

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 (14 – 104 °F)
Application method	Single use applicator
Consumption	20 ml/m ²
Flash-off time	-10 – 40 °C (14 – 104 °F) minimum 30 seconds maximum 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 a 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 wind-screens 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

Point felt tip toward the ground and pinch the handle with thumb and index finger to break internal vial thus releasing Sika® Aktivator-309 P into the felt tip (do not bend!).

Apply the Sika® Aktivator-309 P to the pinch-weld in one direction while maintaining continuous contact, making sure to cover all areas of trimmed urethane. Finish just beyond the beginning point to ensure complete coverage of bond area.

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.

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.

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
- Sika AGR Technician Training Manual

PACKAGING INFORMATION

Stix	1.25 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.

ENVIRONMENTAL, HEALTH AND SAFETY

For further information and advice regarding transportation, handling, storage and disposal of chemical products, user should refer to the actual Safety Data Sheets containing physical, environmental, toxicological and other safety related data. User must read the current actual Safety Data Sheets before using any products. In case of an emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

LEGAL DISCLAIMER

Prior to each use of any product of Sika Corporation, its subsidiaries or affiliates ("SIKA"), the user must always read and follow the warnings and instructions on the product's most current product label, Product Data Sheet and Safety Data Sheet which are available at usa.sika.com or by contacting SIKA's Technical Service Department via email at tsmh@us.sika.com. Nothing contained in any SIKA literature or materials relieves the user of the obligation to read and follow the warnings and instructions for each SIKA product as set forth in the current product label, Product Data Sheet and Safety Data Sheet prior to use of the SIKA product.

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within the product's shelf life. User determines suitability of product for intended use and assumes all risks. User's and/or buyer's sole remedy shall be limited to the purchase price or replacement of this product exclusive of any labor costs. **NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS.** Sale of SIKA products are subject to the Terms and Conditions of Sale which are available at <https://usa.sika.com/en/group/SikaCorp/termsandconditions.html> or by calling +1 800-933-7452.

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