

## 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)**

<b>Chemical base</b>	Solvent-based adhesion promoter
<b>Color (CQP001-1)</b>	Colorless to slightly yellow
<b>Application temperature</b>	-10 – 40 °C
<b>Application method</b>	Wiping with lint-free paper towel
<b>Consumption</b>	20 ml/m <sup>2</sup>
<b>Flash-off time</b>	-10 – 40 °C maximum
	minimum 30 seconds 15 minutes
<b>Shelf life (CQP016-1)</b>	9 months <sup>A</sup>

CQP = Corporate Quality Procedure

<sup>A)</sup> 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 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

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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

The information, and, in particular, the recommendations relating to the application and enduse of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

