

Sika® Primer -209 D

Technical Product Data

Chemical base	Pigmented, solvent-based adhesion promoter
Colour	Black
Density (CQP ¹ 006-3 / ISO 2811-1)	1.0 kg/l approx.
Viscosity ² (CQP 029-3 / ISO 3219)	15 mPa·s approx.
Flash point (CQP 007-1 / ISO 13736)	-4°C (25°F)
Solid content	30% approx.
Application temperature	5 - 40°C (40 - 105°F)
Application	Brush, felt, foam applicator
Coverage	50 - 150 ml per m ² approx. depending on substrate porosity
Flash-off time ³	above 15°C (60°F) 10 min below 15°C (60°F) 30 min maximum 24 hours
Storage	Store in sealed container in a cool dry place below 25°C (75°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

Description

Sika® Primer-209 D is a black, moisture-curing low viscous primer specifically formulated for the treatment of painted surfaces or plastics prior to application of Sikaflex® PUR adhesives.

Sika® Primer-209 D is manufactured in accordance with ISO 9001 / 14001 quality assurance system and the responsible care program.

Areas of Application

Sika® Primer-209 D is used to improve adhesion on the following substrates:

Paints

Acrylics, alkyds / melamine, powder coatings, baking varnishes

Plastics

Polymethylmethacrylate (PMMA), polycarbonate (PC), polystyrene (PS), glass fibre reinforced polyester (PES-GRP), glass fibre reinforced epoxy resins (EP-GRP), ABS, PVC, etc.

Due to the individual chemical composition of the formulations and specific surface conditions, we recommend to do adhesion tests on the substrates. Always seek the manufacturer's advice before using the primer on thermoplastics that are prone to stress cracking, such as acrylics, polycarbonates or ABS etc.

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 contaminants, such as grease, oil and dust. Apply Sika® Aktivator using the wipe-on, wipe-off method and allow to flash-off. Shake the can of Sika® Primer-209 D very thoroughly until mixing ball rattles freely. Continue shaking for another minute. The primer may be applied with a brush or felt.

Apply Sika® Primer-209 D evenly as a single thin coat.

Ideal application and surface temperature is between 15°C and 25°C (60°F to 75°F).

Consumption and method of application depend on the specific nature of the substrates and manufacturing process. Tightly re-seal container immediately after each use.

Important Note

Prolonged exposure to atmospheric moisture will cause Sika® Primer-209 D to become inactive. Discard any primer that has gelled or separated.

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:

- Material Safety Data Sheet
- Sika Pre-treatment Chart

Packaging Information

Can	250 ml
-----	--------

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, storage and disposal of chemical products, users shall refer to the actual Material 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 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 Technical Data Sheet for the product concerned, copies of which will be supplied on request.

**Sika (Thailand) Limited**

Head Office
700/37 Moo 5 Bangpakong Industrial Park II,
Km.57 Bangna-Trad Rd., T. Klongtamhru,
Muang District, Cholburi 20000

Tel : +66 3821 4270-85
Fax : +66 3821 4286
E-mail : sikathai@th.sika.com
website : <http://www.sika.co.th>

Sika® Primer -209 D 2/2

