

PRODUCT DATA SHEET

Sika® Aktivator-319 US

(formerly 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 ^A maximum 8 hours ^A
Shelf life	12 months ^B

^A) for specific application, temperature and flash-off time may be different^B) stored in sealed container in up-right position in a dry place ≤ 25 °C**DESCRIPTION**

Sika® Aktivator-319 US 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 US 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
- Suitable for different substrates

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 US 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 US 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 US 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 US 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 US to become inactive. Immediately discard Sika® Aktivator-319 US if it has become opaque instead of clear. Dispose of product 14 days after opening.

Never dilute or mix Sika® Aktivator-319 US 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	700 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.

ENVIRONMENTAL, HEALTH AND SAFETY

For further information and advice regarding transportation, handling, storage and disposal of chemical products, user should refer to the actual Safety Data Sheets containing physical, environmental, toxicological and other safety related data. User must read the current actual Safety Data Sheets before using any products. In case of an emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

LEGAL DISCLAIMER

Prior to each use of any product of Sika Corporation, its subsidiaries or affiliates ("SIKA"), the user must always read and follow the warnings and instructions on the product's most current product label, Product Data Sheet and Safety Data Sheet which are available at usa.sika.com or by contacting SIKA's Technical Service Department via email at tsmh@us.sika.com. Nothing contained in any SIKA literature or materials relieves the user of the obligation to read and follow the warnings and instructions for each SIKA product as set forth in the current product label, Product Data Sheet and Safety Data Sheet prior to use of the SIKA product.

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within the product's shelf life. User determines suitability of product for intended use and assumes all risks. User's and/or buyer's sole remedy shall be limited to the purchase price or replacement of this product exclusive of any labor costs. **NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS.** Sale of SIKA products are subject to the Terms and Conditions of Sale which are available at <https://usa.sika.com/en/group/SikaCorp/termsandconditions.html> or by calling +1 800-933-7452.

PRODUCT DATA SHEET

Sika® Aktivator-319 US
Version 01.01 (10 - 2026), en_US
014560013338266184

Sika Corporation
30800 Stephenson Highway
Madison Heights, MI 48071
U.S.A.
Telephone: +1 248-577-0020
Email: tsmh@us.sika.com
www.sikausa.com

