

## Product Data Sheet

Version 08/2009 (08/2012)

**Sika® Primer-210****Technical Data**

Chemical Base	Solvent-based adhesion promoter
Colour	Colourless (slightly yellow)
Density (CQP 006-3/ISO 2811-1)	0.98 kg/L approx
Viscosity <sup>1</sup> (CQP 029-3/ISO 3219)	10 mPa.s approx
Flash Point (CQP 007-1/ISO13736)	-4°C
Solids Content	34%
Application Temperature	5°C to 40°C
Application	Brush, felt or foam applicator
Coverage	50 to 150 ml/m <sup>2</sup> approx depending on substrate porosity
Flash-Off Time <sup>1/2</sup>	above 15°C 10 minutes below 15°C 30 minutes maximum 24 hours
Storage	Store in sealed container in a cool, dry place below 25°C
Shelf Life	9 months
CQP = Corporate Quality Procedure <sup>1</sup> 23°C and 50% Relative Humidity <sup>2</sup> In specific applications, temperature and flash-off time may be different.	

**Description**

Sika® Primer-210 is a low viscosity adhesion promoter designed to improve adhesion of Sikaflex® products on various substrates. Sika® Primer-210 is manufactured in accordance with ISO 9001 and ISO14001 Quality Assurance Systems.

**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. Testing with actual substrates and conditions has to be performed to ensure adhesion and material compatibility.

**Method of Application**

Surfaces must be clean, dry and free from grease, oil and dust. Pre-treat the bond face of non-porous substrates with Sika® Aktivator-205 and leave to dry. Apply a thin but covering coat of Sika® Primer-210 with a brush, felt or foam applicator. Do not apply more than one coat. Care must be taken to ensure that this single application gives adequately dense coverage. Sika® Primer-210 exhibits thermoplastic behaviour for up to 3 days following application. Ideal application and surface temperature is between 15°C and 25°C. 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**

Discard any primer that has gelled (its viscosity will have markedly increased), separated or is not homogeneous.

**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 upon request: Material Safety Data Sheet and Sika Pre-Treatment Chart.

**Packaging**

6 x 250 ml Tins  
4 x 1 litre Tins



# Industry

**Value Bases**

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

**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 for the appropriate type of substance. All Product Data Sheets and Material Safety Data Sheets are available on our website at: [www.sika.ca](http://www.sika.ca) or via your local Sika representative.



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, within their shelf life. 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 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 Product Data Sheet for the product concerned, copies of which will be supplied on request or can be accessed in the Internet under [www.sika.ca](http://www.sika.ca).

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