

## PRODUCT DATA SHEET

# Sika® Aktivator-306 LUM

Solvent-based adhesion promoter for coatings

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

<b>Chemical base</b>	Solvent-based adhesion promoter						
<b>Color (CQP001-1)</b>	Slightly yellow						
<b>Application temperature</b>	5 – 40 °C						
<b>Application method</b>	Wipe-on, wipe-off with lint-free paper towel						
<b>Consumption</b>	depending on substrate porosity 20 ml/m <sup>2</sup>						
<b>Flash-off time</b>	<table border="0"> <tr> <td>≥ 15 °C</td> <td>10 minutes<sup>A</sup></td> </tr> <tr> <td>&lt; 15 °C</td> <td>30 minutes<sup>A</sup></td> </tr> <tr> <td>maximum</td> <td>2 hours<sup>A</sup></td> </tr> </table>	≥ 15 °C	10 minutes <sup>A</sup>	< 15 °C	30 minutes <sup>A</sup>	maximum	2 hours <sup>A</sup>
≥ 15 °C	10 minutes <sup>A</sup>						
< 15 °C	30 minutes <sup>A</sup>						
maximum	2 hours <sup>A</sup>						
<b>Shelf life</b>	12 months <sup>B</sup>						

CQP = Corporate Quality Procedure

<sup>A)</sup> in specific application, temperature and flash-off time may be different<sup>B)</sup> stored in sealed container in a dry place at ≤ 25 °C**DESCRIPTION**

Sika® Aktivator-306 LUM is a solvent-based, slightly yellow 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-306 LUM is specifically formulated for the treatment of non-porous bond faces prior to the application of Sika's elastic adhesives and sealants.

Sika® Aktivator-306 LUM fluoresces under long-wave UV light for a limited period of time. This feature is used for in-process control.

**PRODUCT BENEFITS**

- Visible under UV light, suitable for automated in-process control
- One pre-treatment for various coatings
- Easy to apply

**AREAS OF APPLICATION**

Sika® Aktivator-306 LUM is used to improve adhesion on substrates such as coil-coated, powder-coated, stove-enamel and other painted or primed surfaces.

Sika® Aktivator-306 LUM cannot be used on glass or ceramics for black-primerless bonding.

This product is suitable for experienced professional users only. Tests with actual substrates and conditions have to be performed ensuring adhesion and material compatibility.

## METHOD OF APPLICATION

### Preparation

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-306 LUM. Immediately wipe-off with a clean, dry, lint-free paper towel. 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-306 LUM 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.

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

Tightly reseal container immediately after each use.

### IMPORTANT NOTE

Sika® Aktivator-306 LUM 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-306 LUM 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-306 LUM to become inactive. Immediately discard Sika® Aktivator-306 LUM 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.

When applied to some light-colored substrates the product may appear slightly yellow in color, but this typically will disappear completely within hours.

Never dilute or mix Sika® Aktivator-306 LUM 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, an adequate UV protection is mandatory.

### DETECTION OF THE LUMINESCENCE

Sika® Aktivator-306 LUM can be visualized by using a light source with a wavelength of 320 to 420 nm as in-line control. By reducing foreign light such as sunlight or artificial light during the detecting process the quality of the detection can be increased significantly.

Note: The luminescent effect will degrade with time.

### 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	250 ml 1 000 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

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