

Sika® Primer -210

Primer with Good Allround Qualities

Technical Data

Chemical base	Solvent-Based Adhesion Promoter	
Colour	Colourless, Slightly Yellow	
Density (CQP ¹ 006-3 / ISO 2811-1)	1.0 kg/l approx.	
Flash point (CQP 007-1 / ISO 13736)	-4°C (25°F)	
Solid content	34%	
Application temperature	5 - 40°C (40 - 105°F)	
Application	Brush, felt, lint-free cloth or foam applicator	
Coverage	50 - 150 ml/m ² approx. depending on substrate porosity	
Flash-off time ^{2/3}	≥ 15°C (60°F)	10 min
	< 15°C (60°F)	30 min
	maximum	24 hours
Storage	In sealed container in a dry place at ≤ 25°C (77°F)	
Shelf life	9 months	

¹⁾ CQP = Corporate Quality Procedure

²⁾ 23°C (73°F) / 50% r.h.

³⁾ In specific applications temperature and flash-off time may be different

Product Description

Sika® Primer-210 is a low viscosity liquid primer to improve adhesion of Sikaflex® products on various substrates.

Sika® Primer-210 is manufactured in accordance with ISO 9001 / 14001 quality assurance system and the responsible care program.

Areas of Application

Sika® Primer-210 is used to improve the adhesion of Sikaflex® adhesives on many metals such as aluminum 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. Tests with actual substrates and conditions, especially boundary temperature 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. For use with Sikasil® products on non-porous substrates pre-treatment with Sika® Cleaner-P (wipe-on/wipe-off) is also possible.

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 thermo-plastic behaviour for up to 3 days following application. Ideal application and surface temperature is between 15°C to 25°C (60°F to 75°F).

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:

- Safety Data Sheets
- Sika Pre-treatment Chart for 1-Component Polyurethanes

Packaging Information

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Value Bases

All technical data stated in this Product Data Sheet are laboratory test based. Current measured values may vary do to factors beyond our influences.

Health and Safety Information

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

Legal Notes

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 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.



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