

PRODUCT DATA SHEET

Sika® Aktivator-309 P

Transparent solvent-based adhesion promoter for pinch weld and paint

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base	Solvent-based adhesion promoter	
Color (CQP001-1)	Colorless to slightly yellow	
Application temperature	-10 – 40 °C	
Application method	Wiping with lint-free paper towel	
Consumption	20 ml/m ²	
Flash-off time	-10 – 40 °C maximum	minimum 30 seconds 15 minutes
Shelf life	9 months ^A	

CQP = Corporate Quality Procedure

^{A)} stored in sealed container in a dry place at ≤ 25 °C

DESCRIPTION

Sika® Aktivator-309 P is an solvent-based colorless adhesion promoter which reacts with moisture and deposits active groups on the substrate. These groups act as a link between substrates and primers or sealants/adhesives. Sika® Aktivator-309 P is specifically formulated for the treatment of pinchweld substrates like paint, cut polyurethane, etc. prior to application of Sika's polyurethane adhesives.

PRODUCT BENEFITS

- Improves adhesion to body side substrates
- Shortest flash-off time
- Easy to apply
- Transparent

AREAS OF APPLICATION

Sika® Aktivator-309 P improves adhesion on body side substrates such as paint, pre applied adhesive systems, encapsulation on windscreens and cut face of old polyurethane adhesive.

It must not be used on glass or ceramic frits! This product is suitable for experienced professional users only. For other applications than Automotive Glass Replacement, tests with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

METHOD OF APPLICATION

Surfaces must be clean, dry and free from grease, oil, dust and contaminants.

Adhesion on substrates may be improved by adding and/or combining pre-treatment processes such as scuffing and cleaning prior to the activator application.

Application

Wipe bond faces with a clean, lint-free paper towel moistened (not wet) with Sika® Aktivator-309 P. Never dip the towel into the activator. Only wipe the surface with a clean side of the towel. Do not moisten the same paper towel twice and change it frequently.

Sika® Aktivator-309 P has to be applied sparingly (ensuring the bond face has been treated) as excess of activator could lead to adhesion failure.

If the pre-treated area is not bonded within the maximum flash-off time, the activation process has to be repeated (once only).

Ideal application and surface temperature is between 15 °C and 25 °C.

Consumption and method of application depends on the specific nature of the substrates.

Tightly reseal container immediately after each use.

IMPORTANT NOTE

Sika® Aktivator-309 P contains solvent which may dull the surface finish of some freshly applied paints. Preliminary trials must be carried out. Never apply to porous substrates since it may not dry completely and prevent the adhesive or sealant from curing. Protect adjacent surfaces by masking where necessary.

Sika® Aktivator-309 P is a moisture reactive system. In order to maintain product quality it is important to reseal the container with the inner plastic liner immediately after use. Once the surface pre-treatment operation is completed the cap has to be screwed on. Prolonged exposure to atmospheric moisture will cause Sika® Aktivator-309 P to become inactive. Immediately discard Sika® Aktivator-309 P if it has become opaque instead of clear.

Dispose of product approx. one month after opening if used frequently or after two months in case of infrequent use.

Never dilute or mix Sika® Aktivator-309 P with any other substances.

It must not be used for tooling/smoothing of products or as cleaning agent.

FURTHER INFORMATION

The information herein is offered for general guidance only. Advice on specific applications is available on request from the Technical Department of Sika Industry.

Copies of the following publications are available on request:

- Safety Data Sheets

PACKAGING INFORMATION

Can	100 ml
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BASIS OF PRODUCT DATA

All technical data stated in this document are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

HEALTH AND SAFETY INFORMATION

For information and advice regarding transportation, handling, storage and disposal of chemical products, users shall refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

DISCLAIMER

Any information or suggestions for use concerning Sika's products, which we either in writing or orally have given buyers or end-users of the product, have been given in good faith based on our own experiences and based on approved praxis and the technological and scientific knowledge on the time of giving such suggestions and information, which are given without any type of guarantees, and which do not lead to any further responsibility from Sika Danmark A/S, besides what is stated in the sales agreement in question. The buyer or end-user should themselves investigate or otherwise make sure, that our products are suitable for the use in question and further make sure that the products are kept and used correct and in agreement with the published rules and considering the actual conditions in order to avoid damages or less satisfactory results. Any order is accepted and any deliverance is affected according to the general terms of sales and delivery from Sika Danmark A/S, which are considered known and accepted, and which could be handed out when asked for. Our catalogues are not up-dated automatically. The present product data sheet is only for use in Denmark. Values stated in the present product data sheet should be seen as recommended, unless stated otherwise.

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