BUILDING TRUST

PRODUCT DATA SHEET

Sika® Primer-215

Non-pigmented, solvent-based primer for plastics and wood

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base		Solvent-based Polyurethane solution
Color (CQP001-1)		Colorless, slightly yellow
Solid content		34 %
Application temperature		5 – 40 °C
Application method		Brush, felt or foam applicator
Consumption	depending to substrate porosity	50 g/m^2
Flash-off time	≥ 15 °C	30 minutes [A]
	< 15 °C	60 minutes [A]
	maximum	24 hours [A]
Shelf life		12 months [B]

CQP = Corporate Quality Procedure
[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 at ≤ 25 °C

DESCRIPTION

Sika® Primer-215 is a solvent-based colorless to slightly yellow primer, which reacts with moisture and forms a thin layer. This layer acts as a link between substrates and adhesives.
Sika® Primer-215 is specifically formulated for the treatment of bond faces prior to application of Sika's 1-component Polyurethanes.

AREAS OF APPLICATION

Sika® Primer-215 is used to improve adhesion on many plastics and wood such as GRP, epoxy resins, PVC, ABS and timber.
Due to the wide variety of plastics it is mandatory to perform preliminary tests on original substrates under production conditions.
Seek manufacturer's advice and perform tests on original substrates before using Sika® Primer-215 on materials prone to stress cracking.
This product is suitable for experienced professional users only. Tests 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, dust and contaminants.
Adhesion on substrates might be improved by adding and/or combining pre-treatment processes such as scuffing, cleaning and activating prior the primer application.

Application

Apply a thin but covering coat of Sika® Primer-215 with a brush, felt or foam applicator.
Ideal application and surface temperature is between 15 °C and 25 °C.
Sika® Primer-215 has to be applied once only. Care must be taken to ensure that this single application gives adequately dense coverage.
Consumption and method of application depend on the specific nature of the substrates.
Tightly reseal container immediately after each use.

IMPORTANT NOTE

Sika® Primer-215 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 of product approx. one month after opening if used frequently or after two months in case of infrequent use. 30 ml cans are for single application only.
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.
If used on transparent or translucent substrates such as plastics, etc., 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	30 ml 250 ml 1000 ml

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.

Sika (Singapore) Pte Ltd.
28 Tuas South Ave 8
Singapore 637648
Phone: +65 6861 0632
Fax: +65 6862 3915
Email: sales@sg.sika.com
www.sika.com.sg