

# Activator for RK-1300 & RK-1500



## Activator for RK-1300/ RK1500

For the process-safe application of the MMA adhesives RK-1300 and RK-1500 in large containers (800 g can, 330 g cartridge, 6 kg can). The activator causes the adhesives to cure and is available in the following container sizes: 100 ml pump spray or 1 l bottle.

### Characteristics

Colour	colourless, transparent	
Minimum shelf life	at room temperature	6 mon.
Minimum shelf life	from +2 °C to +7 °C	12 Mon.

### Approvals / Guidelines

MIL-Spec	complies with	MIL-A-8064B
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## Instructions for use

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

## Surface Pre-Treatment

Clean and dry bonding surfaces are essential for flawless adhesive bonding (e.g. cleaning and degreasing with WEICON Surface Cleaner). Higher strengths can be achieved by further pre-treatment of the surfaces, such as roughening by blasting or grinding. Some plastics, especially polyamides, PTFE, polyolefines etc., can only be bonded after special pre-treatment of the surfaces by e.g. fluorination, low-pressure plasma, corona, flame treatment, or similar.

## Application

Processing the RK Activator: Depending on the size of the bonding gap, the RK Activator is applied to one or both sides of the bonding surfaces (brush, spray, dip). For adhesive gaps up to max. 0.4 mm, a single-sided application is sufficient; for adhesive gaps up to max. 0.8 mm and/or rough, porous as well as passive surfaces (chrome, nickel, etc.), a double-sided application is required. For smooth plastic and metal surfaces approx. 30 g/m<sup>2</sup>, for rough and porous surfaces up to 150 g/m<sup>2</sup> activator are required. The flash-off time is at least 5 minutes at room temperature (+20°C). A significant advantage over other adhesive systems is that the coated workpieces can be stored at room temperature (+20°C) for up to 30 days without the effectiveness decreasing. Processing of the RK Adhesive: The adhesive is only applied on to side and usually to the surface not coated with activator. The bonding gap can be up to 0.80 mm (only with activator applied to both sides). Adhesive joints with a thickness of 0.15 mm to 0.25 mm generally have the highest tensile shear strength. Processing temperature: The processing should be done at room temperature (+20°C). Higher temperatures e.g. +40°C shorten the positioning and curing times by approx. 30%; low temperatures around +10°C increase the respective times by approx. 50%, until from +5°C almost no reaction takes place.

## Scope of delivery

Activator

## Available sizes

- 10000131 Activator for RK-1300 & RK-1500, 1 L, colourless, transparent
- 10000128 Activator for RK-1300 & RK-1500, 100 ml, colourless, transparent

### 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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# Activator for RK-1300 & RK-1500

Epoxy Resin Systems

## Plastic Metal

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