

## PRODUCT DATA SHEET

# Sika® Primer-210

Non-pigmented, solvent-based primer for metals

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

<b>Chemical base</b>	Solvent-based Epoxy solution
<b>Color (CQP001-1)</b>	Colorless, slightly yellow
<b>Solid content</b>	34 %
<b>Application temperature</b>	5 – 40 °C (41 – 104 °F)
<b>Application method</b>	Brush, felt, lint-free cloth or foam applicator
<b>Consumption</b>	depending on substrate porosity 50 ml/m <sup>2</sup>
<b>Flash-off time</b>	≥ 15 °C (59 °F) 10 minutes <sup>A</sup> < 15 °C (59 °F) 30 minutes <sup>A</sup> maximum 24 hours <sup>A</sup>
<b>Shelf life</b>	9 months <sup>B</sup>

CQP = Corporate Quality Procedure <sup>A)</sup> for specific application, temperature and flash-off time may be different  
<sup>B)</sup> stored in sealed container in up-right position in a dry place at ≤ 25 °C (77 °F)

**DESCRIPTION**

Sika® Primer-210 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-210 is specifically formulated for the treatment of bond faces prior to application of Sika's 1-component Polyurethanes.

**AREAS OF APPLICATION**

Sika® Primer-210 is used to improve adhesion on many metals such as aluminum, steel and non-ferrous metals. The primer might also be used to enhance the adhesion of Sikasil® sealants and adhesives.

Seek manufacturer's advice and perform tests on original substrates before using Sika® Primer-210 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-210 with a brush, felt, clean lint-free cloth or foam applicator.

Sika® Primer-210 exhibits a thermo-plastic behavior up to 3 days after application, therefore higher temperature or early stress to the bond line have to be avoided.

Ideal application and surface temperature is between 15 °C and 25 °C (59 °F and 77 °F).

Sika® Primer-210 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.

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Sika® Primer-210

Version 02.01 (03 - 2023), en\_US  
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### 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 of product approx. one month after opening if used frequently or after two 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.

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	250 ml
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### 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](http://usa.sika.com) or by contacting SIKA's Technical Service Department via email at [tsmh@us.sika.com](mailto: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.

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