

## PRODUCT DATA SHEET

# Sika® Aktivator-205

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 TRANSPARENT SOLVENT-BASED ADHESION PROMOTER FOR NON-POROUS SUBSTRATES
 

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## TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

|                                |                                   |                           |
|--------------------------------|-----------------------------------|---------------------------|
| <b>Chemical base</b>           | Solvent-based adhesion promoter   |                           |
| <b>Color (CQP001-1)</b>        | Colorless, clear                  |                           |
| <b>Application temperature</b> | 5 – 40 °C (41 – 104 °F)           |                           |
| <b>Application method</b>      | Wiping with lint-free paper towel |                           |
| <b>Consumption</b>             | 20 ml/m <sup>2</sup>              |                           |
| <b>Flash-off time</b>          | minimum                           | 10 minutes <sup>A/B</sup> |
|                                | maximum                           | 2 hours <sup>A/B</sup>    |
| <b>Shelf life</b>              | 12 months <sup>C</sup>            |                           |

CQP = Corporate Quality Procedure

B) for specific application, temperature and flash-off time may be different

A) 23 °C (73 °F) / 50 % r. h.

C) stored in sealed container in a dry place at ≤ 25 °C (77 °F)

**DESCRIPTION**

Sika® Aktivator-205 is a solvent-based colorless clear 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-205 is designed for the treatment of bond faces prior to application of Sikaflex® and Sikasil® adhesives and sealants.

**PRODUCT BENEFITS**

- Enhanced adhesion on various substrates
- Short flash-off time
- Easy to use
- Transparent

**AREAS OF APPLICATION**

Sika® Aktivator-205 is used to improve adhesion on non-porous substrates such as metals, plastics, ceramic screen prints and painted surfaces.

Seek manufacturer's advice and perform tests on original substrates before using Sika® Aktivator-205 on materials prone to stress cracking. This product is suitable for experienced professional users only. Tests with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

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Sika® Aktivator-205

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014560012050001000

## 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-205. 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-205 has to be applied sparingly 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 (59 °F and 77 °F).

Consumption and method of application depends on the specific nature of the substrates. Tightly reseal container immediately after each use.

## IMPORTANT NOTE

Sika® Aktivator-205 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.

If Sika® Aktivator-205 is accidentally splashed onto adjacent surfaces, wipe-off immediately with a clean, dry cloth.

Sika® Aktivator-205 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-205 to become inactive. Immediately discard Sika® Aktivator-205 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-205 with any other substances.

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

If used on transparent or translucent substrates such as float glass, plastics, etc., an adequate UV protection is mandatory.

## 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.

Working instructions issued for a defined application may further specify technical data contained in this Product Data Sheet.

Copies of the following publications are available on request:

- Safety Data Sheets

## PACKAGING INFORMATION

|     |                   |
|-----|-------------------|
| Can | 250 ml<br>1000 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](http://usa.sika.com) or by contacting SIKA's Technical Service Department via email at [tsmh@us.sika.com](mailto: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.

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