

TECHNICAL DATA SHEET

BONDAN AT91

Revision: 03.03.2021

Version: 1.001



PRODUCT DESCRIPTION

BONDAN AT91 is a solvent-free activator for accelerating the curing of anaerobic adhesives and sealants. Even in the case of passivated, oxidized metallic surfaces, at low temperatures or in case of large gaps, curing of the adhesive can be achieved within 20 – 180 seconds. After applying the activator no flash-off time must be considered as the product is solvent-free.

When using an activator, it should be noted that, generally, the final product strength can be reduced. In addition, the contact with some thermoplastic materials (such as ABS, PS, PMMA, PC, etc.) should be avoided due to the possibility of stress cracking.

TECHNICAL PROPERTIES

Appearance	liquid
Color	green
Viscosity at 25 °C	5 – 10 mPa·s
Density at 20 °C	1.0 g/cm ³
Flash point	> 100 °C
Activation effect on surface	up to 24 h

DIRECTIONS FOR USE

- Please consult the safety data sheet before use.
- Clean, dry and grease-free surfaces ensure the maximum strength.
- Soiled surfaces must be cleaned (e.g. with BONDAN Cleaner or an appropriate solvent).
- Ensure sufficient flash-off time when cleaning parts.
- Apply a thin film of the activator on the surface. Apply the adhesive on the opposite side and join parts quickly.
- No flash-off time must be considered as the product is solvent-free.
- Only in case of large gaps/clearance between parts apply activator on both sides.

STORAGE

- 12 months in unopened original packaging
- We recommend storing the product in a cool, dry place at temperatures below 25 °C.

PRODUCT LABELLING

See safety data sheet.

PACKAGE UNITS

- For manual application 20 g

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