

## PRODUCT DATA SHEET

## Sika® Primer-215

NON-PIGMENTED, SOLVENT-BASED PRIMER FOR PLASTICS AND WOOD

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

<b>Chemical base</b>	Solvent-based Polyurethane solution						
<b>Color (CQP001-1)</b>	Colorless, slightly yellow						
<b>Solid content</b>	34 %						
<b>Application temperature</b>	5 – 40 °C						
<b>Application method</b>	Brush, felt or foam applicator						
<b>Consumption</b>	depending to substrate porosity 50 g/m <sup>2</sup>						
<b>Flash-off time</b>	<table border="0"> <tr> <td>≥ 15 °C</td> <td>30 minutes<sup>A</sup></td> </tr> <tr> <td>&lt; 15 °C</td> <td>60 minutes<sup>A</sup></td> </tr> <tr> <td>maximum</td> <td>24 hours<sup>A</sup></td> </tr> </table>	≥ 15 °C	30 minutes <sup>A</sup>	< 15 °C	60 minutes <sup>A</sup>	maximum	24 hours <sup>A</sup>
≥ 15 °C	30 minutes <sup>A</sup>						
< 15 °C	60 minutes <sup>A</sup>						
maximum	24 hours <sup>A</sup>						
<b>Shelf life</b>	12 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

**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

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### PRODUCT DATA SHEET

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