

# Activator for RK-1300 & RK-1500



## Activator for RK-1300/1500

### Technical Data

Viscosity Activator	very thin liquid
Specific weight	0,87 g/cm <sup>3</sup>
Colour Activator	colourless, transparent
Consumption depending on surface structure	30 - 150 g/m <sup>2</sup>
Evaporation time of the activator at +20°C	5 min.
Effectiveness of the Activator after application at +20°C	30 day(s)

### Surface pre-treatment

To ensure perfect bonding, the surfaces to be joined must be clean and dry (to clean and degrease use WEICON Surface Cleaner). The highest strength values can be achieved through additional pre-treatment of the surfaces, such as roughening using blasting or abrasive agents. Several plastics, in particular polyamide, PTFE, polyolefin etc. can only be bonded after special surface treatment, for example using fluoridation, low-pressure plasma, corona, flame impingement etc.

### Processing

#### Processing of the RK Activator

The RK Activator is applied, depending on the size of the bonding gap, on either one side or both sides of the surfaces to be bonded (brush, spray, dip). In case of bond lines with a max. of 0.4 mm in width, the Activator only needs to be applied on one side, for bond lines of up to a max. of 0.8 mm in width and/or rough, porous or passive surfaces (chrome, nickel etc) the Activator must be applied on both sides. For smooth plastic and metal surfaces, approx. 30

g/m<sup>2</sup> is necessary, for rough and porous surfaces up to 150 g/m<sup>2</sup> of Activator may be necessary. The evaporation time at room temperature (+20°C) is at least 5 minutes. A significant advantage to other adhesive systems is that the coated components can be stored up to 30 days at room temperature (+20°C) without losing effectiveness.

#### Processing of the RK Adhesive

The Adhesive is applied only on one side and normally on the surface which is not coated with Activator. The size of the bonding gap can be up to 0.80 mm (only if the Activator is applied on both sides). Bonding gaps of 0.15 mm to 0.25 mm in width always have the highest tensile shear strength.

#### Processing temperature

The processing should take place at room temperature (approx. +20°C). Higher temperatures, e.g. +40°C shorten the positioning and curing times by approx. 30%, lower temperatures of approx. +10°C increase the respective times by approx. 50% and at down +5°C almost no reaction occurs anymore.

#### Storage

WEICON RK-Activator has a shelf life of at least 6 months if stored in a dry room at a constant temperature of approx. +20°C. At temperatures between +1°C and +7°C the shelf life can be extended up to 24 months. This applies for closed original units which have not been directly or indirectly exposed to sunrays. In case of storage temperatures exceeding +40°C and high humidity, the shelf-life is considerably shortened.

#### Safety and health

When using WEICON products, the physical, safety technical, toxicological and ecological data and regulations in our EC safety data sheets ([www.weicon.com](http://www.weicon.com)) must be observed.

#### Available sizes:

10562100	Activator for RK-1300 & RK-1500 100 ml
10562901	Activator for RK-1300 & RK-1500 1 L

#### Note

The specifications and recommendations given in this technical data sheet must not be seen as guaranteed product characteristics. They are based on our laboratory tests and on practical experience. Since individual application conditions are beyond our knowledge, control and responsibility, this information is provided without any obligation. We do guarantee the continuously high quality of our products. However, own adequate laboratory and practical tests to find out if the product in question meets the requested properties are recommended. A claim cannot be derived from them. The user bears the only responsibility for non-appropriate or other than specified applications.

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