

KEMPERTEC MA-SF Metal Adhesive



Uses

- for bonding metal profiles and common metals (e.g. made of copper, aluminum, stainless steel, titanium zinc and galvanized steel) to building materials such as sand-lime brick, concrete, aerated concrete, brick, perforated brick, wood, chipboard and OSB boards, KEMPEROL sealant, polymer bitumen sheeting and insulating materials

Characteristics

- UV-resistant
- Cold to process
- Solvent-free
- 1-component
- Ready-to-use
- Base: bitumen emulsion
- Alkali-resistant
- Permanently plastic
- Clean, simple and fast processing
- Can be used with a spatula and stable up to 110°C

Pack sizes

5 kg and 10 kg plastic container

Shelf Life

Store unopened in a cool, dry, frost-free place. Minimum storage life: 12 months

Consumption

Depending on the character of the substrate: min. 1.5 kg/m².

Tooth- ing in mm	Consump- tion kg/m ²	Loadable after h
4	1.50	2.0
6	1.75	2.5
8	2.0	3.0

Consumption may increase due to craftsmanship, different substrates and toothing of the filler during application. However, the consumption must not exceed 3.0 kg/m².

Properties

Colour	black
Workability time*	approx. 30 min
Temperature during application and complete drying***	+5 to + 50°C
Can withstand loads after *	approx. 2 - 3 h
Final hardness after *	approx. 14 days

* Values obtained at a temperature of 23 °C - 50% rel. humidity. These values vary depending on the weather conditions, such as wind, humidity and temperature.

*** Temperature, part, installation and ambient temperatures

Application

Preparing the substrate

The substrate must be dry, level, load-bearing, frost-free, clean and free of oil, grease, tar, gravel pockets, cracks, dust, dirt, mortar residues and other impurities.

KEMPERTEC MA-SF metal adhesive can be applied directly to clean and solid substrates. Sanding, highly absorbent and open-pored substrates such as perforated bricks (Poroton), old cementitious or natural stone surfaces must be pretreated e.g. with the KEMPERTEC TG Primer after removing loose particles and dust.

Larger unevenness (>3mm) should be leveled with suitable materials before applying the KEMPERTEC MA-SF metal adhesive. KEMPEROL sealants, unsplit elastomeric membranes and insulating materials must be cleaned with suitable agents, primed with a solvent-free 2-component primer, e.g. with KEMPERTEC EP5 primer and scattered with KEMCO NQ 0712 before applying the metal adhesive. Before bonding the metal profiles, they must be cleaned of oils, greases and adhesion-reducing substances with KEMCO MEK Cleaning Agent and roughened with a P40 grit sanding sheet to avoid adhesion problems.

Application

The product KEMPERTEC MA-SF Metal Adhesive is ready to use and is taken directly out of the container with a trowel.

The material is applied with the KEMPERTEC professional toothed spatula evenly, parallel and over the full surface in the longitudinal direction of the metal over the entire surface to be bonded in the required layer thickness. Make sure to keep a distance of approx. 2 cm to the edge to prevent run-off beyond the edge. For components to be bonded in inclined ($> 3^\circ$) or vertical areas, additional mechanical fixation is necessary.

If metal is to be bonded to metal (maximum overlap approx. 5 cm), the metal parts must be secured against shifting, e.g. by implementing mechanical fixation. Bonding should be carried out within 30 minutes. Press down the metal profiles thoroughly and evenly.

Take care to apply the metal adhesive over the entire surface. The material should not extend beyond the metal/sheet to be bonded into the visible area, as otherwise yellowish discolouration may occur with subsequent primers, waterproofing products or coatings.

Areas which are not to be bonded should be masked off or protected.

Please observe the data sheet "Kleben in der Klempnertechnik" (Bonding in plumbing).

PPE

Personal protective equipment should be worn.

Important notes

The freshly applied material must be protected against rain, frost and strong sunlight until completely dry.

After removing the metal adhesive, the container has to be carefully closed in order to prevent a skin from forming. Should a skin have formed, remove it before using the material.

General information

No substances of other systems may be mixed into the products of the KEMPER SYSTEM.

Our technical data sheets / technical information and application instructions reflect the current level of knowledge in our company and the experience with our products. In each case, the new edition supersedes the previous technical information and renders it invalid. It is therefore necessary that you always have to hand the current code of practise. The latest version can be retrieved from the KEMPER SYSTEM Login section. When using our products, a detailed, object-related and qualified inspection is required in each individual case in order to determine whether the product and /or application technology in question meets the specific requirements and purposes. We are liable only for our products being free from faults, and this only if our relevant product has been used and applied according to the instructions in our technical data sheets. Correct application of

our products therefore falls entirely within the scope of liability and responsibility of the user (contractor). Our products are sold exclusively on the bases of our conditions of sale and delivery.

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