

KRAFT® FLEX PORCELAIN ADHESIVE

DESCRIPTION

It is a cement based and hard aggregate containing polymer resin reinforced adhesive mortar with high adhesion strength for bonding large and small sized granite, tile, ceramic, glass mosaic, porcelain tile, natural stone and marble.



TS EN 12004-1 -Adhesives -Tile Adhesives -Features, conformity assessment, classification and display
Conforms to C2TE class.

C2 = Cement-based adhesive enhanced with additional
properties T = Increased slip resistance
E = Open hold time extended

PLACES OF USE

- Indoors and outdoors, in large-sized tile, granite applications and wet areas; balcony, terrace, bathroom, kitchen, cement-based screed
- TECHNO KRAFT® FILLED PRIMER** before coating on exposed concrete, gypsum plastered surfaces, gypsum board and ceramic on ceramic. Must be used. Bonding should be done at least 24 hours after the application of FILLED PRIMER. (see **TECHNO KRAFT® FILLED PRIMER**)

POINTS TO BE AWARE OF

- Do not apply on wood, OSB, PVC, bitumen surfaces, painted and metal surfaces.
- Do not apply within 24 hours on surfaces where frost hazard may occur.
- Avoid application under sun and strong wind. Application must be made when the surface temperature is between +5 °C and +25 °C.
- On exterior facades, large-sized ceramic or granite, tile, natural stone etc. Dilatation joint (dilatation lath) should be laid for every 25-30m² application area in order to eliminate the corrosive and challenging effects of the external environment of the coating materials.
- White coloured adhesive materials set earlier than grey adhesives.
- It is recommended to use protective gloves during application. For more detailed protective measures, please refer to the material safety data sheet of the product.

ADVANTAGES

- Single component, easy to prepare and apply.
- Due to its high water retention capacity, pot life and processing time is long.
- Adhesion strength is high. It does not slip vertically.
- Resistant to stresses that may occur due to temperature differences.
- It can be used indoors and outdoors, on surfaces where frost resistance is required.
- It can be used in ceramic bonding works on ceramic on horizontal floors. (It should be checked whether the ceramic coatings are intact.

VARLIK MINERAL GEOTHERMAL ENERGY MINING CONSTRUCTION TRADING CO.

CENTRE: Beştepe Mah.No:1/113 Yenimahalle/Ankara

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Poorly adhered coatings should be removed and glued again).

- White 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, free from paint, scraped plasters and levelled. Holes and cracks on the surface over 5 mm should 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 and the vertical with KRAFT® Ready Plaster (see TECHNO KRAFT® Self Leveling - KRAFT® Ready Plaster). On very porous surfaces and in hot weather applications (if the surface temperature is above +25 0C), 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.

USAGE METHOD

1 Bag (20 kg) **KRAFT® FLEX PORCELAIN ADHESIVE** 5-5,5 kg water is added slowly and mixed with a mixer at 400-600 rpm for 5 minutes until it reaches paste consistency. The prepared mixture is left to rest for 5 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 with the help of a rubber mallet and fixed. The material to be coated is floated in the mortar to ensure and increase the contact of the coating material with the adhesive. (The granite or the material to be coated is placed on the adhesive surface by moving up and down and left and right. During the bonding of large-sized granite and coating materials, the adhesive mortar should be applied approximately 1-2 mm behind the coating). 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. The adhesive applied surface should be protected from frost within the first 24 hours. 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.

EXPENDITURE

Ceramic Sizes	Ceramic Comb Tooth Size	Consumption (kg/m²)
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	6 kg (single-sided) 7.5 kg (double-sided)

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TECHNICAL SPECIFICATIONS

Colour	Grey-White
Material Content	Contains cement, mineral filler and polymer additives.
Tensile Bond Strength-concrete surface (EN 12004)	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 applicable (Early Tensile Adhesion Strength) not -Initial Tensile Bond Strength (Initial Tensile Adhesion Strength) $\geq 1.0 \text{ N/mm}^2$ Durability -Tensile Adhesion Strength after Heat Aging (Tensile Adhesion Strength after Heat Storage) $\geq 1.0 \text{ N/mm}^2$ -Tensile Adhesion Strength after Wet Storage (Tensile Adhesion Strength after Wet Storage) $\geq 1.0 \text{ N/mm}^2$ -Tensile Adhesion Strength after Thaw-Freezing Cycle (Tensile Adhesion Strength after Thaw-Freezing Cycle) $\geq 1.0 \text{ N/mm}^2$ -Tensile Adhesion Strength after open waiting time (Tensile Adhesion Strength after open waiting time) $\geq 0.5 \text{ N/mm}^2$ -Tensile Adhesion Strength after Extended Open Waiting Time $\geq 0.5 \text{ N/mm}^2$
Grain Size (EN 12192-1)	$D_{\max} < 0.8 \text{ mm}$
Mixing Ratio	20 kg powder + 5-5.5 kg water
Application Thickness	3mm - 10mm
Temperature Resistance	-40°C / +100°C
Open Hold Time	≥ 30 minutes
Maturation Time	min 5 minutes
Container Life	2 hours
Slip (mm) (EN 1308)	None
Wettability (EN 1347)	%99
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 After at least 7 days for full pedestrian 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 at +21 °C and 50% relative humidity.

PACKAGING and STORAGE

CODE	PACKAGING
KR-803	KRAFT® FLEX PORCELAIN ADHESIVE -grey (20 kg)
KR-807	KRAFT® FLEX PORCELAIN ADHESIVE -white (20 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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