



The Chemical Company

KRAFTKLEBER®

Very Quickly Curing High Performance Adhesive

Description of Product

KRAFTKLEBER® is a polyurethane based single component very quickly curing high performance adhesive.

Fields of Application

- In inner and outer areas, in vertical and horizontal applications.
- In inner areas for artificial stones and natural stones.
- In adhesion of materials like metal, aluminum, wood, ceramic, concrete, fiberglass, hard plastic, and styrofoam to each other.
- In decoration, stand design, and all types of repair works.
- In chemical wall plugging / fixing of screws, wall plugs, and holders.

- In adhesion of heat insulation sheets.
- As adhesive in wood and furniture sector.

Features and Benefits

- Single component, cures with the humidity of air.
- Odorless.
- Highly resistant, can be applied to many surfaces without primer.
- Dries quickly and without sagging.
- Absorbs sound and vibrations.
- Economical with its single side application style.
- Resistant to temperature changes, chemical effects, aging, and sea weather conditions.
- Does not cause coloring in natural stones.
- Can be painted by sandblasting.
- Does not contain solvent.

Technical Data

Structure of the Material	Polyurethane
Color	Beige
Consistency	Paste like, cake consistency
Density	1.45 kg/liter
Usage Period	
With moisture of air	5 min.
By blasting water on it	2 min.
Mechanic Contraction Pressure	1 - 4 kg/cm ²
Mechanic Contraction Period	
With moisture of air	45 min.
By blasting water on it	30 min.
Mechanic Contraction Temperature	Up to +60°C
Wood Moisture	8 - 16%
Application Ground Temperature	+5°C +30°C
Service Temperature	-40°C +80°C

Obtained in +23°C, 50% relative humidity conditions. Higher temperatures decrease the time, lower temperatures increase the time.



KRAFTKLEBER®

Application Procedure

Preparation of Substrate

Surfaces have to be strong, dry, bearing, dustless, clean, and also in balance and smooth. Surface must be cleaned off all kinds of oil, grease, rust, and paraffin traces that can weaken adherence and no loose particles must be present. The surface to be applied must have the capacity to bear the weights of the objects to be adhered.

Application Method

KRAFTKLEBER® is put into suitable cartridge gun and the plastic safety cover on the tip of the cartridge is cut off by a sharp knife. Then nozzle is applied on the gun, and mouth of the nozzle is cut suitably for the application.

Adhesive is applied on the application surface and spread homogenously by a spatula until minimum thickness is obtained. Surfaces have to be fixed by mechanic apparatus until **KRAFTKLEBER®** hardens completely.

Water Blasting

Water should be blast on the adhesive applied on surface. With this method, adhesive dries more quickly.

Fixing the Parts to be Adhered by Adhesion

Surfaces have to be fixed by mechanic apparatus after the adhesive application. Parts must be left still under the pressure until adherence is complete. Adhesion process should be completed during the open waiting period. Adhesion time can be shortened by blasting water or increasing compression temperature. Applied compression pressure may change depending on material type and size. Drying time may be longer in big and water vapor impermeable parts.

Coverage

200 - 400 g/m² depending on surface absorption and roughness.

Water blasting for quick setting is max. 20 g/m²

Watchpoints

- Working and reaction time of resin based systems are affected by environment and ground temperature, and relative humidity in the air. Low temperatures slow down the chemical reaction, and increase working period, coating time, and work time. Also coverage decreases because viscosity increases. High temperatures accelerate the chemical reaction and times stated above are reduced depending on this. For the material to complete its curing, environment and ground temperatures must not fall down below the minimum allowed value.
- **KRAFTKLEBER®** may not be used in adhesion of glass, mirror, bitumen and paraffin containing materials, PE, PP, PA, EPDM, and PTFE.
- May not be used in anchorage of exterior components in underwater applications.
- During the drying, CO₂ gas is formed. Bubbling of this gas has to be prevented by mechanic compression. This gas is formed depending on application amount, thickness, temperature, and moisture. It causes bubbling and fills the gaps.
- Volume increase, seen in many applications as a result of water blasting is a desirable and advantageous condition.

Cleaning of Tools

All the tools and equipments must be cleaned by appropriate solvent after the application. After **KRAFTKLEBER®** is hardened, it can only be removed from the surface mechanically.

Packaging

310 ml. cartridge.

KRAFTKLEBER®

Storage

Must be stored in unopened original packing, and away from direct sunlight and moisture. In short-term storing, maximum 3 palettes can be stowed on top of each other and delivery has to be according to first in first out system. In long-term storing, the palettes must not be stowed on top of each other.

Shelf Life

12 months after the production date under appropriate storing conditions. Opened packages have to be stored under appropriate storing conditions, and must be used in one week.

Health and Safety Precautions

Approaching warehousing and application areas by fire is hazardous. Warehousing and application areas have to be ventilated.

Work cloth, protective gloves, goggles and masks concordant with Work and Worker Health rules must be used during the application. Due to irritant effects of the non-cured material, avoid contact to skin and eyes during storing and application. If such a contact occurs, it must be washed by soap and plenty of water. Consult a physician urgently if swallowed. Food and drink must be kept outside the application areas. Must be stored away from children. Please look at the Material Safety Data Sheet for detailed information.

Disclaimer

This information given here is true, represents our best knowledge and is based not only on laboratory work, but also on field experience. However, BASF Yapı Kimyasalları San. A.S. is only responsible from the quality of the product. BASF Yapı Kimyasalları San. A.S. cannot be hold responsible from the results caused by applications of the product not in accordance

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