Sika® Aktivator-205
(formerly Sika® Cleaner-205)

Pre-treatment Agent for Non-Porous Substrates

Technical Data

<table>
<thead>
<tr>
<th>Chemical Base</th>
<th>Alkyl titanate in an alcohol solution</th>
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<tbody>
<tr>
<td>Colour</td>
<td>Transparent, clear</td>
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<tr>
<td>Density (CQP(^1) 006-3/ISO 2811-1)</td>
<td>Approx 0.8 kg/l</td>
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<tr>
<td>Viscosity(^2) (CQP 029-3/ISO 3219)</td>
<td>Approx 2 mPa’s</td>
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<tr>
<td>Flash Point (CQP 007-1/ISO 13736)</td>
<td>14°C (55°F)</td>
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<tr>
<td>Application Temperature</td>
<td>5°C to 35°C (40°F to 95°F)</td>
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<tr>
<td>Application Method</td>
<td>With cotton rag or paper towel</td>
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<tr>
<td>Coverage</td>
<td>Approx. 50 ml/m²</td>
</tr>
<tr>
<td>Flash-off Time(^2,3)</td>
<td>minimum - 10 minutes</td>
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<td></td>
<td>maximum - 2 hours</td>
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<tr>
<td>Storage</td>
<td>Store in sealed container in a cool, dry place</td>
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<tr>
<td>Shelf Life</td>
<td>12 months</td>
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</tbody>
</table>

\(^1\) CQP = Corporate Quality Procedures.  \(^2\) 23°C and 50% relative humidity.  \(^3\) Drying time may be affected by temperature and specific applications.

Description

Sika® Aktivator-205 is an alcohol solution containing a bond-activating substance for activating bond faces prior to bonding and sealing with Sikaflex® products. Sika® Aktivator-205 is manufactured in accordance with ISO 9001 and ISO 14001 Quality Assurance Systems.

Product Benefits

Cleans and improves adhesion on non-porous surfaces which to be adhered using Sikaflex® products.

Areas of Application

Sika® Aktivator-205 is used to activate the following non-porous substrates: metals, plastics, glazed ceramics and painted surfaces. This product is suitable for professional, experienced users only. Testing with actual substrates and conditions has to be performed to ensure adhesion and material compatibility.

Method of Application

Wipe bond faces with a clean lint-free cloth or absorbent paper towel moistened with Sika® Aktivator-205. Change cloth or paper towel after each wipe. Tightly re-seal the container immediately after each use. Prolonged exposure to atmospheric moisture will cause Sika® Aktivator-205 to become opaque/cloudy and, therefore, inactive. Discard any product in this condition. Flash-off time will vary based on climatic conditions.
**Important Note**  
Sika® Aktivator-205 contains isopropanol, which may dull the surface finish of some freshly applied paints. Preliminary trials should be carried out. If Sika® Aktivator-205 is accidentally splashed onto adjacent surfaces, wipe off immediately with a clean, dry cloth. **Never apply onto a porous substrate.** The cleaner may not dry completely on porous surfaces, preventing the adhesive or sealant from curing properly. Where necessary, adjacent porous surfaces should be masked. Sika® Aktivator-205 should be used within one month of opening the can. Discard any Sika® Aktivator-205 that has become opaque or cloudy. Sika® Aktivator-205 must not be used for removing or tooling uncured Sikaflex® polyurethane products.

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**Further Information**  
Working instructions for a defined application may require information beyond that which is supplied in this Product Data Sheet. Copy of the following publications are available upon request:
- Material Safety Data Sheet
- Sika Pre-treatment Chart

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**Packaging**  
Bottles of:
- 30 ml
- 250 ml
- 1 litre

Jugs of:
- 3.78 L

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**Value Bases**  
All technical data stated in this Product Data Sheet are laboratory test-based. Current measured values may vary due to factors beyond our influence.

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**Health and Safety Information**  
For information and advice on the safe handling, storage and disposal of chemical products, users should refer to the current Material Safety Data Sheet containing physical, ecological, toxicological and other safety-related data for the appropriate type of substance. All Product Data Sheets and Material Safety Data Sheets are available on our website at: www.sika.ca.