EVA, PO, PA, PE
- Two component PUR and Epoxy Systems
- Foams and Sealing Compounds
- Solvent based Adhesives

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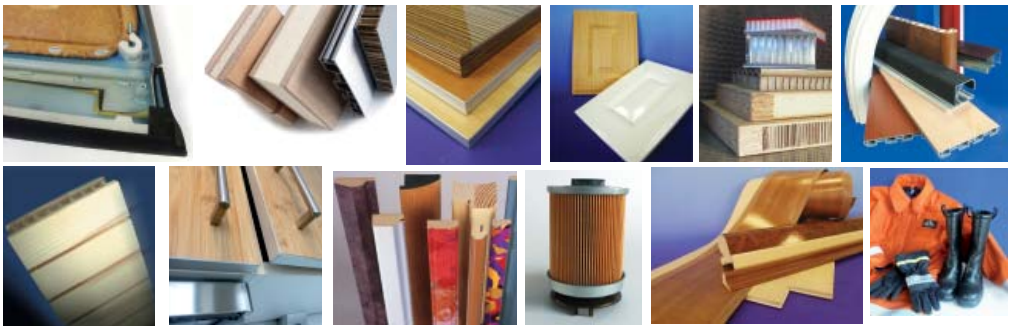
Working internally and in the field, our highly qualified employees always provide the best service that customers can expect: excellent customer care, high quality technical assistance, fast turn around of orders etc.



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Adhesives and Moulding Compounds for the Filter Industry

KLEIBERIT offers a wide range of adhesive and moulding products for the manufacture of filter cartridges, replacement filters and filter-inserts. These products are specially formulated for specific uses. In most cases they are based on Polyurethane (PUR), Epoxy (EP) and Plastisol (PVC)

KLEIBERIT adhesives are available either as a coldhardening two-component system (EP and PUR), or as a heat curing single component system (PVC). The range is complimented by a balanced pallet of hot melt adhesives.

KLEIBERIT adhesives made for the filter industry are solvent-free.

KLEIBERIT moulding compounds are mainly two-component PUR systems. A choice can be made between hard curing and permanently elastic foam systems. A wide choice of colours is available.

KLEIBERIT adhesives and moulding compounds fulfill the most stringent demands and requirements.

Motor vehicle air-filter seal development

Metal end caps are used only in the case of large air filters for heavy machinery

In most cases, the filter end cap is moulded and has been developed to form a foam sealing lip.

This technique places high demands on the form and equipment construction, but also on the foam system. **KLEIBERIT** foam systems have various densities and therefore fulfill differing requirements.

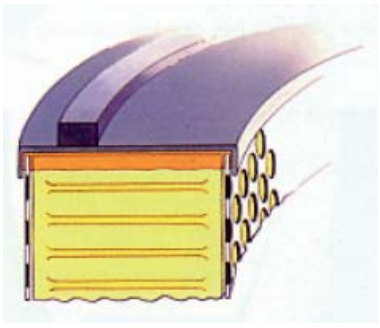

Fig.1: Metal end cap with separately bonded seal.

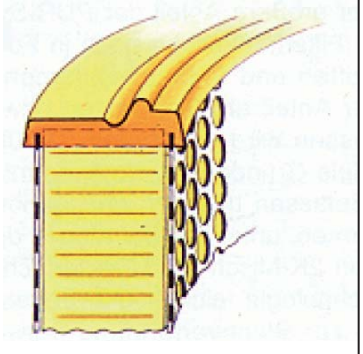

Fig. 2: Fully moulded end cap with moulded sealing lip

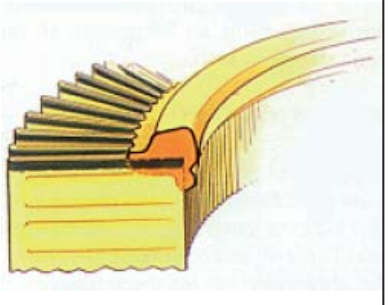

Fig. 3: Pocket filter with foamed sealing lip

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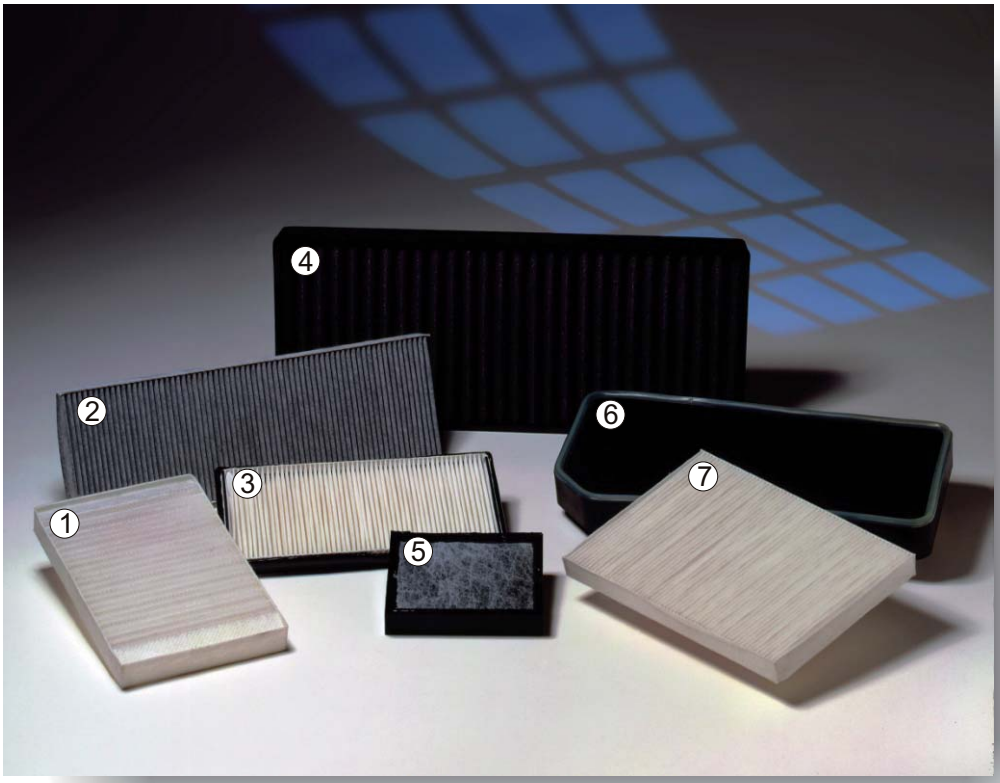
Adhesives and Moulding Compounds for Motor Vehicle Interior Filters



The range of KLEIBERIT products includes adhesives and moulding compounds for bonding and forming end-caps and frames

PRODUCTS

Number	Areas of use	Products	Base	Properties
1	Motor vehicle interior filter	HM 719 HM 725.7*	EVA PO	Hot melt low *fogging value
2; 7	Motor vehicle interior filter	HM 703.5*, 703.8* HM 796	PUR-HM Polyester	low *fogging value Hot melt
3	Motor vehicle interior filter	521, 522	2c-PUR	Foamed / elastic
4; 5; 6	Motor vehicle interior filter	547 525* 549.5*	2c-PUR 2c-PUR 2c-PUR	Compact / elastic Compact / hard Compact / elastic; low *fogging value

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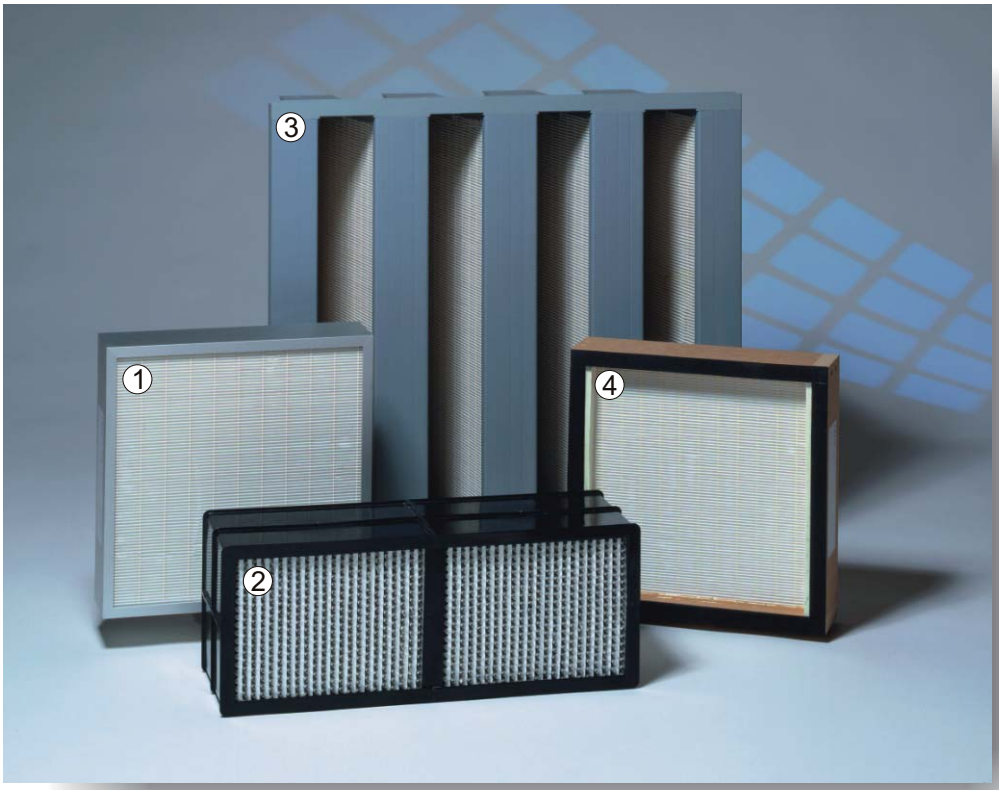
Adhesives and Moulding Compounds for Air Conditioning and Computer Filters



The range of KLEIBERIT products includes adhesives and moulding compounds for moulding fleece or paper packs for temperatures up to 130°C.

PRODUCTS

Number	Areas of use	Products	Base	Properties
1; 4	Air condition filter, HEPA, ULPA,	425.6 575.0 HM 719 574.4	Dispersion 2c-PUR EVA 2c-PUR	Textile thread coating with bacteriostatic and fungistatic hard / tough, with bacteriostatic and fungistatic Hot melt Transparent, uv-stable with bacteriostatic and fungistatic (repair moulding compound)
2	Computer filter	572, 575	2c-PUR	Compact-hard
3	Air condition filter	425 572, 575 576 SK 719	Dispersion 2c-PUR 2c-PUR EVA	Compact-hard Foamed-hard Hot melt

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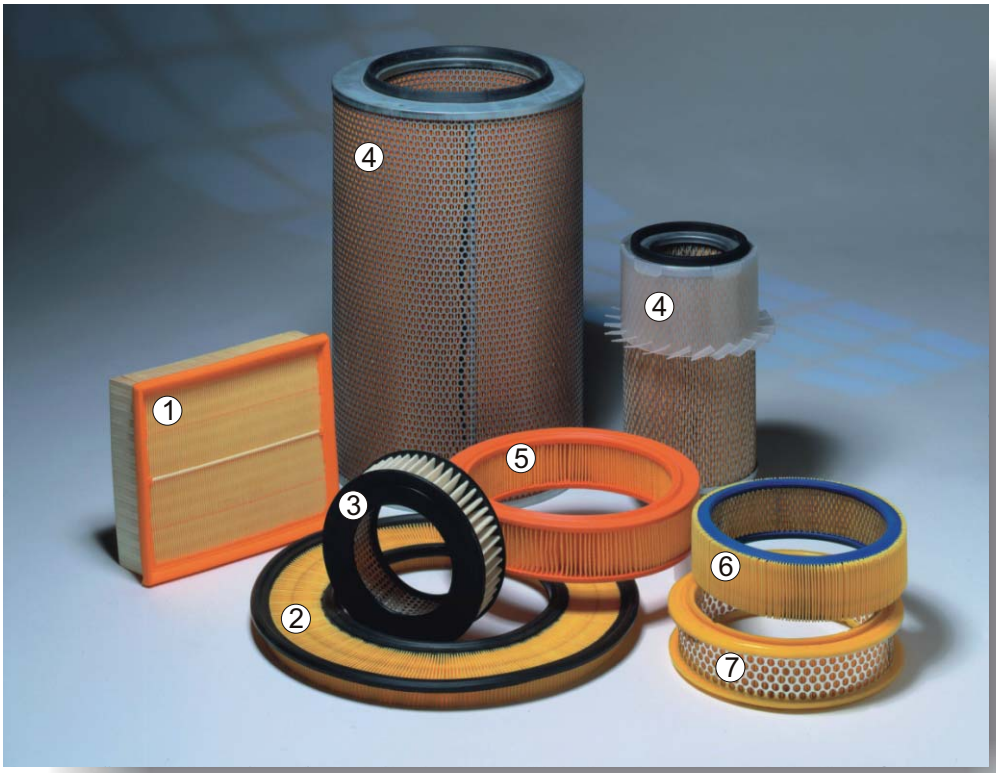
Adhesives and Moulding Compounds for Motor Vehicle Air Filters



The range of KLEIBERIT products includes adhesives and moulding compounds for bonding and moulding end caps and sealing rings, as well as for bonding paper pleats or bellows.

PRODUCTS

Number	Areas of use	Products	Base	Properties
1; 2; 6	Airfilter with foamed sealing lips in closed forms, bonding and fixing pleats or bellows	521, 522 HM 715.5, 725 HM 791 HM 796	2c-PUR PO PA Polyester	Foamed / elastic Hot melt Hot melt Hot melt
3; 4	Airfilter bonding and moulding end caps	PVC-Plastisol 515, 516 571 HM 703.8 576 HM 750	PVC 2c-PUR PUR-HM 2c-PUR PO	Compact / elastic Compact / hard Hot melt Foamed / hard Hot melt
5; 7	Airfilter with foamed sealing lips in open forms	PVC-Plastisol 518 526 547	PVC 2c-PUR 2c-PUR	Compact / elastic Foamed / elastic Compact / elastic

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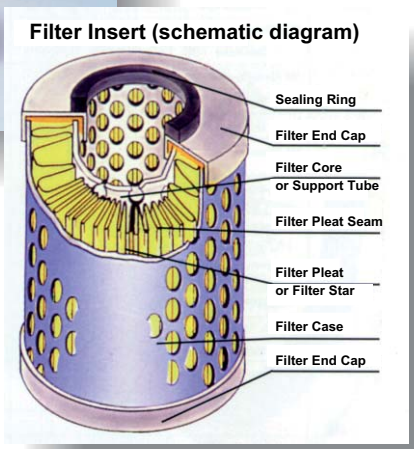
Adhesives and Moulding Compounds for Oil and Hydraulic filters



The range of KLEIBERIT products includes adhesives and moulding compounds for bonding metal end caps and filter pleats made from paper or metallic materials.

PRODUCTS

Number	Areas of use	Products	Base	Properties
1	Hydraulic filters – Steel end cap, metallic material	Plastic-Mastic 531 525	2c-EP 2c-PUR	Compact / hard Compact / hard
2	Motor vehicle filter cartridges for motor oil and diesel fuel	PVC-Plastisol 515, 516 571 576	PVC 2c-PUR 2c-PUR	Compact / elastic Compact / hard Foamed / hardt

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Adhesives and Moulding Compounds for Special Filters

The range of KLEIBERIT products includes adhesives and moulding compounds for bonding and moulding end caps and sealing lips.

PRODUCTS

Number	Areas of use	Products	Base	Properties
1	Dry cleaning	525	2c-PUR	Compact / hard
2	Air filters for chain saws	547	2c-PUR	Compact / elastic
3; 4; 5	Ventilation filter for oil and hydraulic tanks	525 545.5, 547	2c-PUR 2c-PUR	Compact / hard Compact / elastic
6; 7	Filters for industrial vacuum cleaners	525*, 541* 547; 549*, SK 708.8	2c-PUR 2c-PUR PUR-HM	Compact / hard, *FDA-conform Compact / elastic, *FDA-conform Good temperature resistance
8	Special filters	525*, 541*	2c-PUR	Compact / hard, *FDA-conform

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Adhesives
and
Moulding Compounds
for the
Manufacture
of
Filter Inserts

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Filter Guide

Table of Contents

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Filter Types (Filter Terms)

General Description

In-Line Filter Completely disposable unit consisting of an insert and a housing which is installed directly in-line

Filter Insert
Filter Cartridge In order to function correctly, they must be enclosed in a suitable filter housing.

Pocket Filter Mainly used for filtering air and liquids. Each individual filter is pocket shaped, i.e. three sides are closed and one side is open. In the case of large filters it saves end-cap material, and in the case of small filters it increases the filter surface.

Felt Filter This type of filter is not made from paper, but from a wound felt material.

Wound Filter The filter bellow is made from a special paper which is wound in the shape of a coil. End-caps are not provided. The wound filter coil is sealed in a housing.

Gap Filter The size of the particles to be retained by the filter is pre-determined by the size of gap. These are precision filters!

Ultra Filter Filter without binding agent manufactured from a new type of micro-fleece, (non-woven material).

Frame Filter The filter material (fleece, paper, etc.) is glued or cast into a frame or insert.

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Filter Applications

Various Specifications for Area of Use:

Fuel Filters **Petrol Filters** **Gasoline Filters** **Diesel Filters**	(motor vehicles)	In-line filter for motor vehicles. Their purpose is to filter the motor fuel.
Oil Filters **Motor Oil Filters** **Transmission Oil Filter**	(motor vehicles)	Filterinserts used in motor vehicle engines which are usually only effective when contained in a housing, and filter cartridges which are screwed on to the engine block. Their purpose is to filter the lubricants.
Air Filters	(motor vehicles)	Filter-inserts which must be contained in a housing to function correctly. Their purpose is to filter the air which is fed to the carburetor.
Hydraulic Filters **Hydraulic Oil Filters**		Filter-inserts which must be contained in a housing located in hydraulic system (e.g., excavator, rolling mill), to function correctly. Their purpose is to filter the hydraulic fluids.
Filters for Chemical Cleaning-Appliances **Washing Machines**		Filter-inserts to filter the cleaning agent (usually perchlorethylene PER) used in chemical cleaning appliances.
Filters for Air-Conditioners		Filters used to filter the air in air-conditioners.
Industrial Filters		Filter-inserts used to filter gaseous, liquid and solid Materials.

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Filter Components

Components, Materials

Filter Type	Components	Materials
Fuel Filter	Filter-insert	Impregnated paper
	Filter housing	Polyamide or metal, e.g., thin sheet metal or aluminium
Oil Filter-Insert	Sealing ring	Elastomer
	Filter end cap	Thin galvanised sheet metal, aluminium
	Inner supporting frame	Perforated, thin galvanised sheet metal
	Filter bellow (Filter pleat)	Impregnated paper, felt, and in some cases plastic fleece
	Filter casing	Perforated special paper, and in some cases perforated sheet metal
Air Filter Insert	Filter end-cap	Permanently elastic PVC or PUR based moulding compounds, foamed or non-foamed. In some cases, thin sheet metal
	Inner supporting frame	Perforated paper or perforated sheet aluminium, in certain cases extendable stretched aluminium web.
	Filter bellow (Filter star)	Impregnated paper
	Filter casing	Perforated paper or perforated sheet aluminium

Filter Type	Components	Materials
Hydraulic Filter Insert	Sealing ring	Elastomer
	Filter end cap	Deep drawn sheet-metal V2A sheet metal (non-ferrous)
	Inner support frame	According to the end caps, perforated
	Filter bellow (Filter pleat)	Impregnated paper or metal material with varying mesh densities, felt
	Filter casing	Seldom available if found, then made from perforated sheet metal
Chemical Cleaning Plant Filter Inserts	Sealing ring	Elastomer
	Filter End Cap	Thin galvanised sheet metal or moulded from PUR
	Filter bellow (Filter pleat)	Impregnated paper
	Inner support frame	Special part made from perforated thin sheet metal
	Filter casing	not available Form stability achieved by fixing the folds
Air Conditioning Filter	Frames	Metals, large range of plastics or wood Filter Inserts
	Filter cells / mats	Special paper, glass-fibre matting, plastic fleece

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Filter Manufacture

Parts to be Joined
Joining Methods

Filter Type	Parts to be Joined	Joining Methods
Fuel Filter	Filter-insert with filter housing	High quality adhesives, usually epoxy's, which seal the filter according to the given conditions
Oil Filter-Insert	Sealing ring with filter end cap	Mostly a plug connection, otherwise contact or cyanacrylate adhesives. PUR adhesives are also possible
	End-cap with filter pleat	Single-component PVC based adhesive or a two-component PUR based reaction adhesive
	Filter pleat seam	Metal clip or bonding with a dispersion or hot-melt adhesive
	Filter casing	made from paper, then sewn or bonded with dispersion adhesive or hot melt adhesive; sheet metal is mechanically bonded
Air Filter Inserts for Motor Vehicles	Sealing ring with filter end-cap	As in 2 above, in those cases where a metal end-cap is used, e.g., filters for commercial vehicles
	Filter end-cap with filter pleat	When a metal end-cap is used, the bonding agent is described in 2 above
	End-cap cast with filter pleat	Without the use of a metal end cap ! The 'self-supporting non-metallic' end cap is an integral cast. The casting process is carried out with either PVC (one-component, hot-gelling), or PUR (two-component, cold setting) based moulding compounds. Due to their permanently elastic properties these end-caps are self-sealing and therefore do not require sealing rings

Filter Type	Parts to be Joined	Joining Methods
Air Filter Inserts for Motor Vehicles (continued)	End-cap cast with filter pleat	Without the use of a metal end cap ! The 'self-supporting non-metallic' end cap is moulded. The moulding process is carried out with either PVC (one-component, hot-gelling), or PUR (two-component, cold setting) based moulding compounds. Due to their permanent - elastic properties these end-caps are self-sealing and therefore do not require sealing rings
Hydraulic Filter Inserts	End-cap with filter pleat	High-quality epoxy based adhesive. In the case of highly stressed filters and aggressive fluids, the connection is soldered
	Filter bellow seam	With paper, metal clips are used; and with metal, plumber's solder is used. It is also possible to use thixotropic epoxy adhesive.
Inserts for Chemical Cleaning Filter	End-cap with filter pleat	The criterion is the resistance to PER and PER resistant PUR, plastisol or epoxy as bonding agent for sheet metal end caps. For non-metallic end-caps a PUR moulding compound is used.
	Filter pleat seam	Metal clip
Air Filter for Air Conditioning Systems	Due to the diversity of construction, it is not possible to provide a schematic outline. Filter cartridges and filter cells are used. Frames made from wood, plastic and metal are bonded and sealed with filter paper and filter fleece using two-component PUR moulding compounds.	

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Filter Adhesives and Moulding Compounds

Methods of Processing

Two-Component Epoxy System	For small batches, the adhesive is mixed and dosed manually, i.e., by hand. For serial production, an automatic mixing and dosing plant is used. The setting process can be accelerated by the application of heat. Single-sided application.
Two-Component Polyurethane System	Excellent suitability for large serial production as the setting process can be accelerated. To bridge the short setting time, an automatic mixing and dosing device should be used together with a rotating table or conveyor belt. Thereby both end-caps can be bonded in rapid succession. Single sided application. Optimal cycle times.
PVC based plastisol	Single-component product, simple dosing is possible using a barrel pump and dosing valves. However, a more complicated process is required to promote the gelling process by using a tunnel oven (tunnel dryer) or electrically heated plates. The production output can be accelerated by overhead or double-sided processing, i.e., the adhesive in each of the end-caps hardens (or forms a gel) simultaneously. During this process the adhesive must be prevented from dripping out of the upper end-cap (upper head). The requirement for this is a carefully measured level of viscosity coupled with a reasonable degree of thixotropy.
Moulding Compounds based upon PUR for non-metallic Filter End-Cap	Excellent suitability for large series production as it PUR for non-metallic Filter End-Caps sets fast at normal temperatures. Simple processing is possible using mixing and dosing equipment. Dosing into casting moulds following which the hardened form can be removed after just a few minutes. By using a rotating table, the cycle times can be easily controlled. PUR systems are available in compact hardening levels from hard to soft (Shore Hardness Grades). Foam systems with differing densities are also available. A double process enables two consecutive moulding processes, i.e., an elastic sealing lip can be moulded onto a hard end-cap.
Dispersion Adhesive	Double-sided adhesive application. Dosing by means of a pressurised container and a pistol applicator. Evaporation and pressing allow contact bonding

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Methods of Processing

Hot Melt Adhesive	Single-sided adhesive application. Dosing using a hot-melt application plant fitted with a spray head. Short cooling and pressing process times enable rapid bonding.
Hot Melt Adhesive for Special Purposes	For improved handling of filter pleats, a thread of Special Purposes hot-melt adhesive can be applied to the top edges of the pleated paper immediately following pleating. This provides the filter bellows with a greater degree of stability during any further processing, and the filter folds have a uniform shape. In principle the same can be performed with PVC plastisols, however in this case a gelling process is required too, i.e., it is not suitable for 'non-curing' paper.
Hot Melt Adhesive for Pocket Filters	Integrated in the manufacture of the filter folds, the for Pocket Filters fold is bonded into a pocket form using a bead of hot-melt adhesive which is applied to both sides of the filter bellows. When a hot-melt adhesive is used which is resistant to high temperatures, hardening of the filter paper is possible. However, in this case the hot-melt must be processed using an extruder.

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KLEIBERIT Products

Brief Description

- Processing
- Properties
- Technical Data Sheets

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KLEIBERIT Products

Brief Description

Welglue 383.2

This solvent-free dispersion adhesive can be employed for all paper bonds which are necessary for the manufacture of motor vehicle filter inserts.

Example of the working procedure required for the bonding of folds for pocket filters

KLEIBERIT Welglue 383.2 is filled into a pressurised container from which it is pumped to two thread pistols. These pistols provide a continuous thread of adhesive, approximately 0·5 mm in diameter to both outer sides of the paper web. The paper which now bears adhesive is transported to the evaporation station, (which can be a closed unit similar in form to a cabinet). The filter paper web is conveyed through the station in such a manner that an evaporation period of 60-90 seconds is attained.

The temperature in the evaporation station should be kept at approximately 60°C.

Following the above, the paper web reaches the pleating station. During the forming of the folds (pleating), the pressure necessary to bond the folds is produced automatically.

The next stage is to harden the filter paper (if necessary), following which the filter bellows can be cut to the required length.

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KLEIBERIT Products

Brief Description

Hot Setting Single-Component Adhesive Plastisol 513 - 516

Plastisols are adhesives **based upon PVC.**
They are used during the manufacture of motor vehicle filter inserts to bond metal filter end-caps to paper filter pleats. They can be processed without any great amount of technical effort. In most cases, the plastisol is fed from a pressurised container via a dosing valve into the filter end-cap. The filter end-cap is mounted on a rotating table underneath the dosing valve. The centrifugal force resulting from the rotation of the table serves to spread the adhesive over the complete surface of the end-cap.

In order to achieve their required solid aggregate condition, the plastisol must be gelled by exposure to heat. For this purpose, a source of either contact heat, (e.g., electrical heating plate), or heated circulating air (e.g., circulating air oven) is used.

Due to the inherent resistance to fluids (extraction) and the temperature resistance, it is possible to use plastisols to bond filter inserts for air, motor oil and diesel fuel filters.

Distinctive Features :

Plastisol 513.3	medium viscosity to slightly thixotropic
Plastisol 515.5	thixotropic consistency, can also be processed 'overhead'
Plastisol 516.6	low viscosity; flows extremely well, can be applied using dosing valves fitted with multiple outlets

The characteristics of plastisols can be influenced in many different ways, (e.g., viscosity, gelling properties). Please provide us with a description of your requirements. The following data sheets provide information concerning our standard products.

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KLEIBERIT Products

Brief Description

Hot Setting Single-Component Adhesive Plastisol 517 and 518

These moulding compounds, which **are based upon PVC** are used for the manufacture of motor vehicle air filters. They are used for the moulding non-metallic self-supporting end-caps which also function as a sealing ring.

As with all PVC materials, KLEIBERIT Plastisol 517 and 518 gel when exposed to heat. They form a compact permanently elastic material which is highly resistant to high and low temperatures.

Working Process

A dosing applicator is used to pour the necessary amount of material into the casting mould. The amount required depends upon the size of the mould. The shape of the casting mould accords to the shape of the air-filter end-cap for which it is being cast. The filter end-cap is mounted on a rotating table underneath the dosing unit. Thereby, the moulding compound is spread evenly in the casting mould. The paper filter pleat pack is placed into the fluid material.

The plastisol in the mould is now subjected to heat for a short time (usually with a heated plate) to cause it to gel slightly and to avoid it from falling out if the mould is turned upside down.

Once the plastisol has been poured into a second mould, the other side of the filter is placed into position. In most cases the filter now passes through an oven fitted with a circulating air facility during which the material is fully gelled.

Both sides can be heated using heating plates.

The two cold-setting two-component moulding compounds 526 and 547 described later in this brochure represent an alternative to the above and also provide savings in energy.

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KLEIBERIT Products

Cold Setting Two-Component Moulding Compounds and Foams.
Free from Chlorinated Fluorocarbons (CFC's)

Our two component systems are **based on PUR.**

These systems are used for the manufacture of air-filter inserts.
End-caps and sealing rings are cast in moulds or foamed.
Metal end-plates are not required. Air filters manufactured in this manner using elastic systems are self-sealing.

Two component systems are, as opposed to plastisols cold-hardening and therefore do not require exposure to heat in order to gel. That saves energy !

When in their hardened state they are ecologically friendly because they can be disposed of without any special measures being necessary.

Working Process
In order to process such two-component systems, mixing and dosing equipment is required. Please contact us for names and addresses of the manufacturers of such equipment.
The mixed system is either dosed into moulds (matrix) which either rotate underneath the dosing head of the application equipment, or are fed by a co-ordinate table system, or are fed by the applicator according to the shape of the mould. The filter paper pleat is placed into the moulding compound while it is still in a fluid state, following which the compound sets. After a few minutes the moulded assembly can be removed. Now the second end-cap (which is also a sealing ring) can be moulded.
For serial production a rotating table or a conveyor belt is recommended. Dependant upon the setting time of the moulding compound, the required time for each cycle for these devices and the number of casting moulds to be used can be determined. The setting reaction can also be suited to a pre-determined cycle period.

It is recommended that a release agent be used. Please contact us should you require any information required regarding such suitable products.

The product types 521, 524, 525, 526, and 547 represent the basic systems.

The following distinctive features should be noted:

521: PUR - Foam, soft-elastic
524: PUR - Moulding Compound, with or without foam reaction, semi-hard to hard
525: PUR- Moulding Compound, without foam reaction, hard. Can also be used as an adhesive
526: PUR- Moulding Compound, with foam reaction, soft-elastic
547: PUR- Moulding Compound, compact elastic
549: PUR- Moulding Compound, compact elastic

Please pay attention to the following technical data sheets It is possible to adjust the reaction of individual products according to other individual requirements.

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KLEIBERIT Products

Brief Description

Cold Setting Two-Component Reaction Adhesive Plastic-Mastic 531.1 and 531.8

Plastic-Mastic 531.1

This adhesive is **epoxy based**.
It is used to bond filter metal end-caps with filter pleats made from paper or wire mesh.
Owing to their resistance to fluids (extraction) as well as their temperature resistance, epoxy adhesives can be used for the manufacture of filter inserts for petrol/gasoline and hydraulic fluids.

To bond the filter bellows a thixotropic component A can be used (see 531.3).

The adhesive sets at room temperature (approx. 20° C). The process can be accelerated by warming the bond, which will also serve to increase the chemical resistance of the system.

After having been mixed, the adhesive can be manually processed.

However, it is safer and economically more advantageous to process the adhesive using a mixing and dosing plant designed for two-component adhesives. Please contact us should you require details of the manufacturers of such machinery.

Such application equipment can be complemented by the use of a rotating table upon which the filter end-cap is placed to be filled. The centrifugal force resulting from the rotation of the table serves to evenly spread the adhesive over the complete surface of the filter end-cap.

Plastic-Mastic 531.8

Filler-free low viscosity epoxy system adhesive

This product is used for coil filters to seal the end-cap against the filter housing.

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KLEIBERIT Products

Brief Description

Cold Setting Two-Component Adhesive 525, 571, 572 and Adhesive Foam 576.1

These adhesives are ***based upon PUR***. They are used in various fields to bond metal filter end-caps with filter pleats made from paper and for the manufacture of metal-free end-caps.

Distinctive Features

525	Filters for chemical cleaning machines (see Moulding Compounds)
572.1, 572.3 and 572.5:	Filters for air-conditioner, particularly good flow properties
571	Filters for the motor vehicle industry
576.1	(see 571), this is more commercially favourable due to its foaming reaction

These adhesives are processed using a two-component mixing and dosing plant. Please contact us should you require details of the manufacturers of such equipment. Due to the mechanical method of processing, the bonding is accelerated which in turn requires only a very short setting (or curing) period. This factor is important for short cycle times in the case of serial production.

The dosing of the adhesive is performed directly in the end cap (rotation principle). A rotating table or a conveyor belt bridges the setting time, which is only a few minutes.

The paper filter pleat is placed into the fluid adhesive. In most cases it is not necessary to provide additional heat for the setting process.

In the field of air conditioner there is a wide range of materials which are to be bonded or moulded, e.g. frames made from plastic, metal, or wood with various filter fleece materials.

Please provide us with details of your specific requirements.

1099 aw/eg

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KLEIBERIT Products

Brief Description

Hot-Melt Adhesive HM
715.5, 719, 791, 792, 795 N and 796

Hot-melt adhesives are mainly used as a support in the assembly stage and to bond filter paper.
In the case of air filter inserts, the filter bellow which is precisely cut lengthways is placed into the mould. This is difficult if the filter pleats have not been fixed. If the hot-melt adhesive is applied immediately following the pleating station (where the folds or pleats are formed), the filter pleats can be handled without problem.
The bead of hot-melt adhesive is placed in such a manner that it will be subsequently enclosed by the air-filter moulding compound.
A further use is bonding of filter folds to form so-called "pocket filters" which are used mainly used for air filters.

KLEIBERIT Hot-Melt Adhesive SK 715.5	Base: Polyethylene
KLEIBERIT Hot-Melt Adhesive SK 719	Base: EVA
KLEIBERIT Hot-Melt Adhesive SK 791	Base: Polyamide
KLEIBERIT Hot-Melt Adhesive SK 792	Base: Polyester
KLEIBERIT Hot-Melt Adhesive SK 795 N	Base: Polyester
KLEIBERIT Hot-Melt Adhesive SK 796	Base: Polyester

For the purposes of application, commercially available application appliances can be used. Please contact us should you require details of the manufacturers of such appliances.

These KLEIBERIT Hot-Melt Adhesives cannot be used filter manufacturing which requires subsequent gelling of PVC plastisol at high temperatures. Nevertheless, the filter paper can be hardened / cured using KLEIBERIT Hot-Melt Adhesive 792 and 795 N.