

SILIKAL® Additive M is a bonding enhancer for ceramic and other poorly absorbent substrates. It can also be used at joins to metal and when working over small areas of metal substrates.

SILIKAL® Additive M is employed solely in combination with the urethane-modified reactive resin SILIKAL® RU 727. It is essential that the required quantity of max. 0.3 % pbw. (related to the resin content) is not exceeded, as a higher dosage will lead to curing problems.

Resins mixed with SILIKAL® Additive M are not stable for storage. It is therefore important that it is not added until immediately before application. In the premixed condition SILIKAL® Additive M loses its effectiveness after about 2 hours.

Recommended batch quantity:

5.3 kg of SILIKAL® RU 727 resin
1.0 kg of SILIKAL® Additive I
19 g of SILIKAL® Additive M (0.3 % pbw.)

Characteristics of Additive M as delivered


Property	Measuring method	Approx. value
Viscosity at +20 °C	DIN 53 015	approx. 60 mPa · s
Flow time at +20 °C, 4 mm cup	DIN 53 211	17 – 20 sec.
Density D ₄ ²⁰	DIN 51 757	1.21 g/cm ³
Flash point	DIN 51 755	+15 °C


You must remember that admixing SILIKAL® Additive M will result in a slight delay in the curing process and an intensive yellowing of the resin. It is therefore recommended that the quantity of hardener powder be increased by 1 % on the quantity indicated under SILIKAL® RU 727 resin in the “Hardener dosages” table.

For the required quantity of hardener for applying SILIKAL® RU 727 resin in combination with SILIKAL® Additive M, please refer to the following table.

Hardener dosages for RU 727 in combination with Additive M

Temperature	Hardening powder % pbw. *	Pot life approx. min.	Hardening time approx. min.
0 °C	6.0	20	60
+10 °C	5.0	15	40
+20 °C	4.0	15	40
+30 °C	3.0	10	25

* The quantity of hardening powder is always related to the quantity of resin including SILIKAL® Additive I.
 For further information, please refer to the separate product information sheet “SILIKAL® Hardening Powder”.

	Other applicable documents	Data sheet	Page
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