

## PRODUCT DATA SHEET

# Sika® Aktivator DM-1

Solvent based activator to improve adhesion coatings

**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>Density</b>                            | 0.72 kg/l  |
| <b>Application temperature</b>            | 15 – 35 °C   |
| <b>Application method</b>                 | manual or automated Wipe-on, wipe-off with lint-free paper towel |
| <b>Consumption</b>                        | 40 ml/m <sup>2</sup>   |
| <b>Flash point (CQP007-1 / ISO 13736)</b> | -4 °C  |
| <b>Flash-off time</b>                     | minimum 5 minutes <sup>A</sup><br>maximum 24 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 up-right position in a dry place at ≤ 25 °C, protected from sunlight

**DESCRIPTION**

Sika® Aktivator DM-1 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 DM-1 is specifically formulated for the treatment of non-porous bond faces prior to the application of Sika's elastic adhesives and sealants.

**PRODUCT BENEFITS**

- Easy to apply
- Short minimum flash-off time

**AREAS OF APPLICATION**

Sika® Aktivator DM-1 is used to improve adhesion on substrates such as coil coated, powder coated, stove enamel and other painted or primed substrates.

Sika® Aktivator DM-1 cannot be used on glass or ceramics for black-primerless bonding.

Seek manufacturer's advice and perform tests on original substrates before using Sika® Aktivator DM-1 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 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 to the activator application.

### Application

Wipe bond faces with a clean, lint-free paper towel moistened (not wet) with Sika® Aktivator DM-1. 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 DM-1 has to be applied sparingly as excess of activator could lead to adhesion failure.

Deviation from described application method has to be tested, to ensure product properties.

### DRYING

In order to validate the appropriate drying time, testing must be performed on original substrates and in actual process conditions used.

### IMPORTANT NOTE

Sika® Aktivator DM-1 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 DM-1 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® Paint Aktivator PSA to become inactive.

Immediately discard Sika® Aktivator DM-1 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 DM-1 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.

### 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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| Can | 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.

## 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.