Product Data Sheet
02/2012

Sika® Primer-215

Industry

Technical Product Data:

Chemical base	Solvent-based adhesion promoter
Colour	Colourless, slightly yellow
Density (CQP[1] 006-3 / ISO 2811-1)	1.0 kg/l approx.
Viscosity[2] (CQP 029-3 / ISO 3219)	20 mPas approx.
Flash point (CQP 007-1 / ISO 13736)	-4°C
Solids content	34%
Application temperature	5-40°C
Application method	Brush, felt or foam applicator
Coverage	50-150 g per m^2 approx. according to substrate porosity
Flash-off time[3] above 15˚C	30 min
below 15˚C	60 min.
maximum	24 hours
Storage	Store in sealed container in a cool dry place below 25ºC
Shelf life	9 months

[1] CQP = Corporate Quality Procedure
[2] 23˚C / 50% r.h.
[3] In specific applications temperature and flash-off time may be different

Description:

Sika® Primer-215 is a transparent, pale yellow, low viscosity liquid that cures by reaction with atmospheric moisture. It is used to prime various plastics, timber and other porous materials prior to bonding with Sikaflex® products.
Sika® Primer-215 is manufactured in accordance with the ISO 9001/14001 quality assurance system and responsible care programme.

Areas of application:

Sika® Primer-215 is suitable for application to the following substrates: plastics such as GRP, epoxy resins, PVC, ABS and timber. Because plastics vary so much in their chemical composition, preliminary trials are necessary. This product must not be used on plastics that are prone to stress cracking, such as acrylics or polycarbonates.
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 grease, oil and dust. Wipe the bond face with Sika® Aktivator-205 and allow to dry. Apply a thin but covering coat of Sika® Primer-215 with a brush or felt pad. Sika® Primer-215 should be applied once only. Care must be taken to ensure that this single application gives adequately dense coverage.
Ideal application and surface temperature is between 15ºC and 25ºC.
Tightly re-seal container immediately after each use.

Important note:

Sika® Primer-215 should be used within one month of opening the can.
Discard any primer that increased significantly in viscosity or has 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:

- Sika Pre-treatment Chart
- Material Safety Data Sheet

Packaging information:

Can	250 ml
	1000 ml

Value Bases

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

Health and Safety Information:

For information and advice on the safe handling, storage and disposal of chemical products, users should refer to the current Material Safety Data Sheet containing physical, ecological, toxicological and other safety-related data.

Note:

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