

Reliable Adhesives for Industrial Air Filters



ACCOMPLISH **more**



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 even vacuum cleaners, buyers demand high performance and reliability.

To meet these demands you not only need adhesives that are compatible with your media and your production equipment, but also meet the ultimate end-use filter requirements.

With Henkel you get just what you need.

Adhesives that Match your Product Profile

If your application requires adhesives to bond special media or low surface energy substrates, to resist extreme temperature conditions, or to remain flexible for radial designs, we can supply it.

Heavy Duty Applications

For example, cartridge filters used in dust collection or gas turbine applications are often exposed to vibration and high air velocities. Whether serving as the end cap or the potting compound, Henkel's polyurethanes are specifically designed to meet the demands of industrial filtration.

High Temperature Applications

Pleated filters used in vacuum cleaners or engines are often exposed to higher temperatures for extended periods. Our hot

melt adhesives are formulated to not only improve equipment processing and produce superior quality filters, but also withstand the requirements of the end-use application. But a standard product is not always the best solution. When you need a custom adhesive, Henkel can formulate it to match your specific process, design and application.

Consistent Performance

As a global supplier, we can deliver the same product from multiple plants to accommodate your needs. You get the performance you expect in every batch. Plus you eliminate the process variables associated with using adhesives from multiple vendors.

Partners in the Field, Experts in the Lab

Henkel is not just products; it is people. Our adhesive experts will team up with you to find solutions to the toughest process and product issues. They will continue to explore areas of possible improvement for as long as you work with us. Plus they're backed by the full resources of our industry-leading research group. If you would like to accomplish more with your filter products and improve production operations, now is the time to call Henkel. Our filter team will help you analyze your situation and develop a solution based on your needs.

To get started, just call 1-800-797-4992.



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HOT MELT ADHESIVES – Typical Properties

Application	Product No.	Type	Pleating Speeds	Flexibility	Temp Resistance	Color	Softening Point (°C)	Viscosity (cPs)				Open Time (sec)			*(Scale: 1 = Short, 9 = Medium, 10 = Long)
								275°F	300°F	325°F	350°F	300°F	325°F	350°F	
Pleating	34-584C		High	High	Moderate	White	106	3,350	2,175	1,475	1,050	10-15	10-15	15-20	1
	34-373C		Slow	Very High	High	White	129	12,400	7,800	5,400	3,850	25-30	30-35	35-40	9
	34-1214		Moderate	Very High	Low	Lt. Amber	82		5,000	3,200	2,200	40-45	40-45	40-45	10
	34-2636		High	Low	High	Lt. Amber	119	5,000	3,000	1,900	1,250	20-25	20-25	20-25	5
	34-771C		High	Moderate	Moderate	Off-White	107	5,400	3,500	2,400	1,700	20-25			5
	MACROMELT 6228	Polyamide		High	High	Translucent Amber	125	2,000 cPs at 437°F				Moderate: 40-60			
	MACROMELT 6238	Polyamide		Moderate	High	Clear Amber	133	5,000 cPs at 410°F				Moderate: 40-60			
	MACROMELT TPX 16-157	Polyamide		Low	High	Clear Amber	165	750 cPs at 375°F				Moderate-Long: 60-80			
	MACROMELT TPX 16-333	Polyamide		High	High	Translucent Amber	140	3,000 cPs at 375°F				Short: 10-20			
	MACROMELT 6300	Polyamide			Very High	Translucent Amber	190	3,700 cPs at 464°F				Short: 10-20			
	MACROMELT TPX 12-692	Polyamide			Very High	Translucent Amber	206	4,200 cPs at 464°F				Short-Moderate: 20-40			
	MACROMELT TPX 16-192B	Polyamide			High	Dark Amber	167	4,200 cPs at 410°F							
TECHNOMELT 80-8368	EVA			Moderate	Lt. Yellow	110				1,000					
TECHNOMELT 80-8647	EVA			Moderate	Off-White	108	11,500	7,200		4,700					

Application	Product No.	Type	Assembly Time	Open Time	Temp Resistance	Color	Softening Point (°C)	Viscosity (cPs)					
								275°F	300°F	325°F	350°F	375°F	
Potting	34-2787		Moderate	Long	Low	Yellow	90		4,800	3,750	2,450		
	34-342B		Moderate	Long	Low	Yellow	83	9,000	5,700	3,700	2,500	1,500	
High Temperature Resistance	34-3412		Long	Long	Very High	Amber	140		18,500	11,900	7,250	4,500	
	34-412B		Moderate	Moderate	High	White	122	22,000	14,000	9,000	6,500		
	34-871B		Moderate	Moderate	High	White	152			3,800	2,200	1,500	

2-PART POLYURETHANE SYSTEMS – Typical Properties

Application	Product No.	Polyol/Iso	Vol. Mix Ratio (A:B)	Mass Mix Ratio (A:B)	Viscosity (cps)	Density (lbs/gal)	Color	Mixed Viscosity	Shore Hardness	"Gel Time (100g at 77°F)"	Tack Free Time	Tensile Strength	% Elongation	Tear Strength
Potting	82-072A	Polyol	3.2	3.5	7000	11.3	White	Very Thick	90 (A)	150 sec	150 sec	Good	Good	Good
	82-072B	Iso	1	1	200	10.3	Amber							
Potting / End Cap	82-201A	Polyol	2	1.65	1300	8.1	Blue	1000 - 1750 cps	60 (A)	60-90 sec	120 sec	400 psi	100%	40 lbs/in
	82-180B	Iso	1	1	1100	9.7	Amber							
	LOCTITE 821200C													
	LOCTITE 821200R													
Flexible End Cap	82-226A	Polyol	2.9	3.1	1700	9.4	Black	Flows Well	35 (A)	135 sec		Good	Good	Good
	82-226B	Iso	1	1	6700	8.9	Amber							
Gasketing	82-142A	Polyol	4	4	2500	8.6	Black	Flows Well	50 - 60 (00)	40-50 sec (60g, 72F)	150 sec	Low	Low	Low
	82-072B	Iso	1	1	200	10.3	Amber							

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