Air Filtration Solutions
Mechanical Fluid Filtration Solutions
Henkel. Improving your process, understanding your challenges.

Proven filtration solutions for all your needs – today and tomorrow

Filter manufacturers face daily challenges – reducing costs, improving efficiency, and staying ahead of the competition, to name just a few. Many suppliers can offer an adhesive. But Henkel offers much more: Engineering expertise to integrate the adhesives into your manufacturing process, custom-formulated products to meet your specific application requirements, and the innovation pipeline to offer you a continuous stream of new and creative solutions.

Henkel is in the business of solving problems. With our history and experience in the filtration industry, our experts can help find ways to improve your process. We can show you how to reduce your adhesive consumption while improving filter efficiency. And we’ll provide all the testing data to back up our recommendations.

Let us show you the value Henkel offers.

WHY HENKEL?

Henkel, the leading solution provider for adhesives, sealants and functional coatings worldwide, provides more than adhesives. We work with you to optimize your manufacturing process, identify improvements, and solve your toughest challenges.

We’re your partner every step of the way.
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**GLOBAL SUPPORT**

no matter where in the world you’re located.

**GLOBAL SUPPLY CHAIN**

to maintain a reliable supply of products to our customers.

**CUSTOMIZED SOLUTIONS**

We will create the formula that meets your exact requirements.

**INTEGRATED MANUFACTURING PROCESS**

to ensure our equipment works seamlessly with your production line.

**BROAD PRODUCT PORTFOLIO**

to provide the optimum solution for your challenges.

**INNOVATION**

More than 30% of our sales comes from products launched in the past five years.

**ENGINEERING SERVICES**

10 R&D centers around the world staffed by 3,000 design and application professionals.

**COMPREHENSIVE TESTING**

to support our product and process recommendations.

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Filtration Expertise and Value-Added Partnership

Henkel offers in-depth industry knowledge and the broadest technology portfolio in the business. With a global team dedicated to the filtration industry, Henkel offers years of experience, support and expertise. Combined with our broad product portfolio, we can provide solutions for just about any product or process challenge.
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Henkel offers a broad range of adhesives for filtration applications. The following is a brief overview of the various adhesives described in this catalog.

Your Henkel representative can help you identify the best adhesive for your application.

**Hot Melts (HM)**

General purpose, most cost-effective adhesive for many filtration applications:
- **Pressure Sensitive Adhesive (PSA)** – Immediate fixture (permanent tack), broad adhesion to substrates
- **Ethyl Vinyl Acetate (EVA)** – Best foaming ability, general purpose, cost-effective
- **Polyolefin (PO)** – Broad range of adhesion, especially to hard-to-bond substrates; high strength and durability
- **Polyamide (PA)** – Fast setting and high bond strengths, higher temperature and chemical capabilities
- **Reactive Polyurethane (PUR)** – Higher temperature resistance and higher bond strength/durability (thermoset)

**High Performance Filtration Adhesives**

- **Two-Component Polyurethane (2K PU)** – Better temperature and chemical resistance vs. hot melts. Requires two-part mixing.
- **One-Component Epoxy (1K EP)** – Best chemical and highest temperature resistance. Requires heat to cure.
- **Water-Based Polyvinyl Acetate (PVA WB)** – “White glue,” low cost, slow to moderate set time, generally used for paper and wood.

This diagram provides a comparison of the bond strength and heat resistance of various types of hot melts.
CHEMISTRY GUIDE

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This diagram provides a comparison of the bond strength and heat resistance of various types of hot melts.
Bonding Variables
Creating a good quality hot melt adhesive bond requires attention to several factors. Heat management through application temperature and volume, combined with time management, are critical to proper use of hot melt adhesives.

Bonding Processes
The shape and volume of the adhesive deposition is critical to how the adhesive loses heat. This will have a major effect on the open and set times of the adhesive. Similarly, the thermal conductivity of the substrate will also dramatically affect the rate of heat loss. The difference in open time between a large bead placed on an insulator vs. a film placed on a conductor will be dramatic.

Factors Affecting Bond Quality
- Substrate: metal and non-metal
- Application temperature
- Volume of adhesive
- Closing pressure and time

Factors Affecting Open/Set Time
- Large Bead: (Slow heat loss)
- Small Bead: (Fast heat loss)
- Wipe: (Very fast heat loss)

Bonding Processes – Wetting
The ability of any liquid to attach itself to a substrate is called wetting. Wetting is driven primarily by the surface tension of the liquid and its relation to the substrate’s surface energy.

Bond Failures
When evaluating bond failures, it is important to note the type of failure to help determine the root cause. Having adhesive residue on both substrates indicates that the adhesive remained bonded but failed internally. This is called Cohesive failure. If either substrate comes away with no residue, then the failure is termed Adhesive failure, since adhesion to that substrate was lost. Sometimes the bonds can exhibit a combination of failure modes.

Factors Affecting Open/Set Time
- Insulator: (Slow heat loss)
- Conductor: (Fast heat loss)

Henkel’s technical experts can provide training on bonding processes and analysis, as well as recommendations on choosing the proper hot melt adhesive for your application.

Contact us at 1-800-562-8483.
**HOT MELT OVERVIEW**

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**FACTORS AFFECTING BOND QUALITY**
- Application temperature
- Volume of adhesive
- Closing pressure and time

**FACTORS AFFECTING OPEN/SET TIME**
- **BEAD CONFIGURATION**
  - Large Bead (Slow heat loss)
  - Small Bead (Fast heat loss)
  - Wipe (Very fast heat loss)

- **SUBSTRATE MATERIAL**
  - Insulator (Slow heat loss)
  - Conductor (Fast heat loss)

**GENERAL BONDING OVERVIEW**

**Bonding Processes – Wetting**
The ability of any liquid to attach itself to a substrate is called wetting. Wetting is driven primarily by the surface tension of the liquid and its relation to the substrate’s surface energy.

**CONSCISE VERSUS ADHESIVE FAILURE**
- Cohesive failure (desirable)
- Adhesive failure (undesirable)

**WETTING**
- Good wetting: Substrate with relatively smooth surface
- Poor wetting: Substrate with relatively rough surface

**Bond Failures**
When evaluating bond failures, it is important to note the type of failure to help determine the root cause. Having adhesive residue on both substrates indicates that the adhesive remained bonded but failed internally. This is called Cohesive failure. If either substrate comes away with no residue, then the failure is termed Adhesive failure, since adhesion to that substrate was lost. Sometimes the bonds can exhibit a combination of failure modes.

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Reduced adhesive consumption, improved performance

Henkel offers a unique range of foaming hot melt adhesives for pleating applications that can reduce adhesive consumption up to 65 percent. Adhesive foaming technology combines inert gas with hot melt adhesives to create a homogenous, closed cell foam mixture. Foaming offers a number of advantages:

- **Increased open time:** Nitrogen bubbles insulate the material, increasing work time and offering more flexibility.
- **Faster set time:** Foamed materials require less force to compress, producing a thin bond line. The thin bond line decreases the set time for better production rates.
- **Volumetric increase:** Increased volume has better gap-filling capabilities to improve bond strength.
- **Reduced adhesive consumption:** Foaming can reduce material consumption up to 65 percent depending on the hot melt material.
- **Improved penetration:** Foamed hot melt penetrates porous material for a stronger bond.
- **Improved wetting:** Foam requires less force to compress, allowing penetration of impervious surfaces to enhance application versatility.
- **Lower heat density:** Foamed hot melt materials reduce thermal distortion of temperature-sensitive substrates and improve operator safety.
- **Reduced sagging or running:** The thixotropic nature of foamed material reduces the tendency of materials to run or sag on sloped surfaces.

Foamed material can be applied in swirl, spray, bead or slot patterns. Henkel’s experts can test foaming adhesives for your application to optimize performance and meet your production requirements. Consult your Henkel representative for more information on foaming.

Good quality foam is required for consistent manufacturing. This image shows stable foam with enclosed bubbles, which creates a strong bond. This image shows over-foamed adhesive, which results in unstable bonding. Henkel’s technical experts can work with you to create the proper foaming rate for your application.
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SOLUTIONS FOR AIR FILTERS

Industrial filters must consistently deliver clean air under severe operating conditions. Whether the filters are used in automotive engines, heavy-duty equipment, dust collectors or vacuum cleaners, buyers demand high performance and reliability.

Henkel’s solutions include:

**Automotive Air Filters**

Heavy-duty air filters for construction vehicles need to withstand harsh operating environments. Many applications require high temperature and chemical resistance. Henkel offers the following solutions:

- **First pleat/last pleat bonding**: EVA and PA hot melts with a range of temperature resistance
- **End cap bonding**: Durable 2-part polyurethane and epoxy adhesives
- **Spiral wrap bonding**: PUR and PO hot melts with higher performance or cost-effective options

**Key Benefits:**

1. Wide range of processing speeds
2. High temperature resistance
3. High durability
4. High bond strength

**Industrial Air – Commercial and Residential Filters**

Air filters for commercial, residential and industrial use must consistently deliver high performance and reliability. Henkel’s solutions include:

- **Panel (HVAC) filters**: Hot melt and PVA water-based adhesives for frame bonding for plastic and paper frames; two-part polyurethanes for metal and plastic frames
- **Bag filters**: Hot melt and PVA water-based adhesives for seam sealing and frame bonding with a range of temperature resistance and open times/cure speeds

**Key Benefits:**

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**Industrial Air – High Efficiency Filters**

The stakes are high for laboratory, clean room and industrial filters. Dust contaminants can compromise an entire electronic assembly or skew the results of a laboratory study. Henkel has a full range of adhesive solutions for manufacturing HEPA and ULPA filters:

- **Pleating**: EVA hot melt adhesives with fast open and set speeds, foamable for cost savings; PA hot melts for higher temperatures
- **Frame bonding**: Two-part polyurethane adhesives with a range of viscosities, flame retardant, range of pot life/cure speeds

**Key Benefits:**

1. Wide range of processing speeds
2. High bond strengths
3. High flexibility
4. High durability
5. Industry approvals: UL 900 and UL 94 V-0
6. Foaming capabilities

**HEAVY-DUTY AIR FILTERS**

Joining First/Last Pleat

Pleating/Edge Sealing

Bonding or eliminating metal end caps
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HEAVY-DUTY AIR FILTERS

Joining First/Last Pleat
Pleating/Edge Sealing
Bonding or eliminating metal end caps
# Pleating – EVA Hot Melts

<table>
<thead>
<tr>
<th>PRODUCT NO.</th>
<th>TYPE</th>
<th>PLEATING SPEEDS</th>
<th>FLEXIBILITY</th>
<th>TEMPERATURE RESISTANCE</th>
<th>COL-DR</th>
<th>SOFTENING POINT (ºC/ºF)</th>
<th>VISCOSITY (cPs)</th>
<th>OPEN TIME (SEC.)</th>
<th>DESCRIPTION</th>
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<td>TECHNOMELT® AS 3354™*</td>
<td>EVA</td>
<td>High</td>
<td>High</td>
<td>Moderate</td>
<td>White</td>
<td>110/220</td>
<td>8,000</td>
<td>Short: 10-20</td>
<td>Fast set speeds (parallel to a PA)</td>
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<td>EVA</td>
<td>High</td>
<td>Moderate</td>
<td>Moderate</td>
<td>White</td>
<td>103/217</td>
<td>8,000</td>
<td>Short: 10-20</td>
<td>Flame retardant, rapid running speeds, good adhesion to media</td>
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<tr>
<td>E1H1649315 (Box)</td>
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<tr>
<td>TECHNOMELT® AS 3112™*</td>
<td>EVA</td>
<td>High</td>
<td>Moderate</td>
<td>Moderate</td>
<td>White</td>
<td>95/203</td>
<td>3,000</td>
<td>Short: 10-20</td>
<td>Excellent for high speed pleating and can be used foamed or unfoamed</td>
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<td>TECHNOMELT® AS 6370™*</td>
<td>EVA</td>
<td>High</td>
<td>High</td>
<td>Moderate</td>
<td>Off-white</td>
<td>103/217</td>
<td>1,475</td>
<td>Short: 10-15</td>
<td>Flame retardant, good adhesion to fiber glass &amp; polyester media</td>
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<td>TECHNOMELT® AS 7715™*</td>
<td>EVA</td>
<td>High</td>
<td>Moderate</td>
<td>Moderate</td>
<td>Off-white</td>
<td>103/217</td>
<td>2,400</td>
<td>Short: Medium: 30-23</td>
<td>Excellent flexibility, good heat resistance, best adhesion to fiber glass &amp; polyester media</td>
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<td>E1H1217880 (Box)</td>
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<tr>
<td>TECHNOMELT® AS 8647™*</td>
<td>EVA</td>
<td>High</td>
<td>Moderate</td>
<td>Moderate</td>
<td>Off-white</td>
<td>102/213</td>
<td>4,700 at 177°C/350°F</td>
<td>Medium: 40-80</td>
<td>Short: Medium: 40-80</td>
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<tr>
<td>IDH: Consult Henkel</td>
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<td>TECHNOMELT® AS 1214™</td>
<td>EVA</td>
<td>Moderate</td>
<td>Very High</td>
<td>Low</td>
<td>Off-white</td>
<td>75/167</td>
<td>2,000</td>
<td>Medium: 40-80</td>
<td>Long open time until solidified, PSA alternative – FDA 175.105</td>
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<td>TECHNOMELT® AS 6379™*</td>
<td>EVA</td>
<td>High</td>
<td>Low</td>
<td>Moderate</td>
<td>Light yellow</td>
<td>110/220</td>
<td>1,200 at 177°C/350°F</td>
<td>Medium-Lump: 30-40</td>
<td>Excellent hot tack for low compression applications – FDA 175.105</td>
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<td>E1H1649309 (Box)</td>
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<td>TECHNOMELT® AS 3115™*</td>
<td>EVA</td>
<td>High</td>
<td>High</td>
<td>Moderate</td>
<td>White</td>
<td>104/221</td>
<td>7,000,000,000</td>
<td>Short: 12-15</td>
<td>Good heat resistance, low shrinkage, foameable</td>
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<tr>
<td>E1H1217763 (Box)</td>
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<td>TECHNOMELT® AS 3116™*</td>
<td>EVA</td>
<td>High</td>
<td>High</td>
<td>Moderate</td>
<td>White</td>
<td>110/220</td>
<td>6,000</td>
<td>Short: 5-10</td>
<td>High flexibility for pleating air filters</td>
</tr>
<tr>
<td>E1H1217763 (Box)</td>
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<tr>
<td>TECHNOMELT® AS-3888™*</td>
<td>EVA</td>
<td>High</td>
<td>High</td>
<td>Moderate</td>
<td>White</td>
<td>110/220</td>
<td>5,000</td>
<td>Short: 5-10</td>
<td>Air filter &amp; gas turbine pleating, no filler, low shrinkage – FDA 175.105</td>
</tr>
<tr>
<td>E1H1217763 (Box)</td>
<td></td>
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* UL Class II Fire Retardant.
**AIR FILTERS – PRODUCT SELECTION GUIDE**

**HOT MELTS – TYPICAL PROPERTIES**

<table>
<thead>
<tr>
<th>PRODUCT NO.</th>
<th>TYPE</th>
<th>PLEATING SPEEDS</th>
<th>FLEXIBILITY</th>
<th>TEMPERATURE RESISTANCE</th>
<th>COLOR</th>
<th>SOFTENING POINT (ºC/ºF)</th>
<th>VISCOSITY (cPs)</th>
<th>OPEN TIME (SEC.)</th>
<th>DESCRIPTION</th>
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<tbody>
<tr>
<td>TECHNOMELT® AS 3254™</td>
<td>EVA</td>
<td>High</td>
<td>High</td>
<td>Moderate</td>
<td>White</td>
<td>110/230</td>
<td>8,000</td>
<td>Short: 10-20</td>
<td>Fast set speeds (parallel to a PA)</td>
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<tr>
<td>TECHNOMELT® AS 5060™</td>
<td>EVA</td>
<td>High</td>
<td>Moderate</td>
<td>White</td>
<td>109/220</td>
<td>8,000</td>
<td>Short: 10-20</td>
<td>Flame retardant, rapid running speeds, good adhesion to media</td>
<td></td>
</tr>
<tr>
<td>TECHNOMELT® AS 3112™</td>
<td>EVA</td>
<td>High</td>
<td>Moderate</td>
<td>White</td>
<td>95/203</td>
<td>3,000</td>
<td>Short: 10-20</td>
<td>Excellent for high speed pleating and can be used foamed or unfoamed</td>
<td></td>
</tr>
<tr>
<td>TECHNOMELT® AS 6730™*</td>
<td>EVA</td>
<td>High</td>
<td>High</td>
<td>Moderate</td>
<td>White</td>
<td>109/220</td>
<td>1,475</td>
<td>Short: 10-15</td>
<td>Excellent flexibility, good heat resistance, good adhesion to fiber glass &amp; polyester media</td>
</tr>
<tr>
<td>TECHNOMELT® AS 7770™*</td>
<td>EVA</td>
<td>High</td>
<td>High</td>
<td>Moderate</td>
<td>White</td>
<td>106/223</td>
<td>2,400</td>
<td>Short-Medium: 20-25</td>
<td>Excellent flexibility, good heat resistance, good adhesion to fiber glass &amp; polyester media</td>
</tr>
<tr>
<td>TECHNOMELT® AS 8647™*</td>
<td>EVA</td>
<td>High</td>
<td>Moderate</td>
<td>Moderate</td>
<td>Off-white</td>
<td>108/226</td>
<td>4,700 at 177°C/350°F</td>
<td>Medium: 40-60</td>
<td>Flame retardant, good adhesion to metals – FDA 175.105</td>
</tr>
<tr>
<td>TECHNOMELT® AS 1214™</td>
<td>EVA</td>
<td>Moderate</td>
<td>Very High</td>
<td>Low</td>
<td>Off-white</td>
<td>75/167</td>
<td>2,000</td>
<td>Medium: 40-90</td>
<td>Long open time until coated, PSA alternative – FDA 175.105</td>
</tr>
<tr>
<td>TECHNOMELT® AS 5070™</td>
<td>EVA</td>
<td>High</td>
<td>Low</td>
<td>Moderate</td>
<td>Light yellow</td>
<td>110/230</td>
<td>1,200 at 177°C/350°F</td>
<td>Medium-Lump: 20-40</td>
<td>Excellent hot tack for low compression applications – FDA 175.105</td>
</tr>
<tr>
<td>TECHNOMELT® AS 3113™</td>
<td>EVA</td>
<td>High</td>
<td>Moderate</td>
<td>White</td>
<td>104/221</td>
<td>7,000/8,000</td>
<td>Short: 12-15</td>
<td>Good heat resistance, low shrinkage, formable</td>
<td></td>
</tr>
<tr>
<td>TECHNOMELT® AS 3115™*</td>
<td>EVA</td>
<td>High</td>
<td>High</td>
<td>Moderate</td>
<td>White</td>
<td>110/230</td>
<td>6,000</td>
<td>Short: 5-10</td>
<td>High flexibility for pleating air filters</td>
</tr>
<tr>
<td>TECHNOMELT® AS-5806™*</td>
<td>EVA</td>
<td>High</td>
<td>High</td>
<td>Moderate</td>
<td>White</td>
<td>110/230</td>
<td>5,000</td>
<td>Short: 5-10</td>
<td>Air filter &amp; gas turbine pleating, no filler, low shrinkage – FDA 175.105</td>
</tr>
</tbody>
</table>

* UL Class II Fire Retardant.

**AIR FILTRATION / HEPA/ULPA**

**CLEAN ROOM – HEPA/ULPA**

**PLEATING**

**HOT MELTS**

**General Purpose**

- Cost-effective
- Foamable
- Fast open/set time
- Flame retardant
- Low outgassing

**Higher Temperature**

- Higher temperature resistance
- Fast open/set time

See Automotive Pleating section, page 22.
AIR FILTERS – PRODUCT SELECTION GUIDE

FRAME BONDING & FACE WELDING – PU

<table>
<thead>
<tr>
<th>PRODUCT NO.</th>
<th>POLYMER</th>
<th>VISCOSITY</th>
<th>MILD ABRASIVE</th>
<th>CURE TIME</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>LOCTITE® UK 072™ A</td>
<td>Ethyl</td>
<td>950</td>
<td>1.02</td>
<td>5 min.</td>
<td>Fast curing, low viscosity, excellent adhesion to metal, plastic, wood, media, etc.</td>
</tr>
<tr>
<td>LOCTITE® UK 072™ B</td>
<td>Ethyl</td>
<td>950</td>
<td>1.02</td>
<td>5 min.</td>
<td>Fast curing, low viscosity, excellent adhesion to metal, plastic, wood, media, etc.</td>
</tr>
<tr>
<td>LOCTITE® PE US5502™ A</td>
<td>Ethyl</td>
<td>950</td>
<td>1.02</td>
<td>5 min.</td>
<td>Fast curing, low viscosity, excellent adhesion to metal, plastic, wood, media, etc.</td>
</tr>
<tr>
<td>LOCTITE® PE US5502™ B</td>
<td>Ethyl</td>
<td>950</td>
<td>1.02</td>
<td>5 min.</td>
<td>Fast curing, low viscosity, excellent adhesion to metal, plastic, wood, media, etc.</td>
</tr>
<tr>
<td>LOCTITE® SI 593™ Black</td>
<td>Silicone</td>
<td>950</td>
<td>1.02</td>
<td>5 min.</td>
<td>Long term, excellent chemical resistance.</td>
</tr>
<tr>
<td>LOCTITE® SI 587™ Blue</td>
<td>Silicone</td>
<td>950</td>
<td>1.02</td>
<td>5 min.</td>
<td>Long term, excellent chemical resistance.</td>
</tr>
<tr>
<td>LOCTITE® SI 589™ Black</td>
<td>Silicone</td>
<td>950</td>
<td>1.02</td>
<td>5 min.</td>
<td>Long term, excellent chemical resistance.</td>
</tr>
</tbody>
</table>

AIR FILTERS – PRODUCT SELECTION GUIDE

FRAME BONDING

Two Part PU

- Range of viscosity: high flow to thixotropic
- Flame retardant
- Low outgassing/puerty
- Range of pot life/cure speed
- Range of filler content
- Chemical and temperature resistance
- Color (white available)

CURE-IN-PLACE GASKETING – SILICONE

<table>
<thead>
<tr>
<th>PRODUCT NO.</th>
<th>TYPE</th>
<th>SET SPEED</th>
<th>FLEXIBILITY</th>
<th>TEMPERATURE RESISTANCE</th>
<th>COLOR</th>
<th>VISCOSITY (cPs)</th>
<th>OPEN TIME (SEC.)</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>LOCTITE® SI 587™ Black</td>
<td>Silicone</td>
<td>Long</td>
<td>High</td>
<td>Very high</td>
<td>Black</td>
<td>30 (10g/min. extruder)</td>
<td>30</td>
<td>Cure-in-place gasket, temp. up to 400°F/204°C</td>
</tr>
<tr>
<td>LOCTITE® SI 589™ Black</td>
<td>Silicone</td>
<td>Long</td>
<td>High</td>
<td>Very high</td>
<td>Black</td>
<td>20 (3g/min. extruder)</td>
<td>5</td>
<td>Very thick, cure-in-place gasket, temp. up to 400°F/204°C</td>
</tr>
<tr>
<td>LOCTITE® SI 593™ Black</td>
<td>Silicone</td>
<td>Long</td>
<td>High</td>
<td>Very high</td>
<td>Blue</td>
<td>50 (0.5g/min. extruder)</td>
<td>50</td>
<td>Oil resistant, cure-in-place gasket, temp. up to 400°F/204°C</td>
</tr>
</tbody>
</table>

GASKET BONDING – INERT ADHESIVE

<table>
<thead>
<tr>
<th>PRODUCT NO.</th>
<th>TYPE</th>
<th>FLEXIBILITY</th>
<th>TEMPERATURE RESISTANCE</th>
<th>COLOR</th>
<th>VISCOSITY (cPs)</th>
<th>OPEN TIME (SEC.)</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>LOCTITE® AR™</td>
<td>PSA</td>
<td>Medium</td>
<td>Medium</td>
<td>Moderate</td>
<td>Clear</td>
<td>45</td>
<td>Bonding rubber or foam gaskets to metal or plastic end caps, 250°F/121°C temp. resistance, excellent chemical resistance.</td>
</tr>
<tr>
<td>LOCTITE® AR™</td>
<td>PSA</td>
<td>Medium</td>
<td>Medium</td>
<td>Moderate</td>
<td>Clear</td>
<td>175</td>
<td>Tackified adhesive for higher durability and for metal and rubber bond, excellent chemical resistance.</td>
</tr>
<tr>
<td>LOCTITE® AR™</td>
<td>PSA</td>
<td>Medium</td>
<td>Medium</td>
<td>Moderate</td>
<td>Clear</td>
<td>110</td>
<td>Bonding rubber or foam gaskets to metal or plastic end caps, 250°F/121°C temp. resistance, excellent chemical resistance.</td>
</tr>
<tr>
<td>LOCTITE® AR™</td>
<td>PSA</td>
<td>Medium</td>
<td>Medium</td>
<td>Moderate</td>
<td>Clear</td>
<td>30</td>
<td>Bonding rubber or foam gaskets to metal or plastic end caps, 250°F/121°C temp. resistance, excellent chemical resistance.</td>
</tr>
<tr>
<td>LOCTITE® AR™</td>
<td>PSA</td>
<td>Medium</td>
<td>Medium</td>
<td>Moderate</td>
<td>Clear</td>
<td>200</td>
<td>Highly flexible CA for applications that require high impact or bonding flexible substrates</td>
</tr>
<tr>
<td>LOCTITE® HY 489™</td>
<td>PSA</td>
<td>Medium</td>
<td>Medium</td>
<td>Moderate</td>
<td>Clear</td>
<td>10,000</td>
<td>&lt;3min.</td>
</tr>
</tbody>
</table>
**AIR FILTRATION / HEPA/ULPA**

- **Cure-in-Place Gasketing** - Eliminates cut gasket to provide solution in one step and cost savings
- **Gasket Bonding** - Provides high speed bonding of cut gaskets

### AIR FILTRATION / HEPA/ULPA

- **Range of viscosity; high flow to thixotropic**
- **Flame retardant**
- **Low outgassing/purity**
- **Range of pot life/cur time speed**
- **Range of filler content**
- **Chemical and temperature resistance**
- **Color (white available)**

### FRAME BONDING & FACE WELDING – PU

<table>
<thead>
<tr>
<th>PRODUCT NO.</th>
<th>TYPE</th>
<th>SET SPEED</th>
<th>FLEXIBILITY</th>
<th>TEMPERATURE RESISTANCE</th>
<th>COLOR</th>
<th>VISCOSITY (cPs)</th>
<th>FURTHER TIME (SEC.)</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>LOCTITE® PE 10000™</td>
<td>A</td>
<td>5-6</td>
<td>Fast</td>
<td>380ºF/193ºC</td>
<td>White</td>
<td>2000</td>
<td>200</td>
<td>Bonding rubber or foam gaskets to metal or plastic end caps, excellent chemical and temperature resistance.</td>
</tr>
<tr>
<td>LOCTITE® SI 598™</td>
<td>Spray</td>
<td>10-15</td>
<td>Very</td>
<td>400ºF/204ºC</td>
<td>Black</td>
<td>1000</td>
<td>100</td>
<td>Bonding rubber or foam gaskets to metal or plastic end caps, excellent chemical and temperature resistance.</td>
</tr>
<tr>
<td>LOCTITE® SI 587™</td>
<td>Spray</td>
<td>15-20</td>
<td>Very</td>
<td>400ºF/204ºC</td>
<td>Black</td>
<td>1000</td>
<td>100</td>
<td>Bonding rubber or foam gaskets to metal or plastic end caps, excellent chemical and temperature resistance.</td>
</tr>
</tbody>
</table>

### CURE-IN-PLACE GASKETING – SILICONE

<table>
<thead>
<tr>
<th>PRODUCT NO.</th>
<th>TYPE</th>
<th>TEMPERATURE RESISTANCE</th>
<th>COLOR</th>
<th>VISCOSITY (cPs)</th>
</tr>
</thead>
<tbody>
<tr>
<td>LOCTITE® AV 102™</td>
<td>250ºF/121ºC</td>
<td>Medium</td>
<td>300</td>
<td>Bonding rubber or foam gaskets to metal or plastic end caps, 250ºF/121ºC temp. resistance, excellent chemical resistance.</td>
</tr>
<tr>
<td>LOCTITE® AV 104™</td>
<td>250ºF/121ºC</td>
<td>Medium</td>
<td>300</td>
<td>Bonding rubber or foam gaskets to metal or plastic end caps, 250ºF/121ºC temp. resistance, excellent chemical resistance.</td>
</tr>
<tr>
<td>LOCTITE® AV 105™</td>
<td>400ºF/204ºC</td>
<td>Medium</td>
<td>300</td>
<td>Bonding rubber or foam gaskets to metal or plastic end caps, 400ºF/204ºC temp. resistance, excellent chemical resistance.</td>
</tr>
</tbody>
</table>
AIR FILTERS – PRODUCT SELECTION GUIDE

**TECHNOMELT® AS 4222™**
- IDH 884120 (Drum)
- IDH 1407069 (Box)

**TECHNOMELT® PS 8843™**
- IDH 475559 (Box)

**TECHNOMELT® 6009S™**
- IDH 1730862 (Box)
- PO High
- Moderate
- Moderate
- White
- 110/230
- 8,000
- Short:

**TECHNOMELT® AS 4216™**
- TECHNOMELT® AS 871B™
- IDH 73809 (Bag 20kg)
- PO Moderate
- Moderate
- High
- Translucent
- 125/261
- 2,900
- at 396ºF

**TECHNOMELT® AS 4206™**
- IDH 1348378 (Drum)

**FRAME ASSEMBLY – EVA HOT MELT**

**PRODUCT NUMBER**
<table>
<thead>
<tr>
<th>TYPE ASSEMBLY</th>
<th>TEMPERATURE RESISTANCE</th>
<th>OPEN TIME (SEC.)</th>
<th>COLOR</th>
<th>SOFTENING POINT (ºC)/(ºF)</th>
<th>VISCOSITY (LBS/GAL)</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>TECHNOMELT® 2032™</td>
<td>EVA Fast</td>
<td>High</td>
<td>Short</td>
<td>10-20</td>
<td>Light yellow</td>
<td>10/1020</td>
</tr>
<tr>
<td>TECHNOMELT® SUPRA 150™</td>
<td>EVA Fast</td>
<td>High</td>
<td>Short</td>
<td>10-20</td>
<td>White</td>
<td>10/1020</td>
</tr>
<tr>
<td>TECHNOMELT® SUPRA 720C®</td>
<td>EVA Fast</td>
<td>High</td>
<td>Medium</td>
<td>40-80</td>
<td>Light amber</td>
<td>11/1122</td>
</tr>
<tr>
<td>TECHNOMELT® SUPRA 740C®</td>
<td>EVA Fast</td>
<td>Moderate</td>
<td>Short</td>
<td>10-20</td>
<td>Light yellow</td>
<td>92/1098</td>
</tr>
<tr>
<td>TECHNOMELT® SUPRA 3411™</td>
<td>EVA Moderate</td>
<td>High</td>
<td>Medium</td>
<td>40-80</td>
<td>Medium yellow</td>
<td>10/1020</td>
</tr>
<tr>
<td>TECHNOMELT® EM 6172™</td>
<td>EVA Moderate</td>
<td>Low</td>
<td>Medium-Long</td>
<td>60-80</td>
<td>Light amber</td>
<td>74/1095</td>
</tr>
<tr>
<td>TECHNOMELT® 5266™</td>
<td>EVA Moderate</td>
<td>Medium</td>
<td>Short</td>
<td>20-40</td>
<td>Yellow</td>
<td>82/1076</td>
</tr>
</tbody>
</table>

**FRAME ASSEMBLY – WATER BASED (WB)**

**PRODUCT NUMBER**
<table>
<thead>
<tr>
<th>TYPE ASSEMBLY</th>
<th>TEMPERATURE RESISTANCE</th>
<th>OPEN TIME (SEC.)</th>
<th>COLOR</th>
<th>SOFTENING POINT (ºC)/(ºF)</th>
<th>VISCOSITY (LBS/GAL)</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>TECHNOMELT® COOL 806A™</td>
<td>EVA Fast</td>
<td>Moderate</td>
<td>Short</td>
<td>10-20</td>
<td>Light yellow</td>
<td>78/1069</td>
</tr>
</tbody>
</table>

**PRE-APPLIED HEAT REACTIVATED – HOT MELT**

**PRODUCT NUMBER**
<table>
<thead>
<tr>
<th>TYPE ASSEMBLY</th>
<th>TEMPERATURE RESISTANCE</th>
<th>OPEN TIME (SEC.)</th>
<th>COLOR</th>
<th>SOFTENING POINT (ºC)/(ºF)</th>
<th>VISCOSITY (LBS/GAL)</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>ADHESIVE-040-062-213 (3340®)</td>
<td>Long</td>
<td>Moderate</td>
<td>Low</td>
<td>6,000</td>
<td>50</td>
<td>8.5</td>
</tr>
<tr>
<td>ADHESIVE-51-3130™</td>
<td>Medium</td>
<td>Fast</td>
<td>90-250</td>
<td>Moderate</td>
<td>2,000</td>
<td>57</td>
</tr>
<tr>
<td>ADHESIVE-LA 5112™</td>
<td>Medium</td>
<td>Fast</td>
<td>90-250</td>
<td>High</td>
<td>1,800</td>
<td>57</td>
</tr>
<tr>
<td>ADHESIVE-LA 7186™</td>
<td>Short</td>
<td>Fast</td>
<td>90-120</td>
<td>High</td>
<td>1,780</td>
<td>61</td>
</tr>
<tr>
<td>ADHESIVE-AV 701™</td>
<td>Medium</td>
<td>Fast</td>
<td>90-250</td>
<td>High</td>
<td>4,000</td>
<td>56</td>
</tr>
<tr>
<td>ADHESIVE-PY 3095™</td>
<td>Medium</td>
<td>Fast</td>
<td>120-250</td>
<td>High</td>
<td>5,000</td>
<td>36</td>
</tr>
<tr>
<td>ADHESIVE-AV 504™</td>
<td>Medium</td>
<td>Fast</td>
<td>120-250</td>
<td>Medium</td>
<td>10,000</td>
<td>61</td>
</tr>
<tr>
<td>ADHESIVE-LA 7044™</td>
<td>Short</td>
<td>Fast</td>
<td>90-120</td>
<td>High</td>
<td>2,800</td>
<td>56</td>
</tr>
<tr>
<td>ADHESIVE-CG 003™</td>
<td>Medium</td>
<td>Fast</td>
<td>120-250</td>
<td>Medium</td>
<td>2,000</td>
<td>40</td>
</tr>
<tr>
<td>ADHESIVE-LA 7044 UTIL™</td>
<td>Short</td>
<td>Fast</td>
<td>90-120</td>
<td>High</td>
<td>2,800</td>
<td>56</td>
</tr>
</tbody>
</table>
AIR FILTRATION / HVAC

Air and Mechanical Fluid Filtration Solutions

- TECHNOMELT® AS 4222™
  - IDH 1217803 (Box) PO Moderate Moderate Moderate Off-white 135/275 10,000
- TECHNOMELT® PS 8843™
  - IDH 554668 (Box) PO Moderate Moderate Moderate Amber 118/244 10,000
- TECHNOMELT® AS 3210™
  - IDH 1217873 (Box) PO High High Moderate Off-white 152/305 3,800
- TECHNOMELT® 5303™
  - IDH 1348378 (Drum) PO Moderate Moderate High White 155/311 5,500
- TECHNOMELT® AS 8890™
  - IDH 1217803 (Box) PO Moderate Moderate Moderate Amber 118/244 10,000
- TECHNOMELT® EM 8572™
  - IDH 1217803 (Box) PO Moderate Moderate Medium-Long Medium-yellow 74/169 3,900
- TECHNOMELT® AS 2686™
  - IDH 1208300 (Bag) PO Medium-Medium Medium-Long Medium-yellow 82/176

PLASTIC

- SPEED FLEXIBILITY TEMPERATURE RESISTANCE COLOR SOFTENING POINT (ºC)/(ºF)
- Fastest set speeds Range of viscosities Well balanced performance, excellent water resistance – FDA 175.105
- Excellent adhesion to difficult to bond substrates, excellent high & low temp resistance, low odor – FDA 175.105
- Excellent adhesion to to media and polyethylene, low bleed through – FDA 175.105
- Excellent adhesion to difficult to bond substrates, excellent low energy costs, excellent adhesion to difficult to bond substrates – FDA 175.105
- Excellent adhesion to difficult to bond substrates, excellent high & low temp resistance, low odor – FDA 175.105

PAPER

- OPEN TIME (SEC.) TACK VISCOSITY (cPs) SOLIDS (%) PH DENSITY (L/KG) DESCRIPTION
- Bonds difficult to bond substrates, excellent cold temp. resistance, low bleed through – FDA 175.105

ABS/PS Frame

- FRAME ASSEMBLY – EVA HOT MELT
  - DESCRIPTION
  - Excellent adhesion to difficult to bond substrates – FDA 175.105

PO Hot Melt

- FRAME ASSEMBLY – WATER BASED (WB)
  - PRE-APPLIED HEAT REACTIVATED – HOT MELT

EVA Hot Melt

- FRAME ASSEMBLY – PO HOT MELT
  - VARIOUS ADHESIVES – TYPICAL PROPERTIES
  - TECHNOMELT® AS 2520™
    - IDH 1703025 (Box) PO Moderate Moderately Moderate Off-white 135/275 10,000
  - TECHNOMELT® PS 8403™
    - IDH 1410589 (Box) PO Long Medium Moderately Moderate Off-white 143/290 5,300
  - TECHNOMELT® AS 4222™
    - IDH 1217803 (Box) PO Short Short High Medium-yellow 160/340 8,100
  - TECHNOMELT® AS 4222™
    - IDH 1340278 (Drum) PO Medium Moderately High White 155/311 5,500
  - TECHNOMELT® Cogo™
    - IDH 135893 (Bag) PO Medium Moderately High Translucent 125/261 2,005 at 189ºF (370ºC)
  - TECHNOMELT® AS 6718™
    - IDH 1217873 (Box) PO High High Moderately Off-white 152/305 3,600
  - TECHNOMELT® AS 4218™
    - IDH 1530662 (Box) PO High High Moderately Medium-yellow 155/311 30,000
  - TECHNOMELT® 0089™
    - IDH 4702318 (Bag) PO Medium Moderately High White 110/220 8,600

PVA WB

- FRAME BONDING

Frame Bonding
AIR FILTERS – PRODUCT SELECTION GUIDE

HVAC

PLEATING AND STABILIZATION

EVA Hot Melt

- Cost-effective
- Range of viscosities
- Range of open/set times for ease of assembly

PSA Hot Melt

- Good adhesion to metal
- High instant tack
- Fast set speeds
- Roll coatable
- Cost effective

WIRE MESH

TECHNOMELT® AS 8647™

IDH 1649568 (Box)
IDH 1655665 (Drum)

EVA Moderate High Medium:

40-60
Off-white
150/302
1,100 at 177ºC/350ºF

Flame retardant, good adhesion to media – FDA 175.105

TECHNOMELT® 8370™

IDH 1554389 (Box)
IDH 164989 (Sack)

EVA Fast High Short:

10-20
Light yellow
150/311
36,600 at 177ºC/320ºF

Optimised viscosity for pleat stabilisation, fast set speeds for high process speeds.

TECHNOMELT® 7883™

IDH 1353256 (Bag)

EVA Fast High Short:

10-20
Light yellow
150/311
800 at 177ºC/320ºF

Very aggressive hot tack, low viscosity – FDA

TECHNOMELT® AS 4216™

IDH 1730862 (Box)

PO Moderate Moderate Medium:

40-60
White
150/311
30,000 at 177ºC/320ºF

Optimised viscosity for pleat stabilisation, fast set speeds for high process speeds.

Bag Filters

AIR FILTERATION / HVAC

BAG FILTERS

SEAM SEALING

EVA Hot Melt

- Temperature >100ºC
- Fast set
- Flame retardant
- Range of open time/cure speed

PA Hot Melt

- Most cost-effective
- Range of open time/cure speed

FRAME BONDING

General Purpose

Higher Temperature

PVA WB

See HVAC Frame Bonding, page 19.

See Automotive First/Last Pleat Bonding PA Hot Melts page 23.

STITCH SEAL/PLEAT SEPARATOR – EVA HOT MELT

Hot Melt Adhesives – Typical Properties

PRODUCT NUMBER TYPE ASSEMBLY TIME TEMPERATURE RESISTANCE OPEN TIME (SEC.) COLOR SOFTENING POINT (ºC/ºF) VISCOSITY PROFILE (cPs) DESCRIPTION

TECHNOMELT® AS 8647™

IDH 1649568 (Box)
IDH 1655665 (Drum)

EVA Moderate High Medium:

40-60
Off-white
150/302
1,100 at 177ºC/320ºF

Flame retardant, good adhesion to media – FDA 175.105

TECHNOMELT® 8370™

IDH 1554389 (Box)
IDH 164989 (Sack)

EVA Fast High Short:

10-20
Light yellow
150/311
36,600 at 177ºC/320ºF

Optimised viscosity for pleat stabilisation, fast set speeds for high process speeds.

TECHNOMELT® 7883™

IDH 1353256 (Bag)

EVA Fast High Short:

10-20
Light yellow
150/311
800 at 177ºC/320ºF

Very aggressive hot tack, low viscosity – FDA

TECHNOMELT® AS 4216™

IDH 1730862 (Box)

PO Moderate Moderate Medium:

40-60
White
150/311
30,000 at 177ºC/320ºF

Optimised viscosity for pleat stabilisation, fast set speeds for high process speeds.

* UL Class II Fire Retardant.

WIRE MESH / SCRIM ATTACHMENT – PSA HOT MELT

Hot Melt Adhesives – Typical Properties

PRODUCT NUMBER TYPE ASSEMBLY TIME TEMPERATURE RESISTANCE OPEN TIME (SEC.) COLOR SOFTENING POINT (ºC/ºF) VISCOSITY PROFILE (cPs) DESCRIPTION

TECHNOMELT® 2787™

IDH 1989546 (Box)
IDH 2140353 (Tote)

PSA Moderate Moderate Medium:

40-60
Medium amber
72/162
1,500

Good adhesion to glass, metal, PET & media – FDA 175.105

TECHNOMELT® EM 4005™

IDH 1353263 (Box)

PSA Moderate Moderate Medium:

40-60
Medium amber
72/162
1,500

Good adhesion to glass, metal, PET & media – FDA 175.105

Stitch Seal (EVA)
AIR FILTRATION / HVAC

PLEATING AND STABILIZATION

EVA Hot Melt

- Cost-effective
- Range of viscosities
- Range of open/set times for ease of assembly

PSA Hot Melt

- Good adhesion to metal
- High instant tack
- Fast set speeds
- Roll coatable
- Cost effective

WIRE MESH

HVAC

PLEAT SEPARATOR – EVA HOT MELT

| PRODUCT NUMBER TYPE ASSEMBLY TIME TEMPERATURE RESISTANCE OPEN TIME (SEC) COLOR SOFTENING POINT (ºC/ºF) VISCOSITY PROFILE (cPs) DESCRIPTION |
| --- | --- | --- | --- | --- | --- | --- |
| TECHNOMELT® AS 8647™ IDH 1649568 (Box) IDH 1655665 (Drum) EVA Moderate High Medium 40-60 Off-white 110/230 4,700 Translucent white 108/226 4,000 Excellent hot tack for low compression applications – FDA 175.105 |
| TECHNOMELT® AS 8370™ IDH 1649389 (Box) IDH 164989 (Sack) EVA Fast High Medium 40-60 Tan 110/230 1,000 Light tan 110/230 1,500 Excellent hot tack, excellent thermal stability extending pot life – FDA 175.105 |
| TECHNOMELT® AS 8448™ IDH 1329423 (Bag) IDH 1329233 (Tote) EVA Fast High Medium 40-60 Tan 110/230 1,100 Light tan 110/230 1,500 Excellent hot tack, excellent thermal stability extending pot life – FDA 175.105 |
| TECHNOMELT® AS 7883™ IDH 1353256 (Bag) EVA Fast High Short 10-20 Light yellow 150/302 800 Yellow 150/302 800 Very aggressive hot tack, low viscosity – FDA |

WIRE MESH / SCRIM ATTACHMENT – PSA HOT MELT

| PRODUCT NUMBER TYPE ASSEMBLY TIME TEMPERATURE RESISTANCE OPEN TIME (SEC) COLOR SOFTENING POINT (ºC/ºF) VISCOSITY PROFILE (cPs) DESCRIPTION |
| --- | --- | --- | --- | --- | --- |
| TECHNOMELT® 2757™ IDH 1989546 (Box) IDH 2140353 (Tote) PSA Moderate High Medium 40-60 Yellow 90/194 4,800 Yellow 90/194 4,800 Good adhesion to glass, metal, PET & metal – FDA 175.105 |
| TECHNOMELT® EM 4563™ IDH 1752823 (Box) PSA Moderate High Medium 40-60 Medium amber 72/162 1,500 Medium amber 72/162 1,500 Good adhesion to glass, metal, PET & metal – FDA 175.105 |

BAG FILTERS

SEAM SEALING

Frame Bonding

General Purpose

Higher Temperature

- Temperature >100°C
- Fast set
- Flame retardant
- Range of open time/cure speed

- Temperature <100°C
- High adhesion to difficult-to-bond media

PA Hot Melt

Most cost-effective

- Range of open time/cure speed

- Temperature >100°C
- Higher adhesion to difficult-to-bond media

See Automotive First/Last Pleat Bonding PA Hot Melt page 23.

FRAME BONDING

- Temperature <100°C
- Fast set
- Flame retardant
- Range of open time/cure speed

- Temperature >100°C
- Higher adhesion to difficult-to-bond media

See Automotive First/Last Pleat Bonding PA Hot Melt page 23.

STITCH SEAL/PLEAT SEPARATOR – EVA HOT MELT

| PRODUCT NUMBER TYPE ASSEMBLY TIME TEMPERATURE RESISTANCE OPEN TIME (SEC) COLOR SOFTENING POINT (ºC/ºF) VISCOSITY PROFILE (cPs) DESCRIPTION |
| --- | --- | --- | --- | --- | --- |
| TECHNOMELT® AS 8847™ IDH 1649389 (Box) IDH 1649568 (Drum) EVA Fast High Medium 40-60 Light yellow 110/230 1,350 Light yellow 110/230 1,350 Heat Reactivated – FDA 175.105 |

* UL Class II Fire Retardant.

BAG FILTERS

SEAM SEALING

Frame Bonding

General Purpose

Higher Temperature

- Temperature >100°C
- Fast set
- Flame retardant
- Range of open time/cure speed

- Temperature <100°C
- High adhesion to difficult-to-bond media

PA Hot Melt

Most cost-effective

- Range of open time/cure speed

- Temperature >100°C
- Higher adhesion to difficult-to-bond media

See Automotive First/Last Pleat Bonding PA Hot Melt page 23.

FRAME BONDING

- Temperature <100°C
- Fast set
- Flame retardant
- Range of open time/cure speed

- Temperature >100°C
- Higher adhesion to difficult-to-bond media

See Automotive First/Last Pleat Bonding PA Hot Melt page 23.

STITCH SEAL/PLEAT SEPARATOR – EVA HOT MELT

| PRODUCT NUMBER TYPE ASSEMBLY TIME TEMPERATURE RESISTANCE OPEN TIME (SEC) COLOR SOFTENING POINT (ºC/ºF) VISCOSITY PROFILE (cPs) DESCRIPTION |
| --- | --- | --- | --- | --- | --- |
| TECHNOMELT® AS 8067™ IDH 1648578 (Box) IDH 1653583 (Drum) EVA Fast High Medium 40-60 Off-white 108/226 4,000 Good adhesion to media – FDA 175.105 |
| TECHNOMELT® AS 8370™ IDH 1649389 (Box) IDH 164989 (Sack) EVA Fast High Medium 40-60 Tan 110/230 1,000 Off-white 110/230 1,500 Excellent hot tack, excellent thermal stability extending pot life – FDA 175.105 |
| TECHNOMELT® AS 8448™ IDH 1329423 (Bag) IDH 1329233 (Tote) EVA Fast High Medium 40-60 Tan 110/230 1,100 Light tan 110/230 1,500 Excellent hot tack, excellent thermal stability extending pot life – FDA 175.105 |
| TECHNOMELT® AS 7883™ IDH 1353256 (Bag) EVA Fast High Short 10-20 Light yellow 150/302 800 Light yellow 150/302 800 Very aggressive hot tack, low viscosity – FDA |

WIRE MESH / SCRIM ATTACHMENT – PSA HOT MELT

| PRODUCT NUMBER TYPE ASSEMBLY TIME TEMPERATURE RESISTANCE OPEN TIME (SEC) COLOR SOFTENING POINT (ºC/ºF) VISCOSITY PROFILE (cPs) DESCRIPTION |
| --- | --- | --- | --- | --- | --- |
| TECHNOMELT® 2757™ IDH 1989546 (Box) IDH 2140353 (Tote) PSA Moderate High Medium 40-60 Yellow 90/194 4,800 Yellow 90/194 4,800 Good adhesion to glass, metal, PET & metal – FDA 175.105 |
| TECHNOMELT® EM 4563™ IDH 1752823 (Box) PSA Moderate High Medium 40-60 Medium amber 72/162 1,500 Medium amber 72/162 1,500 Good adhesion to glass, metal, PET & metal – FDA 175.105 |

* UL Class II Fire Retardant.
# Air Filtration / Automotive and Heavy Duty Air Filters

## Automotive and Heavy Duty Air Filters

### Pleating, Stabilization and Edge Sealing

**General Purpose Flexibility (Cylindrical) Highest Temperature**

- Cost-effective
- High durability
- Fast set speeds

See HEPA/ULPA Pleating section, page 15.

### EVA Hot Melt

- Cost-effective
- Good temperature and chemical resistance
- Fast set speeds

See HEPA/ULPA Pleating section, page 15.

### PO Hot Melt

- Best temperature and chemical resistance
- Fast set speeds

See HVAC section, page 18.

### PA Hot Melt

- High durability
- Cost-effective
- Foamable

See HVAC section, page 18.

### First/Last Pleat Bonding

**Temperature <100°C**

- EVA Hot Melt
- PA Hot Melt

**Temperature >100°C**

- Best temperature and chemical resistance
- Fast set speeds

**Cost-effective**

**Good temperature and chemical resistance**

**Fast set speeds**

See HEPA/ULPA Pleating section for an EVA option, page 15.

## Pleating/Stabilization and Edge Sealing – PA Hot Melt

### Hot Melt Adhesives – Typical Properties

<table>
<thead>
<tr>
<th>PRODUCT NUMBER</th>
<th>TYPE</th>
<th>PLEATING SPEEDS</th>
<th>FLEXIBILITY</th>
<th>TEMPERATURE RESISTANCE</th>
<th>COLOR</th>
<th>SOFTENING POINT (ºC/ºF)</th>
<th>VISCOSITY (cPs)</th>
<th>OPEN TIME (SEC.)</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>TECHNOMELT® PA 6300™</td>
<td>IDH 1398258 (Bag)</td>
<td>PA</td>
<td>High</td>
<td>Moderate</td>
<td>Very High</td>
<td>Translucent</td>
<td>190/374</td>
<td>3,700 (cPs)</td>
<td>10-20</td>
</tr>
<tr>
<td>TECHNOMELT® PA 2102B™</td>
<td>IDH 1396375 (Bag)</td>
<td>PA</td>
<td>High</td>
<td>Moderate</td>
<td>High</td>
<td>Dark Amber</td>
<td>167/333</td>
<td>4,200 (cPs)</td>
<td>20-40</td>
</tr>
<tr>
<td>TECHNOMELT® PA 6240™</td>
<td>IDH 1397818 (Bag)</td>
<td>PA</td>
<td>Moderate</td>
<td>Moderate</td>
<td>High</td>
<td>Light Amber</td>
<td>142/269</td>
<td>7,000 (cPs)</td>
<td>40-80</td>
</tr>
<tr>
<td>TECHNOMELT® PA 2692™</td>
<td>IDH 1415054 (Bag)</td>
<td>PA</td>
<td>High</td>
<td>Moderate</td>
<td>Very High</td>
<td>Translucent</td>
<td>206/403</td>
<td>4,200 (cPs)</td>
<td>20-40</td>
</tr>
<tr>
<td>TECHNOMELT® PA 6238™</td>
<td>IDH 1861214 (Bag)</td>
<td>PA</td>
<td>Moderate</td>
<td>Moderate</td>
<td>High</td>
<td>Clear</td>
<td>133/271</td>
<td>5,000 (cPs)</td>
<td>60-80</td>
</tr>
<tr>
<td>TECHNOMELT® PA 6228™</td>
<td>IDH 1801214 (Bag)</td>
<td>PA</td>
<td>Moderate</td>
<td>Moderate</td>
<td>High</td>
<td>Clear</td>
<td>133/271</td>
<td>5,000 (cPs)</td>
<td>40-80</td>
</tr>
</tbody>
</table>

## First/Last Pleat Bonding

**Temperature <100°C**

- EVA Hot Melt
- PA Hot Melt

**Temperature >100°C**

- Best temperature and chemical resistance
- Fast set speeds

**Cost-effective**

**Good temperature and chemical resistance**

**Fast set speeds**

See HEPA/ULPA Pleating section for an EVA option, page 15.

### First/Last Pleat Bonding – PA Hot Melt

<table>
<thead>
<tr>
<th>PRODUCT NUMBER</th>
<th>TYPE</th>
<th>PLEATING SPEEDS</th>
<th>FLEXIBILITY</th>
<th>TEMPERATURE RESISTANCE</th>
<th>COLOR</th>
<th>SOFTENING POINT (ºC/ºF)</th>
<th>VISCOSITY (cPs)</th>
<th>OPEN TIME (SEC.)</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>TECHNOMELT® PA 2333B™</td>
<td>IDH 1396375 (Bag)</td>
<td>PA</td>
<td>Moderate</td>
<td>Moderate</td>
<td>High</td>
<td>Light Amber</td>
<td>142/269</td>
<td>3,000 (cPs)</td>
<td>10-20</td>
</tr>
<tr>
<td>TECHNOMELT® PA 9069™</td>
<td>IDH 1392850 (Bag)</td>
<td>PA</td>
<td>High</td>
<td>Moderate</td>
<td>Very High</td>
<td>Amber</td>
<td>185/365</td>
<td>3,700 (cPs)</td>
<td>10-20</td>
</tr>
<tr>
<td>TECHNOMELT® PA-2030™</td>
<td>IDH: Consult Henkel</td>
<td>PA</td>
<td>High</td>
<td>Moderate</td>
<td>High</td>
<td>Amber</td>
<td>163/320</td>
<td>6500 (mPas)</td>
<td>20-80</td>
</tr>
</tbody>
</table>
### Hot Melt Adhesives – Typical Properties

**Product Number** | **Type** | **Pleating Speeds** | **Flexibility** | **Temperature Resistance** | **Color** | **Softening Point (°C)** | **Viscosity (cPs)** | **Open Time (Sec.)** | **Description** |
<table>
<thead>
<tr>
<th></th>
<th></th>
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<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>TECHNOMELT® PA 6300™</td>
<td>IDH 1398258 (Bag)</td>
<td>PA</td>
<td>High</td>
<td>Moderate</td>
<td>Very High</td>
<td>Translucent</td>
<td>Amber</td>
<td>190/374</td>
<td>3,100</td>
</tr>
<tr>
<td>TECHNOMELT® PA 2102B™</td>
<td>IDH 1396375 (Bag)</td>
<td>PA</td>
<td>High</td>
<td>Moderate</td>
<td>High</td>
<td>Dark Amber</td>
<td>167/333</td>
<td>4,200</td>
<td>Short - Medium: 20-40</td>
</tr>
<tr>
<td>TECHNOMELT® PA 2035™</td>
<td>IDH 1398261 (Bag)</td>
<td>PA</td>
<td>Moderate</td>
<td>Moderate</td>
<td>High</td>
<td>Amber</td>
<td>206/393</td>
<td>7,000</td>
<td>Short: 10-20</td>
</tr>
<tr>
<td>TECHNOMELT® PA 6240™</td>
<td>IDH 1397818 (Bag)</td>
<td>PA</td>
<td>Moderate</td>
<td>Moderate</td>
<td>High</td>
<td>Light Amber</td>
<td>142/287</td>
<td>1,000</td>
<td>Medium: 40-60</td>
</tr>
<tr>
<td>TECHNOMELT® PA 2692™</td>
<td>IDH 1415054 (Bag)</td>
<td>PA</td>
<td>High</td>
<td>Moderate</td>
<td>Very High</td>
<td>Translucent</td>
<td>Amber</td>
<td>206/393</td>
<td>3,000</td>
</tr>
<tr>
<td>TECHNOMELT® PA 6238™</td>
<td>IDH 1861214 (Bag)</td>
<td>PA</td>
<td>Moderate</td>
<td>Moderate</td>
<td>High</td>
<td>Clear</td>
<td>165/329</td>
<td>750</td>
<td>Medium: Long: 60-80</td>
</tr>
<tr>
<td>TECHNOMELT® PA 6239™</td>
<td>IDH 38358 (Bag)</td>
<td>PA</td>
<td>Moderate</td>
<td>Moderate</td>
<td>High</td>
<td>Light</td>
<td>163/320</td>
<td>500</td>
<td>Medium: 40-60</td>
</tr>
</tbody>
</table>
AIR FILTERS – PRODUCT SELECTION GUIDE

AUTOMOTIVE AND HEAVY DUTY AIR FILTERS

END CAP BONDING

Higher Temperatures

Temperature Resistance

One-Part PA

Two Part PU

Two Part Epoxy

- Higher temperature resistance
- Fast open/set time
- Good temperature and chemical resistance
- Range of cure speeds
- Cost-effective
- High adhesion to metal and plastic

See Mechanical Fluid End Cap Bonding section, page 30.

END CAP BONDING – PA HOT MELTS

PRODUCT NUMBER TYPE VISCOSITY @ 240ºC/464°F OPEN TIME (SEC.) TEMPERATURE SOFTENING POINT (ºC)/ (ºF) CHEMICAL RESISTANCE DESCRIPTION

TECHNOMELT® PA-2035™

IDH 1415254 (Bag)

Translucent Light Amber 4,200 Short (10-20) Very High 200/400 ✓ Contact Bonded Contact Bonded High-temp. resistance, with excellent creep resistance and stable chemical resistance - FDA 175.105 approved.

TECHNOMELT® PA-9069™

IDH 1100203 (Pail)

Translucent Light Amber 3,700 Short (10-20) Very High 190/370 ✓ Contact Bonded Contact Bonded High-temp. resistance, with excellent creep resistance and stable chemical resistance. - FDA 175.105 approved.

TECHNOMELT® PA-2192B™

IDH 1223000 (Pail)

Dark Amber 4,200 Medium (20-25) High 167/333 ✓ Contact Bonded Contact Bonded Good chemical resistance and adhesion to plastics, metals and nitrile. - FDA 175.105.

TECHNOMELT® PA-6300™

IDH 1158908 (Bag)

Amber 3,700 Medium (20-25) Very High 185/365 ✓ Contact Bonded Contact Bonded High-temp. resistance, with excellent creep resistance and stable chemical resistance. - FDA 175.105 approved.

TECHNOMELT® PUR™ 246CLV™

IDH 970446 (Drum)

Amber 4,200 Medium (20-25) Very High 200/398 ✓ Contact Bonded Contact Bonded High-temp. resistance, with excellent creep resistance and stable chemical resistance. - FDA 175.105 approved.

TECHNOMELT® PUR™ 9016™

IDH 1392850 (Bag) Amber 3,700 at 210ºC/410°F Short 10-20 Very High 210/410 ✓ Contact Bonded Contact Bonded High-temp. resistance, with excellent creep resistance and stable chemical resistance. - FDA 175.105 approved.

TECHNOMELT® PUR™ 5303™

IDH 1398258 (Bag) PUR 7,500 at 121ºC/250°F Short (10-20) Very High NA ✓ ✓ ✓ High-temp. resistance, with excellent creep resistance and stable chemical resistance. - FDA 175.105 approved.

TECHNOMELT® PUR™ 246CLV®

IDH 1158908 (Bag)

Translucent Light Amber 3,700 Short (10-20) Very High 190/370 ✓ Contact Bonded Contact Bonded High-temp. resistance, with excellent creep resistance and stable chemical resistance. - FDA 175.105 approved.

TECHNOMELT® 535S™

IDH 122899 (Bag 2kg)

PO 2,900 at 190ºC/380°F Medium (30-60) High 125/261 ✓ Contact Bonded Contact Bonded High-temp. resistance, with excellent creep resistance and stable chemical resistance. - FDA 175.105 approved.

TECHNOMELT® PUR™ 8015™

IDH 1392850 (Bag)

Translucent Light Amber 4,200 at 210ºC/410°F Short (10-20) Very High 206/403 ✓ Contact Bonded Contact Bonded High-temp. resistance, with excellent creep resistance and stable chemical resistance. - FDA 175.105 approved.

TECHNOMELT® PUR™ 8015™

IDH 1398258 (Bag)

Translucent Light Amber 3,700 at 210ºC/410°F Short (10-20) Very High 185/365 ✓ Contact Bonded Contact Bonded High-temp. resistance, with excellent creep resistance and stable chemical resistance. - FDA 175.105 approved.

TECHNOMELT® PUR™ 246CLV™

IDH 1158908 (Bag)

Translucent Light Amber 3,700 at 210ºC/410°F Short (10-20) Very High 190/370 ✓ Contact Bonded Contact Bonded High-temp. resistance, with excellent creep resistance and stable chemical resistance. - FDA 175.105 approved.

TECHNOMELT® PUR™ 9016™

IDH 1392850 (Bag) Amber 3,700 at 210ºC/410°F Short (10-20) Very High 210/410 ✓ Contact Bonded Contact Bonded High-temp. resistance, with excellent creep resistance and stable chemical resistance. - FDA 175.105 approved.
Air and Mechanical Fluid Filtration Solutions

**AIR FILTRATION / AUTOMOTIVE AND HEAVY DUTY AIR FILTERS**

**AIR FILTERS – PRODUCT SELECTION GUIDE**

**TECHNOMELT® PA 2035™**
**TECHNOMELT® PA 9069™**
**TECHNOMELT® PA 2192B™**
**TECHNOMELT® PA 6300™**
**TECHNOMELT® PA 2692™**

- **IDH 1396799 (Sack)**
- **IDH 1398258 (Bag)**
- **IDH 1392850 (Bag) Amber 3,700 at 232ºC/450°F**
- **IDH 1396374 (Bag)**

**END CAP BONDING – PA HOT MELTS**

<table>
<thead>
<tr>
<th>PRODUCT NUMBER</th>
<th>COLOR</th>
<th>VISCOSITY @ 20ºC/68ºF</th>
<th>OPEN TIME (SEC.)</th>
<th>TEMPERATURE RESISTANCE</th>
<th>SOFTENING POINT (ºC)/ (ºF)</th>
<th>CHEMICAL RESISTANCE</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>TECHNOMELT® PA 2035™</strong></td>
<td>Translucent Light Amber</td>
<td>4,200</td>
<td>Short (10-20)</td>
<td>Very High</td>
<td>300/603</td>
<td>Contact Heated</td>
<td>Contact Heated</td>
</tr>
<tr>
<td><strong>TECHNOMELT® PA 2692™</strong></td>
<td>Translucent Light Amber</td>
<td>3,700</td>
<td>Short (10-20)</td>
<td>Very High</td>
<td>190/327</td>
<td>Contact Heated</td>
<td>Contact Heated</td>
</tr>
<tr>
<td><strong>TECHNOMELT® PA 5303™</strong></td>
<td>Dark Amber</td>
<td>4,200 at 210ºC/410ºF</td>
<td>Short-Medium: (30-70)</td>
<td>High</td>
<td>167/333</td>
<td>Contact Heated</td>
<td>Contact Heated</td>
</tr>
<tr>
<td><strong>TECHNOMELT® PA 1394™</strong></td>
<td>Transparent Light Amber</td>
<td>3,700 at 210ºC/410ºF</td>
<td>Short (10-20)</td>
<td>Very High</td>
<td>155/325</td>
<td>Contact Heated</td>
<td>Contact Heated</td>
</tr>
<tr>
<td><strong>TECHNOMELT® PA 2535™</strong></td>
<td>Transparent Light Amber</td>
<td>4,200 at 220ºC/430ºF</td>
<td>Short: (10-20)</td>
<td>Very High</td>
<td>200/400</td>
<td>Contact Heated</td>
<td>Contact Heated</td>
</tr>
</tbody>
</table>

**END CAP BONDING – PA HOT MELTS**

- **Two part highest structural bonding and larger gaps**
- **Bonding end caps, 250°F temp. resistance, high deformation resistance.**

**SPIRAL BEAD – TWO PART PUR HOT MELTS**

- **High Performance**
  - Highest strength and durability
  - Highest temperature resistance
  - Less adhesive required to reach performance requirements

- **General Purpose**
  - Highest durability
  - Cost-effective
  - Foamable

**PUR**

**PO Hot Melt**

**SPIRAL BEAD – PO AND PUR HOT MELTS**

<table>
<thead>
<tr>
<th>PRODUCT NUMBER</th>
<th>TYPE</th>
<th>VISCOSITY</th>
<th>OPEN TIME (SEC.)</th>
<th>TEMPERATURE RESISTANCE</th>
<th>SOFTENING POINT (ºC)/ (ºF)</th>
<th>CHEMICAL RESISTANCE</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>TECHNOMELT® PIR™ 3016™</strong></td>
<td>PUR</td>
<td>7,000 at 121ºC/250ºF</td>
<td>Short (10-20)</td>
<td>Very High</td>
<td>NA</td>
<td>✔ ✔ ✔</td>
<td>Exudation, spray or roll on and dry, 250°F temp. resistance, very fast setting, high deformation resistance.</td>
</tr>
<tr>
<td><strong>TECHNOMELT® PIR™ 246CLV™</strong></td>
<td>PUR</td>
<td>15,000 at 82ºC/180ºF</td>
<td>Medium: (40-80)</td>
<td>Very High</td>
<td>NA</td>
<td>✔ ✔ ✔</td>
<td>Excellent adhesion to difficult to bond substrates with low dispense temperatures.</td>
</tr>
<tr>
<td><strong>TECHNOMELT® X365™</strong></td>
<td>PO</td>
<td>2,900 at 130ºC/266ºF</td>
<td>Medium: (30-60)</td>
<td>High</td>
<td>125/265</td>
<td>Contact Heated</td>
<td>Contact Heated</td>
</tr>
</tbody>
</table>

**SPIRAL BEAD**

**GASKET BONDING**

**VARIOUS ADHESIVES – TYPICAL PROPERTIES**

<table>
<thead>
<tr>
<th>PRODUCT NUMBER</th>
<th>TYPE</th>
<th>FLEXIBILITY</th>
<th>TEMPERATURE RESISTANCE</th>
<th>COLOR</th>
<th>VISCOSITY (cPs)</th>
<th>FIXTURE TIME (SEC.)</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>LOCTITE® 485™</strong></td>
<td>CA</td>
<td>Low</td>
<td>Medium: (212ºC/250ºF)</td>
<td>Clear</td>
<td>45</td>
<td>20</td>
<td>Bonding rubber or foam gaskets to metal or plastic end caps, 250°F temp. resistance, excellent chemical resistance.</td>
</tr>
<tr>
<td><strong>LOCTITE® 425™</strong></td>
<td>CA</td>
<td>Low</td>
<td>Medium: (212ºC/250ºF)</td>
<td>Clear</td>
<td>175</td>
<td>30-45</td>
<td>Toughened adhesive for higher durability and for metal and rubber bonding, excellent chemical resistance.</td>
</tr>
<tr>
<td><strong>LOCTITE® 467™</strong></td>
<td>CA</td>
<td>Medium</td>
<td>Medium: (212ºC/250ºF)</td>
<td>Clear</td>
<td>110</td>
<td>15</td>
<td>Bonding rubber or foam gaskets to metal or plastic end caps, 250°F temp. resistance, excellent oil resistance.</td>
</tr>
<tr>
<td><strong>LOCTITE® 454™</strong></td>
<td>CA</td>
<td>Low</td>
<td>Medium: (212ºC/250ºF)</td>
<td>Clear</td>
<td>260</td>
<td>10-30</td>
<td>Highly flexible CA for applications that require high impact or bonding flexible substrates.</td>
</tr>
<tr>
<td><strong>LOCTITE® HM 4006™</strong></td>
<td>CA</td>
<td>Low</td>
<td>Medium: (212ºC/250ºF)</td>
<td>Clear</td>
<td>10,000</td>
<td>&lt;3min</td>
<td>Two part highest structural bonding and larger gaps for bonding rubber or foam gaskets to metal or plastic end caps, 250°F temp. resistance, excellent oil resistance.</td>
</tr>
</tbody>
</table>
Mechanical fluid filters must withstand exposure to the most intense operating conditions. Despite continuous exposure to hot oils or solvents, these filters must remove particulates to keep engines and equipment running effectively.

Henkel’s solutions include:

**Mechanical Fluid Filters**
- **First pleat/last pleat bonding:** Hot melts with fast set times; epoxies with higher temperature and chemical resistance
- **Pleating/edge sealing:** Hot melts with good temperature and chemical resistance
- **End cap bonding:** Wide range of one- and two-part epoxies, hot melts, and polyurethanes with a range of temperature and chemical resistance
- **End cap replacement:** Hot melts and two-part polyurethanes with a range of viscosities and chemical resistance
- **End cap demolding:** Mold release agents with a range of finishes
- **Crimp sealing:** Anaerobic adhesives with a range of gap filling and fixture speeds

**Key Benefits:**
1. High temperature resistance
2. Chemical compatibility
3. High bond strength
4. Media compatibility
SOLUTIONS FOR FLUID FILTERS

Mechanical fluid filters must withstand exposure to the most intense operating conditions. Despite continuous exposure to hot oils or solvents, these filters must remove particulates to keep engines and equipment running effectively.

Henkel’s solutions include:

Mechanical Fluid Filters

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- End cap bonding: Wide range of one- and two-part epoxies, hot melts, and polyurethanes with a range of temperature and chemical resistance
- End cap replacement: Hot melts and two-part polyurethanes with a range of viscosities and chemical resistance
- End cap demolding: Mold release agents with a range of finishes
- Crimp sealing: Anaerobic adhesives with a range of gap filling and fixture speeds

Key Benefits:

1. High temperature resistance
2. Chemical compatibility
3. High bond strength
4. Media compatibility
MECHANICAL FLUIDS

FLUID FILTERS – PRODUCT SELECTION GUIDE

END CAP BONDING

ONE-PART SOLUTIONS

PA Hot Melts

- Cost-effective
- Versatile
- Fast to moderate open time
- Good temperature resistance

TWO-PART SOLUTIONS

One-Part Heat Cured Epoxies

- Best chemical resistance
- Best temperature resistance
- Thermal shock resistance

PUR

- High adhesion and durability
- Better chemical resistance
- Better temperature resistance

Two-Part Epoxies

- Best chemical resistance
- Better temperature resistance

Two-Part PU

- Better chemical resistance
- Good temperature resistance
- Highest adhesion

END CAP REPLACEMENT

PA Hot Melts

- Good temperature resistance
- Cost effective
- Lighter colors or black
- Longer open times
- Viscosity range

END CAP DEMOLDING

LOCTITE® FREKOTE® Mold Release

- Sacrificial
- Range of finishes
- High clarity of mold features (i.e., lettering)

*Diesel Fuel, Hydraulic Fluid, Transmission Fluid, Anti-Freeze Compatible
+Flame Retardant UL900 or 94V-0

FIRST/LAST PLEAT

HOT MELTS

Considerations for PA hot melts:

- Cost-effective
- Set time – fast to moderate
- Good temperature resistance
- Good chemical resistance

HIGHER CHEMICAL OR TEMPERATURE RESISTANCE

Considerations for epoxies:

- Best temperature resistance
- Better chemical resistance
- Range of pot life vs. cure speed

END CAP DE-MOLDING

LOCTITE® FREKOTE® Mold Release

- Sacrificial
- Range of finishes
- High clarity of mold features (i.e., lettering)

*Diesel Fuel, Hydraulic Fluid, Transmission Fluid, Anti-Freeze Compatible
+Flame Retardant UL900 or 94V-0

END CAP BONDING

ONE-PART SOLUTIONS

PA Hot Melts

- Good temperature resistance
- Cost effective
- Lighter colors or black
- Longer open times
- Viscosity range

TWO-PART SOLUTIONS

One-Part Heat Cure Epoxies

- Better chemical resistance
- Better temperature resistance
- Range of pot life vs. cure speed

PUR

- High adhesion and durability
- Better chemical resistance
- Better temperature resistance

Two-Part Epoxies

- Best chemical resistance
- Better temperature resistance

Two-Part PU

- Better chemical resistance
- Good temperature resistance
- Highest adhesion

HOT MELTS FOR PLEATING OR EDGE SEALING

PA Hot Melts

- Set time – fast to moderate
- Better temperature resistance
- Better chemical resistance

CRIMP SEAL

Anaerobic Adhesives

- Range of gap fill: from 0.015 to 0.050 inches (.375 to 1.25 mm)
- Range of fixture speed

Joining First/Last Pleat

Pleating

Pleating/Edge Sealing

Crimp Seal
**MECHANICAL FLUIDS**

**END CAP BONDING**

**ONE-PART SOLUTIONS**
- PA Hot Melts
  - Cost-effective
  - Versatile
  - Fast to moderate open time
  - Good temperature resistance

**TWO-PART SOLUTIONS**
- One-Part Heat Cured Epoxies
  - Best chemical resistance
  - Best temperature resistance
  - Thermal shock resistance
- PUR
  - High adhesion and durability
  - Better chemical resistance
  - Better temperature resistance
- Two-Part Epoxies
  - Best chemical resistance
  - Better temperature resistance
- Two-Part PU
  - Better chemical resistance
  - Good temperature resistance
  - Highest adhesion

**END CAP REPLACEMENT**
- PA Hot Melts
  - Good temperature resistance
  - Cost effective
  - Lighter colors or black
  - Longer open times
  - Viscosity range
- Two-Part PU
  - Better chemical & temperature resistance*
  - Flame retardant+
  - Viscosity range

**END CAP DE-MOLDING**
- LOCTITE® FREKOTE® Mold Release
  - Sacrificial
  - Range of finishes
  - High clarity of mold features (i.e., lettering)

*OIL, Diesel Fuel, Hydraulic Fluid, Transmission Fluid, Anti-Freeze Compatible
+Flame Retardant UL900 or 94V-0

**FIRST/LAST PLEAT**

**HOT MELTS**
- Considerations for PA hot melts:
  - Cost-effective
  - Set time – fast to moderate
  - Good temperature resistance
  - Good chemical resistance

**HIGHER CHEMICAL OR TEMPERATURE RESISTANCE**
- Considerations for epoxies:
  - Better temperature resistance
  - Better chemical resistance
  - Range of pot life vs. cure speed

**HOT MELTS FOR PLEATING OR EDGE SEALING**
- PA Hot Melts
  - Set time – fast to moderate
  - Better temperature resistance
  - Better chemical resistance

**CRIMP SEAL**
- Anaerobic Adhesives
  - Range of gap fill: from 0.015 to 0.050 inches (.375 to 1.25 mm)
  - Range of fixture speed
## MECHANICAL FLUIDS

### END CAP BONDING & FIRST PLEAT/LAST PLEAT – TWO PART EPOXIES

<table>
<thead>
<tr>
<th>PRODUCT NUMBER</th>
<th>COLOR</th>
<th>MIXED VISCOSITY (cP)</th>
<th>OPEN TIME (SEC.)</th>
<th>TEMPERATURE (°C/°F)</th>
<th>CHEMICAL RESISTANCE</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>LOCTITE® EA A-304-29™</td>
<td>Grey</td>
<td>19,500</td>
<td>5</td>
<td>-40°C/5°F</td>
<td>Contact</td>
<td>Henkel</td>
</tr>
<tr>
<td>LOCTITE® EA A-304-26™</td>
<td>Grey</td>
<td>250,000</td>
<td>5</td>
<td>-40°C/5°F</td>
<td>Contact</td>
<td>Henkel</td>
</tr>
<tr>
<td>LOCTITE® EA A-316-43™</td>
<td>Grey</td>
<td>250,000</td>
<td>5</td>
<td>-40°C/5°F</td>
<td>Contact</td>
<td>Henkel</td>
</tr>
<tr>
<td>LOCTITE® EA A-329-14™</td>
<td>Grey</td>
<td>100,000</td>
<td>5</td>
<td>-40°C/5°F</td>
<td>Contact</td>
<td>Henkel</td>
</tr>
</tbody>
</table>

### EPOXY ADHESIVES – TYPICAL PROPERTIES

<table>
<thead>
<tr>
<th>PRODUCT NUMBER</th>
<th>COLOR</th>
<th>VISCOSITY</th>
<th>OPEN TIME (SEC.)</th>
<th>TEMPERATURE (°C/°F)</th>
<th>CHEMICAL RESISTANCE</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>LOCTITE® 8101™ B3 AND LOCTITE® UK 5400™ COMBINED</td>
<td>Grey</td>
<td>7,500 at 121°C/250°F</td>
<td>Short: (10-20) Very high</td>
<td>Contact</td>
<td>Henkel</td>
<td></td>
</tr>
<tr>
<td>LOCTITE® 8101™ B3 AND LOCTITE® UK 5400™ COMBINED</td>
<td>Grey</td>
<td>7,500 at 180°C/351°F</td>
<td>Medium: (40-80) Very high</td>
<td>Contact</td>
<td>Henkel</td>
<td></td>
</tr>
</tbody>
</table>

### END CAP BONDING & END CAP REPLACEMENT – TWO PART PU

<table>
<thead>
<tr>
<th>PRODUCT NUMBER</th>
<th>POLYOL</th>
<th>VOL. MIX (cP)</th>
<th>SOLID MIX (cP)</th>
<th>MIXED VISCOSITY</th>
<th>GEL TIME (cP)</th>
<th>VISCOSITY</th>
<th>DENSITY</th>
<th>COLOR</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>LOCTITE® Styrene® 6105™ F1 AND LOCTITE® Styrene® 6106™ F1 COMBINED</td>
<td>Polyol</td>
<td>3.1</td>
<td>3.57</td>
<td>1,800</td>
<td>75 (5)</td>
<td>2.5 min.</td>
<td>3,200</td>
<td>1.5</td>
<td>White</td>
</tr>
<tr>
<td>LOCTITE® Styrene® 6105™ F1 AND LOCTITE® Styrene® 6106™ F1 COMBINED</td>
<td>Iso</td>
<td>3.1</td>
<td>4.1</td>
<td>2,050</td>
<td>60 (8)</td>
<td>-40°C/5°F</td>
<td>8,000</td>
<td>1.45</td>
<td>Cream</td>
</tr>
</tbody>
</table>

### HOT MELT ADHESIVES – TYPICAL PROPERTIES

<table>
<thead>
<tr>
<th>PRODUCT NUMBER</th>
<th>TYPE</th>
<th>FINISH</th>
<th>SUBSTRATES RELEASED</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>TECHOCRE® FBR® 8016™</td>
<td>Silicone</td>
<td>High gloss</td>
<td>Silicone mold release agents offer superb release properties, choice of finish, and excellent part detail to meet your specific molding requirements.</td>
<td></td>
</tr>
<tr>
<td>TECHOCRE® FBR® 240EX™</td>
<td>Silicone</td>
<td>High gloss</td>
<td>Silicone mold release agents offer superb release properties, choice of finish, and excellent part detail to meet your specific molding requirements.</td>
<td></td>
</tr>
</tbody>
</table>

### END CAP DE-MOLDING

<table>
<thead>
<tr>
<th>PRODUCT NUMBER</th>
<th>TYPE</th>
<th>FINISH</th>
<th>SUBSTRATES RELEASED</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>LOCTITE® Frekote® LIFTT™</td>
<td>Sacrificial</td>
<td>Semi-gloss</td>
<td>Silicone mold release agents offer superb release properties, choice of finish, and excellent part detail to meet your specific molding requirements.</td>
<td></td>
</tr>
<tr>
<td>LOCTITE® Frekote® LIFTT™</td>
<td>Sacrificial</td>
<td>Semi-gloss</td>
<td>Silicone mold release agents offer superb release properties, choice of finish, and excellent part detail to meet your specific molding requirements.</td>
<td></td>
</tr>
</tbody>
</table>
### MECHANICAL FLUIDS

#### END CAP BONDING & FIRST PLEAT/LAST PLEAT – TWO PART EPOXIES

<table>
<thead>
<tr>
<th>PRODUCT NUMBER</th>
<th>COLOR</th>
<th>MIXED VISCOSITY (cPs)</th>
<th>WORK LIFE</th>
<th>SERVICE TEMPERATURE (ºC/ºF)</th>
<th>CHEMICAL RESISTANCE</th>
<th>ACIDSﬂUIDS</th>
<th>SOLVENTS</th>
<th>BASES</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>LOCTITE® EA A-409™</td>
<td>Black</td>
<td>25,000</td>
<td>35</td>
<td>-40ºC/-40ºF</td>
<td>Medium setting, excellent chemical resistance, meets UL 764 and UL 722.</td>
<td>✓</td>
<td>✓</td>
<td>✓</td>
<td>✓</td>
</tr>
<tr>
<td>LOCTITE® EA A-409™</td>
<td>Cream Paste</td>
<td>45</td>
<td>-40ºC/-40ºF</td>
<td>Contact Henkel</td>
<td>Medium setting, general purpose, excellent metal &amp; plastic adhesion.</td>
<td>Contact Henkel</td>
<td>✓</td>
<td>✓</td>
<td>✓</td>
</tr>
<tr>
<td>LOCTITE® EA A-328™</td>
<td>Clear</td>
<td>30</td>
<td>-40ºC/-40ºF</td>
<td>Contact Henkel</td>
<td>Very fast setting, general purpose, good metal adhesion.</td>
<td>Contact Henkel</td>
<td>✓</td>
<td>✓</td>
<td>✓</td>
</tr>
<tr>
<td>LOCTITE® EA A-968™</td>
<td>Black</td>
<td>10,000</td>
<td>60</td>
<td>-40ºC/-40ºF</td>
<td>Long setting, general purpose, good metal adhesion.</td>
<td>Contact Henkel</td>
<td>✓</td>
<td>✓</td>
<td>✓</td>
</tr>
<tr>
<td>LOCTITE® E-9558™</td>
<td>Clear</td>
<td>9,900</td>
<td>10</td>
<td>-40ºC/-40ºF</td>
<td>Very fast setting, general purpose, good metal &amp; plastic adhesion.</td>
<td>Contact Henkel</td>
<td>✓</td>
<td>✓</td>
<td>✓</td>
</tr>
<tr>
<td>LOCTITE® EA A-316™</td>
<td>Cream Paste</td>
<td>70,000</td>
<td>15</td>
<td>-40ºC/-40ºF</td>
<td>Fast setting, clean, general purpose adhesion to metals &amp; plastics. MSF Approved.</td>
<td>Contact Henkel</td>
<td>Contact Henkel</td>
<td>Contact Henkel</td>
<td>✓</td>
</tr>
</tbody>
</table>

#### END CAP BONDING & END CAP REPLACEMENT – TWO PART PU

<table>
<thead>
<tr>
<th>PRODUCT NUMBER</th>
<th>POLYOL/ISO</th>
<th>VOL. % AXIS (A/B)</th>
<th>MASS % AXIS (A/B)</th>
<th>MIXED VISCOSITY HARDNESS</th>
<th>GEL TIME (100ºC/212ºF)</th>
<th>VISCOSITY (SEC)</th>
<th>DENSITY (g/L)</th>
<th>COLOR</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>LOCTITE® Signature™ 0671™</td>
<td>Polyol</td>
<td>3.1</td>
<td>3.5/1</td>
<td>1,800</td>
<td>75</td>
<td>2.5 min.</td>
<td>5100</td>
<td>White</td>
<td>Oil, diesel fuel, hydraulic fluid, transmission fluid, anti-freeze compatibility, long exposure to 120ºC. – flame retardant 040-d</td>
</tr>
<tr>
<td>LOCTITE® Signature™ 0671™</td>
<td>Isocyanate</td>
<td>3.1</td>
<td>3.5/1</td>
<td>1,800</td>
<td>75</td>
<td>2.5 min.</td>
<td>5100</td>
<td>Brown</td>
<td>Oil, diesel fuel, hydraulic fluid, transmission fluid, anti-freeze compatibility, long exposure to 120ºC. – flame retardant 040-d</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>PRODUCT NUMBER</th>
<th>TYPE</th>
<th>FINISH</th>
<th>SUBSTANCES RELEASED</th>
<th>DESCRIPTION</th>
</tr>
</thead>
<tbody>
<tr>
<td>LOCTITE® Frekote® EXIT™</td>
<td>Silicone</td>
<td>High gloss</td>
<td>Silicone mold release agents offer superb release properties, choice of finish, and excellent part detail to meet your specific molding requirements.</td>
<td></td>
</tr>
</tbody>
</table>
MECHANICAL FLUIDS

FLUID FILTERS – PRODUCT SELECTION GUIDE

CRIMP SEALING

ANAEROBIC ADHESIVES – TYPICAL PROPERTIES

PRODUCT NUMBER | TYPE | VISCOSITY (mPas) | OPEN TIME (SEC.) | TEMP. RESISTANCE | COLOR | TEMPERATURE RESISTANCE

LOCTITE® 6001™ | IDH 467119 (250ml) | IDH 493621 (1L MTO) | Anaerobic Short Low High Rosy white 3,000 cPs (thixo) Fixtures 15 min. | High temp. resistance, with excellent creep resistance. Good chemical resistance – FDA 175.105 approved.

LOCTITE® 620™ | IDH 135514 (50ml) | IDH 135515 (250ml) | Anaerobic Moderate Low High Green 8,500 cPs Fixtures 1 hr. | Provides adhesion to metal substrates, high temp. resistance to 450°F, max gap fill 0.015" diametral.

LOCTITE® 5182™ | IDH 88128 (850ml) | Anaerobic Moderate High Moderate Red Gel Fixtures 25 min. | Provides adhesion to metal substrates, high temp. resistance to 300°F, max gap fill 0.050" diametral, deaerated for gasketing.

TECHNOMELT® PA 2692™ | IDH 1415054 (Bag) | Transparent light amber 4,200 Short: (10-20) Very high 200/403 | Contact Henkel | Excellent chemical resistance – FDA 175.105 approved.

TECHNOMELT® PA 6300™ | IDH 1398258 (Bag) | IDH 1396374 (Bag) | IDH 1396799 (Sack) | Dark amber 4,200 at 210ºC/410ºF Short- Medium: (20-25) High 167/333 | High temp. resistance, with excellent creep resistance & moisture resistance with excellent chemical resistance – FDA 175.105 approved.

TECHNOMELT® PA-2030™ | IDH: Consult Henkel Amber 6,500 mPas at 200ºC/392ºF Short: (20-30) High 160/320 | Low fogging according to DIN 75201 B.

TECHNOMELT® PA 2384™ | IDH 1022624 (Bag) | Amber 12,000 at 220ºC/428ºF Medium: (40-60) High 182/196 | Contact Henkel | Excellent chemical resistance.

NOTE: Surfaces must be clean, free of oxide and particulate contamination. Test recommended for critical applications. Henkel recommends testing with a supplier representative prior to use.

CRIMP SEALING

ANAEROBIC ADHESIVES – TYPICAL PROPERTIES

PRODUCT NUMBER | TYPE | VISCOSITY (mPas) | OPEN TIME (SEC.) | TEMP. RESISTANCE | COLOR | TEMPERATURE RESISTANCE

LOCTITE® 6101™ | IDH 467119 (250ml) | IDH 493621 (1L MTO) | Anaerobic Short Low High Rosy white 3,000 cPs (thixo) Fixtures 15 min. | High temp. resistance, with excellent creep resistance. Good chemical resistance – FDA 175.105 approved.

LOCTITE® 6102™ | IDH 135514 (50ml) | IDH 135515 (250ml) | Anaerobic Moderate Low High Green 8,500 cPs Fixtures 1 hr. | Provides adhesion to metal substrates, high temp. resistance to 450°F, max gap fill 0.015" diametral.

LOCTITE® 6108™ | IDH 88128 (850ml) | Anaerobic Moderate High Moderate Red Gel Fixtures 25 min. | Provides adhesion to metal substrates, high temp. resistance to 300°F, max gap fill 0.050" diametral, deaerated for gasketing.
### MECHANICAL FLUIDS

#### CRIMP SEALING

- **TECHNOMELT® PA 2035™**
  - IDH 1022624 (Bag)
  - Amber
  - 12,000 at 220ºC/428ºF
  - Medium: (40-60)
  - High: 182/196
  - Contact Henkel
  - Excellent chemical resistance.

### ANAEROBIC SEALING – TYPICAL PROPERTIES

- **LOCTITE® 6001™**
  - IDH 467119 (250ml)
  - IDH 493621 (1L MTO)
  - Anaerobic
  - Short: (10-20)
  - Very high: 3,000 cPs (thixo)
  - Fixtures: 15 min.
  - Surface insensitive retaining compound, provides primerless adhesion to metal substrates, highly thixo liquid, max gap fill 0.015” diametral.

- **LOCTITE® 620™**
  - IDH 135514 (50ml)
  - IDH 135515 (250ml)
  - Anaerobic
  - Moderate: (10-20)
  - High: 8,500 cPs
  - Fixtures: 1 hr.
  - Provides adhesion to metal substrates, high temp. resistance to 450°F, max gap fill 0.015” diametral.

- **LOCTITE® 5182™**
  - IDH 88128 (850ml)
  - Anaerobic
  - Moderate: (20-25)
  - High: 167/333
  - Fixtures: 25 min.
  - Provides adhesion to metal substrates, high temp. resistance to 300°F, max gap fill 0.050” diametral, deaerated for gasketing.

### PA HOT MELTS – PLEATING & EDGE SEALING

#### FIRST PLEAT/LAST PLEAT

- **TECHNOMELT® PA 2692™**
  - IDH 1415054 (Bag)
  - Translucent light amber
  - Short: (10-20)
  - Very high: 4,200
  - Fixtures: (10-20)
  - High: 206/403
  - Contact Henkel
  - Henkel
  - High temp. resistance, with excellent creep resistance. Good chemical resistance – FDA 175.105 approved.

- **TECHNOMELT® PA 6300™**
  - IDH 1398258 (Bag)
  - Translucent light amber
  - Short: (20-25)
  - High: 190/374
  - Fixtures: 1 hr.
  - Contact Henkel
  - Henkel
  - High temp. resistance, with excellent creep resistance. Good chemical resistance – FDA 175.105 approved.

- **TECHNOMELT® PA 2192B™**
  - IDH 1396374 (Bag)
  - Dark amber
  - Short: (10-20)
  - High: 107/333
  - Fixtures: 25 min.
  - Contact Henkel
  - Henkel
  - High temp. resistance, with excellent creep resistance & moisture resistance with excellent chemical resistance – FDA 175.105 approved.

- **TECHNOMELT® PA 9069™**
  - IDH 1392850 (Bag)
  - Amber
  - Medium: (40-60)
  - High: 182/196
  - Fixtures: 25 min.
  - Contact Henkel
  - Henkel
  - Good chemical resistance and adhesion to plastics, metals and media – FDA 175.105 approved.

- **TECHNOMELT® PA-2030™**
  - IDH: Consult Henkel
  - Amber
  - 6,500 mPas at 200ºC/392ºF
  - Medium: (30-40)
  - High: 200/398
  - Fixtures: 30 min.
  - Contact Henkel
  - Henkel
  - Low fogging according to DIN 75011 B.

- **TECHNOMELT® PA 2384™**
  - IDH 1252624 (Bag)
  - Amber
  - Medium: (40-60)
  - High: 182/196
  - Fixtures: 25 min.
  - Contact Henkel
  - Henkel
  - Excellent chemical resistance.

### END CAP REPLACEMENT

#### END CAP BONDING

- **LOCTITE® 6001™**
  - IDH 467119 (250ml)
  - IDH 493621 (1L MTO)
  - Anaerobic
  - Short: (10-20)
  - Very high: 3,000 cPs (thixo)
  - Fixtures: 15 min.
  - Contact Henkel
  - Henkel
  - High temp. resistance, with excellent creep resistance. Good chemical resistance – FDA 175.105 approved.

- **LOCTITE® 620™**
  - IDH 135514 (50ml)
  - IDH 135515 (250ml)
  - Anaerobic
  - Moderate: (10-20)
  - High: 8,500 cPs
  - Fixtures: 1 hr.
  - Contact Henkel
  - Henkel
  - Provides adhesion to metal substrates, high temp. resistance to 450°F, max gap fill 0.015” diametral.

- **LOCTITE® 5182™**
  - IDH 88128 (850ml)
  - Anaerobic
  - Moderate: (20-25)
  - High: 167/333
  - Fixtures: 25 min.
  - Contact Henkel
  - Henkel
  - Provides adhesion to metal substrates, high temp. resistance to 300°F, max gap fill 0.050” diametral, deaerated for gasketing.

#### HINGE SEALING

- **LOCTITE® 6001™**
  - IDH 467119 (250ml)
  - IDH 493621 (1L MTO)
  - Anaerobic
  - Short: (10-20)
  - Very high: 3,000 cPs (thixo)
  - Fixtures: 15 min.
  - Contact Henkel
  - Henkel
  - High temp. resistance, with excellent creep resistance. Good chemical resistance – FDA 175.105 approved.

### END CAP REPLACEMENT

- **LOCTITE® 620™**
  - IDH 135514 (50ml)
  - IDH 135515 (250ml)
  - Anaerobic
  - Moderate: (10-20)
  - High: 8,500 cPs
  - Fixtures: 1 hr.
  - Contact Henkel
  - Henkel
  - Provides adhesion to metal substrates, high temp. resistance to 450°F, max gap fill 0.015” diametral.

- **LOCTITE® 5182™**
  - IDH 88128 (850ml)
  - Anaerobic
  - Moderate: (20-25)
  - High: 167/333
  - Fixtures: 25 min.
  - Contact Henkel
  - Henkel
  - Provides adhesion to metal substrates, high temp. resistance to 300°F, max gap fill 0.050” diametral, deaerated for gasketing.
FUNCTIONAL COATINGS – SOLUTIONS FOR METAL PRETREATMENT

Henkel offers a full range of metal pretreatment solutions to reduce process steps, improve efficiency, and increase cost savings. Our solutions will help you achieve enhanced paint adhesion and corrosion protection with less energy and water consumption, less wastewater, and more environmentally conscious formulas.

The Henkel Portfolio

**Cleaners**
- Process
- Industrial
- Specialty
- Pickles
- Strippers
- Alkaline
- Neutral
- Conditioners

**Metal Pretreatment and Conversion Coatings**
- Iron phosphate, zinc phosphate, manganese phosphate
- New generation coatings (nanoceramics)
- Light metal finishing (chrome, non-chrome technologies, anodizing)

BONDERITE® metal pretreatments and conversion coatings set a high standard for corrosion protection and paint adhesion. These high-performance, sustainable products can help improve your process reliability and are available in multiple options for dip or spray applications.

**Coatings**
- Electroceramic coating
- Autophoretic coating (A-Coat)
- Rust prevention
- Break-in lubricant coating

BONDERITE® coating processes deliver anti-corrosion, friction reduction, and improved heat resistance benefits while offering a number of environmental benefits.

Key Henkel Processes

Henkel’s focus on innovation has led to the development of new, more efficient surface treatment processes that offer environmental benefits and reduced energy and CO₂.

- Henkel Nanoceramic Process: Our BONDERITE® M-NT™ conversion coating provides a phosphate-free alternative to traditional iron phosphate.
- Henkel Autodeposition Process: Our BONDERITE® M-PP autodeposition process combines metal pretreatment and finishing in one process, increasing efficiency along with energy and cost savings.

Read more about these innovative processes on the following page.

Henkel Process Services

- **Process selection**: Henkel’s experts consult with customers to match their individual requirements to the right Henkel process.
- **Analytic and process validation**: Henkel analyzes the complete production process for customers, reducing production cycle times and rejection rates.
- **Start-up of application and lab testing**: Henkel tests applications of your process in our labs and ensures that Henkel products can be smoothly integrated into your plant.
- **Process optimization**: Henkel works with customers to design simpler and more efficient production processes, with a focus on meeting environmental and safety criteria.
- **Customer training**: Henkel offers comprehensive training to help our customers understand our products in detail and learn correct application methods.

Equipment

All our product solutions are supported by a full range of dispensing equipment that can be easily integrated into your existing manufacturing processes.
FUNCTIONAL COATINGS – SOLUTIONS FOR METAL PRETREATMENT

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The Henkel Portfolio

- **METAL PRETREATMENT AND CONVERSION COATINGS**
  - Iron phosphate, zinc phosphate, manganese phosphate
  - New generation coatings (nanoceramics)
  - Light metal finishing (chrome, non-chrome technologies, anodizing)

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**FUNCTIONAL COATINGS AND METAL PRETREATMENT SOLUTIONS**

**Henkel Nanotechnology Solutions**

**MORE SAVINGS, FEWER STEPS**

**BONDERITE® M-NT 1™**

The BONDERITE® M-NT 1™ conversion coating is single-part zirconium-based nanotechnology, which provides a phosphate-free alternative to traditional iron phosphate. It runs at low temperatures and is completely phosphate- and regulated heavy metal-free, to reduce energy consumption and waste removal. BONDERITE® M-NT 1™ is suitable for dip and spray applications.

**Key Benefits:**

The Henkel Nanoceramic process offers significant savings in manpower, disposal, energy, and water costs compared to traditional processes:

- **Lower energy and water use:** BONDERITE® M-NT 1™ operates at ambient temperatures, reducing energy use and associated CO₂.
- **Reduced hazardous waste:** Free of nickel, phosphates, Volatile Organic Compounds (VOCs) and regulated chemicals.
- **Marginal sludge formation:** Significant savings in hazardous waste generation.
- **Fewer process steps:** Activation and passivation are no longer required; contact times are simultaneously reduced.

**TRADITIONAL MULTI-STEP PROCESS**

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**HENKEL NANOCERAMIC PROCESS**

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**Henkel Autodeposition Solutions**

**ENHANCED CORROSION PROTECTION FOR DEMANDING APPLICATIONS**

**BONDERITE® M-PP**

The BONDERITE® Autodeposition process delivers a highly corrosion-resistant, thin, organic coating while increasing process efficiency over traditional finishing methods. It combines metal pretreatment and finishing in one process, providing a lasting finish – both inside and outside of parts.

**Key Benefits:**

Henkel’s Autodeposition process provides substantial savings compared to traditional e-coating methods:

- **Requires significantly less manpower and equipment, less cycle time, energy, part rework and handling.**
- **Reduced energy:** BONDERITE® M-PP and powder coating topcoats are “co-cured” in a single oven, significantly reducing energy requirements and the production footprint.
- **Environmental benefits:** No toxic heavy metals, very low VOCs.

**TRADITIONAL MULTI-STEP PROCESS**

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**HENKEL AUTODEPOSITION PROCESS**

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**PRODUCT LINE SUPPORT**

Henkel’s BONDERITE® team is made up of chemists, engineers, application specialists and pilot plant facilities that can assist you in the evaluation, design and installation of autodeposition coating processes. For more information, please contact your Henkel representative for assistance.

**VALUE CREATION**

- **Manpower**
- **Disposal**
- **Energy**
- **Water**
- **Other material**
- **Chemistry**
Henkel Nanotechnology Solutions

MORE SAVINGS, FEWER STEPS

BONDERITE® M-NT 1™

The BONDERITE® M-NT 1™ conversion coating is single-part zirconium-based nanotechnology, which provides a phosphate-free alternative to traditional iron phosphate. It runs at low temperatures and is completely phosphate- and regulated heavy metal-free, to reduce energy consumption and waste removal. BONDERITE® M-NT 1™ is suitable for dip and spray applications.

Key Benefits:

The Henkel Nanoceramic process offers significant savings in manpower, disposal, energy, and water costs compared to traditional processes:

- Lower energy and water use: BONDERITE® M-NT 1™ operates at ambient temperatures, reducing energy use and associated CO₂.
- Reduced hazardous waste: Free of nickel, phosphates, Volatile Organic Compounds (VOCs) and regulated chemicals.
- Marginal sludge formation: Significant savings in hazardous waste generation.
- Fewer process steps: Activation and passivation are no longer required; contact times are simultaneously reduced.

Henkel Autodeposition Solutions

ENHANCED CORROSION PROTECTION FOR DEMANDING APPLICATIONS

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Key Benefits:

Henkel’s Autodeposition process provides substantial savings compared to traditional e-coating methods:

- Requires significantly less manpower and equipment, less cycle time, energy, part rework and handling.
- Reduced energy: BONDERITE® M-PP and powder coating topcoats are “co-cured” in a single oven, significantly reducing energy requirements and the production footprint.
- Environmental benefits: No toxic heavy metals, very low VOCs.

TRADITIONAL MULTI-STEP PROCESS

- TRADITIONAL MULTI-STEP PROCESS
- HENKEL AUTODEPOSITION PROCESS

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**FUNCTIONAL COATINGS AND METAL PRETREATMENT SOLUTIONS**

**YOUR APPLICATION**

**METAL AND PAINT PRETREATMENT**

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<th>Step</th>
<th>Task</th>
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<tbody>
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<td>1</td>
<td>Pick a cleaner</td>
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<tr>
<td>2</td>
<td>Pick a conversion coating</td>
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<tr>
<td>3</td>
<td>Seal it</td>
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**SOLUTION**

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<th>BONDERITE® C-AK 305™</th>
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<td>37ºC-60ºC</td>
<td>54ºC-82ºC</td>
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**RECOMMENDED 2-STAGE**

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**RECOMMENDED 4-STAGE PROCESS**

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**RECOMMENDED NANOCEMICS PROCESS**

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**METAL AND PAINT PRETREATMENT**

**Conversion Coating**

1-STAGE

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<td>54ºC-88ºC</td>
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<td>5-25 sec.</td>
<td>Spray</td>
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<tr>
<td>2</td>
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<td>2-4%</td>
<td>5-25 sec.</td>
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</tr>
<tr>
<td>3</td>
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<td>Steel</td>
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**SEAL / POST RINSE (CHROME-FREE)**

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<th>Stage</th>
<th>Process</th>
<th>Coating</th>
<th>Temperature</th>
<th>Concentration</th>
<th>Contact Time</th>
<th>Application</th>
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<td>Spray, Immersion</td>
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**AUTODEPOSITION PROCESS (PRETREATMENT AND FINISHING COMBINED)**

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<th>Application</th>
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<tr>
<td>3</td>
<td>Cleaner</td>
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<tr>
<td>5</td>
<td>Cleaner</td>
<td>Steel</td>
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<td>16%</td>
<td>90-120 sec.</td>
<td>Immersion</td>
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<tr>
<td>6</td>
<td>Coat</td>
<td>Steel</td>
<td>20-22ºC</td>
<td>16%</td>
<td>90-120 sec.</td>
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**APPLICATION**

1-800-562-8483 | na.henkel-adhesives.com/filters

Air and Mechanical Fluid Filtration Solutions
### Functional Coatings and Metal Pretreatment Solutions

#### Your Application

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<thead>
<tr>
<th>Step</th>
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<td>Pick a cleaner</td>
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<td>Pick a conversion coating</td>
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<td>3</td>
<td>Seal it</td>
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#### Metal and Paint Pretreatment

**Cleaning**

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#### Conversion Coating

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<th>4-stage</th>
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<td>Bonderite® M-PP 930™</td>
<td>Bonderite® M-PP 935™</td>
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**Steel Solution**

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<td>Bonderite® M-PP 967™</td>
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#### AUTODEPOSITION Process (Pretreatment and Finishing Combined)

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<th>Acid/Alkaline</th>
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<td>Immersion</td>
<td>Acid</td>
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<tr>
<td>Bonderite® M-PP 930™</td>
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<td>90-120 sec</td>
<td>Immersion</td>
<td>Acid</td>
</tr>
<tr>
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<td>16%</td>
<td>90-120 sec</td>
<td>Immersion</td>
<td>Acid</td>
</tr>
<tr>
<td>Bonderite® M-PP 966™</td>
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#### RECOMMENDED 2-STAGE Process and Spray Wand

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<th>Application</th>
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<tbody>
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<td>Acid</td>
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<tr>
<td>Bonderite® M-FE 200™</td>
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<td>1-6%</td>
<td>1-2 min.</td>
<td>Spray</td>
<td>Acid</td>
</tr>
<tr>
<td>Bonderite® M-FE 500LT™</td>
<td>21ºC-60ºC</td>
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<td>Spray</td>
<td>Acid</td>
</tr>
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<td>43ºC-46ºC</td>
<td>3-4%</td>
<td>30-5 min</td>
<td>Spray</td>
<td>Acid</td>
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<tr>
<td>Bonderite® M-FE 1030™</td>
<td>Ambient</td>
<td>3-5%</td>
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<td>Spray</td>
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#### RECOMMENDED 4-STAGE Process

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<th>Contact Time</th>
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<th>Acid/Alkaline</th>
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<tr>
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<td>11-12%</td>
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<td>Bonderite® M-PP 935™</td>
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<td>16%</td>
<td>90-120 sec</td>
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<td>Acid</td>
</tr>
<tr>
<td>Bonderite® M-PP 966™</td>
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#### RECOMMENDED NANOCERAMICS PROCESS

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<tbody>
<tr>
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<td>Bonderite® M-FE 200™</td>
<td>54ºC-88ºC</td>
<td>1-6%</td>
<td>1-2 min.</td>
<td>Spray</td>
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<tr>
<td>Bonderite® M-FE 500LT™</td>
<td>21ºC-60ºC</td>
<td>4-8%</td>
<td>1-5 min.</td>
<td>Spray</td>
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<tr>
<td>Bonderite® M-FE 700™</td>
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<td>3-4%</td>
<td>30-5 min</td>
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<tr>
<td>Bonderite® M-FE 1030™</td>
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<td>Bonderite® M-FE 1090™</td>
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#### SEAL / POST RINSE (CHROME-FREE)

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<th>Concentration by Volume</th>
<th>Contact Time</th>
<th>Application</th>
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<tbody>
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<td>3-10%</td>
<td>15-60 sec</td>
<td>Spray</td>
<td>Acid</td>
</tr>
</tbody>
</table>
MANUFACTURING EXCELLENCE
Henkel has decades of success optimizing manufacturing processes. We can analyze your complete manufacturing process and provide tailor-made recommendations for reducing production cycle times and rejection rates, thereby lowering your overall costs and increasing your productivity.

LAB TESTING
Henkel’s testing capabilities can provide complete data, relevant and applicable to your process, on our product recommendations. Whether you want to analyze a single component of your production process or review the complete system, our labs can provide all the data you need.

CUSTOMER TRAINING
Henkel offers an array of customized training programs to help customers learn the details of our product technologies and how to apply them effectively. We can also train you to use our custom-designed equipment efficiently. Our Technology Days provide additional training and demonstrations of our newest innovations.

VALUE CALCULATORS
Using our Value Calculators, our adhesives specialists can accurately analyze the total costs of your adhesive processes and determine your savings potential. Simply arrange an appointment with our specialists, and they will visit your production facilities to conduct an in-depth analysis.

ANALYTICAL SERVICES
Henkel provides comprehensive analysis of all steps in your manufacturing process using our own technical staff and industry experts. We will identify problem points on the production line and recommend improvements to the manufacturing process, along with Henkel products and equipment that can help improve results. These services can also include equipment tear-downs, surface analysis and testing.

HENKEL PARTNERSHIP
In addition to offering the broadest product portfolio in the adhesives industry, Henkel provides an array of services to help our filtration customers optimize their manufacturing processes, improve efficiency and reduce overall costs. The following services are available worldwide.
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# INDEX

If an item number or package size is not provided, please consult your Henkel representative.

<table>
<thead>
<tr>
<th>Description</th>
<th>Item No.</th>
<th>Product</th>
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INDEX

If an item number or package size is not provided, please consult your Henkel representative.