

## PRODUCT DATA SHEET

# Sika® Aktivator-319

(formerly G(GC-20))

Solvent-based adhesion promoter for glass and metal

## TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

|                              |                                         |
|------------------------------|-----------------------------------------|
| Chemical base                | Solvent-based adhesion promoter         |
| Color                        | Colorless, clear to yellowish           |
| Solid content (JASO M338-89) | 2 %                                     |
| Viscosity (JASO M338-89)     | (#4 Ford cup) 11 seconds                |
| Application temperature      | 5 – 35 °C                               |
| Application method           | Wipe-on with lint-free paper towel      |
| Flash-off time               | above 5 °C 2 minutes<br>maximum 8 hours |
| Shelf life                   | 6 months                                |

**DESCRIPTION**

Sika® Aktivator-319 is a solvent-based adhesion promoter, which reacts with moisture and deposits active groups on the substrate. These groups act as a link between substrates and primers or sealants/adhesives. Sika® Aktivator-319 is specifically formulated for the treatment of bond faces prior to application of Sika's 1-component polyurethanes.

**PRODUCT BENEFITS**

- Easy to use
- Short flash-off time
- Very good adhesion to glass and metal

**AREAS OF APPLICATION**

Sika® Aktivator-319 is used to improve adhesion on different non-porous substrates such as float glass or ceramic-coated glass and metal. This product is suitable for experienced professional users only. Tests with actual substrates and conditions have to be performed ensuring adhesion and material compatibility.

METHOD OF APPLICATION

Preparation

Surfaces must be clean, dry and free from grease, oil, dust and contaminants. Adhesion on substrates may be improved by adding and/or combining pre-treatment processes such as scuffing, cleaning and activating.

Application

Moisten a clean and lint free cloth or paper towel with Sika® Aktivator-319 and wipe bonding surfaces once ensuring the bond face has been treated. Ideal application and surface temperature is between 5 °C and 35 °C. Prolonged exposure to atmospheric moisture will cause Sika® Aktivator-319 to become inactive. Tightly reseal container immediately after each use. Consumption and method of application depends on the specific nature of the substrates.

IMPORTANT NOTE

Sika® Aktivator-319 contains solvent which may dull the surface finish of some freshly applied paints. Preliminary trials must be carried out. Never apply to porous substrates since it may not dry completely and prevent the adhesive or sealant from curing. Protect adjacent surfaces by masking where necessary.

Sika® Aktivator-319 is a moisture reactive system. In order to maintain product quality it is important to reseal the container with the inner plastic liner immediately after use. Once the surface pre-treatment operation is completed the cap has to be screwed on. Prolonged exposure to atmospheric moisture will cause Sika® Aktivator-319 to become inactive. Immediately discard Sika® Aktivator-319 if it has become opaque instead of clear. Dispose of product approx. 2 hours after opening. Never dilute or mix Sika® Aktivator-319 with any other substances. It must not be used for tooling/smoothing of products or as cleaning agent. If used on transparent or translucent substrates such as float glass an adequate UV protection is mandatory.

FURTHER INFORMATION

The information herein is offered for general guidance only. Advice on specific applications is available on request from the Technical Department of Sika Industry. Copies of the following publications are available on request:

- Safety Data Sheets

PACKAGING INFORMATION

|     |       |
|-----|-------|
| Can | 100 g |
|-----|-------|

BASIS OF PRODUCT DATA

All technical data stated in this document are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

HEALTH AND SAFETY INFORMATION

For information and advice regarding transportation, handling, storage and disposal of chemical products, users shall refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

DISCLAIMER

The information, and, in particular, the recommendations relating to the application and enduse of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

