

# Sika® Primer-215

## Technical Product Data

Chemical base	Solvent-based polyurethane compound
Colour	Transparent with a yellow tint
Density (CQP <sup>1</sup> 006-3 / ISO 2811-1)	1.0 kg/l approx.
Viscosity <sup>2</sup> (CQP 029-3 / ISO 3219)	20 mPa·s approx.
Flash point (CQP 007-1 / ISO 13736)	-4°C (25°F)
Solid content	34%
Application temperature	10 - 35°C (50 - 95°F)
Application method	Brush or felt
Coverage	50 - 150 g per m <sup>2</sup> approx. according to substrate porosity
Flash-off time <sup>3</sup>	below 15°C (60°F) 60 min above 15°C (60°F) 30 min maximum 24 hours
Storage	Store in sealed container in a cool dry place
Shelf life	12 months

<sup>1</sup> CQP= Corporate Quality Procedures

<sup>2</sup> 23°C (73°F) / 50% r.h.

<sup>3</sup> In specific applications, temperature and drying 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 ISO 9001 / 14001 quality assurance system and the responsible care program.

### 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® Cleaner-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.

Do not apply at temperatures below 10°C or above 35°C.

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 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:

- Material Safety Data Sheets
- Sika Pre-treatment Chart

## Packaging Information

Can	30 ml
	250 ml
	1 l

## 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 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.

Further information available at:  
[www.sika.ca](http://www.sika.ca)

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The Sika logo consists of the word "Sika" in a bold, yellow, sans-serif font, with a registered trademark symbol (®) to its right. The logo is set against a red triangular background.