Product Data Sheet
Edition 16 April 2015

Industry

Sika® Primer-210

Primer with good allround qualities

Technical Product Data:

Chemical base	Solvent-based adhesion promoter
Colour	Transparent, yellow
Density (CQP[1] 006-3 / ISO 2811-1)	1.0 kg/l approx.
Flash point (CQP 007-1 / ISO 13736)	-4°C
Solids content	34%
Application temperature	5-40ºC
Application method	Brush, felt, lint-free cloth or foam applicator
Coverage	50-150 ml / m^2 approx. depending on substrate porosity
Flash-off time ≥ 15ºC	10 min.
< 15ºC	30 min.
Maximum	24 hours
Storage	Store in sealed container in a cool dry place ≤ 25ºC
Shelf life	9 months

[1] CQP = Corporate Quality Procedure [2] In specific applications temperature and flash-off time may be different.

Description:
Sika® Primer-210 is a liquid primer of low viscosity to improve adhesion of Sikaflex® products on various substrates.
Sika® Primer-210 is manufactured in accordance with the ISO 9001/14001 quality assurance system and responsible care program.

Areas of application:
Sika® Primer-210 is used to improve the adhesion of Sikaflex® adhesives on many metals such as aluminium and galvanized steel, plastics and paint-primed substrates. This primer is also suitable to enhance the adhesion of Sikasil® sealants and adhesives on porous and non-porous substrates.
This product is suitable for experienced professional users only. Test with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

Method of application:
Surfaces must be clean, dry and free from grease, oil and dust.
Adhesion on substrates might be improved by adding and/or combining pre-treatment processes such as scuffing, cleaning and activating. Pre-treat the bond face of non-porous substrates with Sika® Aktivator-205 and leave to flash-off. Apply a thin but covering coat of Sika® Primer-210 with a brush, felt, clean lint-free cloth or foam applicator. It shall be applied once only. Care must be taken to ensure that this single application gives adequately dense coverage.
Sika® Primer-210 exhibits thermoplastic behaviour for up to 3 days following application. Ideal application and surface temperature is between 15°C and 25°C. Consumption and method of application depend on the specific nature of the substrates and manufacturing process.

Important note:
Sika® Primer-210 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.
Dispose the product of approx. one month after opening if used frequently or after 2 months in case of infrequent use.
If gelling, separation or a significant increase in viscosity is noted, discard the primer immediately.
Never dilute or mix this product with any other substances.

Further information:
Working instructions issued for a defined application may further specify technical data contained in this Product Data Sheet. Copies of the following publications are available on request.

- Sika Pre-Treatment Chart
- Safety Data Sheet

Packaging information:

Can	250 ml
	1000 ml

Value Bases
All technical data stated in the Product Data Sheet are laboratory test based. Current measured values may vary due to factors beyond our influences.

Health and Safety Information:
For information and advice on the safe handling, storage and disposal of chemical products, users should refer to the current Safety Data Sheet containing physical, ecological, toxicological and other safety-related data.

Note:
The information, and, in particular, the recommendations relating to the application and end-use 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 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 proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users should always refer to the most recent issue of the Australian version of the Product Data Sheet for the product concerned, copies of which will be supplied on request.

Sika Australia Pty Limited
ABN 12 001 342 329

aus.sika.com
Tel: 1300 22 33 48