

## PRODUCT DATA SHEET

# Sika® Primer-541 M

(formerly M(M-300), M(RC-50E))

Pigmented, solvent-based Primer for paints or plastics

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

Chemical base	Solvent-based polyurethane solution
Color	Black
Solid content (JASO M338-89)	24 %
Viscosity (JASO M338-89) (#4 Ford cup)	11 seconds
Application temperature	5 – 40 °C
Application method	Brush
Flash-off time	above 5 °C 2 minutes maximum 8 hours
Shelf life	6 months

**DESCRIPTION**

Sika® Primer-541 M is a solvent-based black primer, which reacts with moisture and forms a thin layer. This layer acts as a link between substrates and adhesives.

Sika® Primer-541 M is specifically formulated for the treatment of bond faces prior to application of Sika's 1-component polyurethanes.

The primer might provide adhesion without previous activation step on many substrates.

**PRODUCT BENEFITS**

- One-step application
- Very good adhesion to paints or plastics
- Easy to use

**AREAS OF APPLICATION**

Sika® Primer-541 M is used to improve adhesion on different substrates such as paints or plastics.

Seek manufacturer's advice and perform tests on original substrates before using Sika® Primer-541 M 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 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

Shake the Sika® Primer-541 M container thoroughly before use. Use a shaker (40 mm amplitude, 300 rpm) for at least 10 minutes, or shake vigorously by hand (5 Hz) for at least 60 seconds. Apply a thin, uniform, and continuous coat using a soft brush. Sika® Primer-541 M must be applied once only. Care must be taken to ensure that this single application gives adequately dense coverage. Consumption and method of application depends on the specific nature of the substrates. Tightly reseal container immediately after each use.

IMPORTANT NOTE

Sika® Primer-541 M 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.

If the container remains open for more than 2 hours, the product must be discarded. If the primer is used and the container is resealed after opening, the remaining primer must be disposed of within 24 hours. 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 float glass, plastics, etc., an adequate UV protection is mandatory.

STORAGE CONDITIONS

Sika® Primer-541 M must be stored in sealed container, in a up-right position at temperature ≤ 10 °C in a dry place. Do not expose it to direct sunlight. After opening of the packaging, the content has to be protected against humidity.

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	150 ml 900 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.

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.

