

KRAFT CLASS

DESCRIPTION

Cement based adhesive material used for bonding ceramic, tile and marble.



TS EN 12004-1 -Adhesives -Tile Adhesives -Features, conformity assessment, classification and display

Suitable for C1T class.

C1 = Normal hardening cement based adhesive

T = Reduced drift

PLACES OF USE

- Indoor and outdoor; vertical - horizontal tile, ceramic adhesive applications and horizontal granite applications
- For outdoor bonding, it is recommended to mix with **TECHNO KRAFT® Adherence enhancing acrylic primer** (see **TECHNO KRAFT® Adherence enhancing acrylic primer**)

POINTS TO BE AWARE OF

- It is not applied on wooden, OSB, PVC, bitumen and metal surfaces and painted and waterproofing surfaces.
- It is not applied on surfaces where movement and stress may be high.
- It is not suitable for coatings on surfaces where the temperature can change in a short time, such as terraces, balconies, etc. (see **KRAFT® PRO+**)
- Do not apply on surfaces where frost risk may occur during the year. (see **KRAFT® PRO+**)
- Avoid application under the sun and strong wind. Application should be made when the surface temperature is between +5°C and +25°C .
- Especially for coating materials larger than 30cm x 30cm, double-sided (combined method) bonding should be preferred.
- It is recommended to use protective gloves during applications. For more detailed protective measures, please refer to the material safety data sheet of the product.

ADVANTAGES

- Single component, easy to prepare and apply.
- Does not slip in vertical applications.
- Does not collapse.
- Grey coloured adhesive mortar prevents reflection of mortar on the surface of coating materials such as marble.

SURFACE PREPARATION

The application surface must be clean, smooth and free from paint, scraped plasters and levelled to prevent adhesion. Holes and cracks on the surface over 5 mm must be filled with **KRAFT® Repair Mortar (thin or thick)** 2-3 days in advance (see **KRAFT® Repair Mortar**). Otherwise, the coatings applied on the unsealed holes and cracks are at risk of cracking and breaking when exposed to point load. If the surface is not smooth enough, the floor should be levelled with **TECHNO KRAFT® Self Leveling vertical KRAFT® Ready Plaster** (see **TECHNO KRAFT® Self Leveling - KRAFT® Ready Plaster**). For very porous surfaces and hot weather applications (if the surface temperature is above +25 °C), the surface must be pre-wetted so that it is moist for the appropriate temperature. This will prevent the adhesive from losing its water fast.

VARLIK MINERAL GEOTHERMAL ENERGY MINING CONSTRUCTION TRADING CO.

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KRAFT CLASS (TECHNICAL DATA SHEET)

USAGE METHOD

1 Bag (25 kg) **KRAFT CLASS** 6-6,5 kg of water is added slowly and mixed with 400-600 rpm mixer until it reaches paste consistency. The prepared mixture **is left to rest for 3 minutes**, then mixed again and applied to the surface with a suitable trowel. According to the size of the coating to be laid, **appropriate combing** is made, the coating materials are laid on the surface and fixed with the help of a rubber mallet. In order to ensure and increase the contact of the coating material with the adhesive, the material to be coated is floated in the mortar. (Ceramic or the material to be coated is placed on the adhesive surface by moving up and down and left and right). After the material is pulled to the surface with a trowel and combed, it should be adhered according to the air temperature and climatic conditions in which the material is used. In such cases, the adhesive is pressed with a finger and the adhesive surface is checked. If the material gets on the fingers, the bonding process is continued. Otherwise, the bonding process should be terminated and the dried adhesive material should be scraped off the surface and new adhesive should be applied to the surface. All tools and equipment used after the application should be cleaned with water before the mortar dries. The manufacturer's information written on the packaging should be taken into consideration before and during the application.

TECHNICAL SPECIFICATIONS

Colour	Grey
Material Content	Contains cement, mineral filler and additives.
Tensile Bond Strength-concrete surface (EN 12004-1)	TS EN 12004-1 Improved cementitious adhesive for tiles -Reaction to Fire Class A1 -Release of Hazardous Substances (Release of dangerous substances) see MSDS Bond Strength -Early Tensile Bond Strength does not apply (Early Tensile Adhesion Strength) -Initial Tensile Bond Strength (Initial Tensile Adhesion Strength) $\geq 0.5 \text{ N/mm}^2$ Durability -Tensile Adhesion Strength after Heat Aging (Tensile Adhesion Strength after Heat Storage) $\geq 0.5 \text{ N/mm}^2$ -Tensile Adhesion Strength after Wet Storage (Tensile Adhesion Strength after Wet Storage) $\geq 0.5 \text{ N/mm}^2$ Tensile Adhesion Strength after Thaw-Freezing Cycle (Tensile Adhesion Strength after Thaw-Freezing Cycle) $\geq 0.5 \text{ N/mm}^2$ -Tensile Adhesion Strength after open waiting time (Tensile Adhesion Strength after open waiting time) $\geq 0.5 \text{ N/mm}^2$
Grain Size (EN 12192-1)	D (max) $< 0.8 \text{ mm}$
Mixing Ratio	25 kg powder + 6-6,5 kg water
Application Thickness	3mm - 10mm
Temperature Resistance	$-40^\circ\text{C} / +100^\circ\text{C}$
Open Hold Time	$\geq 30 \text{ minutes}$
Slippage	$\leq 0.5 \text{ mm}$
Maturation Time	min 3 minutes
Container Life	2 hours
Slip (mm) (EN 1308)	None
Wettability (EN 1347)	%90
Joint Application	After at least 24 hours on the wall and floor
Opening Time to Traffic	At least 24 hours after grouting After at least 24 hours for light pedestrian traffic At least 7 days for fully pedestrianised traffic
Shelf Life	12 months from the date of manufacture under appropriate storage conditions When not in use, the packaging should be tightly closed and the material should be consumed within 1 week at the latest.

The above values are valid for $+21^\circ\text{C}$ and 50% relative humidity.

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EXPENDITURE

Ceramic Sizes	Ceramic Comb Tooth Size	Consumption (kg/m ²)
up to 15 cm x 15 cm	6 mm	4 kg (single sided) 5 kg (double sided)
up to 30 cm x 30 cm	8 mm	5 kg (single sided) 6.5 kg (double-sided)
larger than 30 cm x 30 cm	10 mm	7.5 kg (double-sided)

PACKAGING and STORAGE

CODE	PACKAGING
KR-801	KRAFT CLASS-grey (25 kg)

Store the material in its unopened packaging in a dry environment, protected from frost. Do not stack pallets on top of each other especially for long term storage.

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