



PRODUCT DATA SHEET

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ELASTOMERIC JOINT SEALANTS

Sika® Duoflex® Primer-5050

ADHESION-PROMOTING, EPOXY PRIMER FOR USE WITH Sika® Duoflex® POLYSULPHIDE SEALANTS

Description	Sika® Duoflex® Primer-5050 is a two-component, low-viscosity, adhesion-promoting epoxy primer for Sika® Duoflex® polysulphide sealants.
Where to Use	To promote adhesion to porous and dense substrates, including concrete and metal, prior to installing Sika® Duoflex® NS/SL.
Advantages	<ul style="list-style-type: none"> ▪ Two-component 1:1 volume ratio; simply combine and mix. ▪ Low viscosity; easy to apply by brush. ▪ Fast drying time; allowing earlier sealing. ▪ Minimizes downtime; quicker use of joint. ▪ Maximizes adhesion; enhances durability ▪ Low VOC contents; contributes to LEED® Canada credits.

Technical Data

Packaging	946 ml (1 US qt) unit						
Colour	<table border="0"> <tr> <td>Part A (Resin)</td> <td>Clear</td> </tr> <tr> <td>Part B (Hardener)</td> <td>Amber</td> </tr> <tr> <td>Mixed</td> <td>Light Amber</td> </tr> </table>	Part A (Resin)	Clear	Part B (Hardener)	Amber	Mixed	Light Amber
Part A (Resin)	Clear						
Part B (Hardener)	Amber						
Mixed	Light Amber						
Yield	Concrete: 210 – 240 lin. m/unit (700 – 800 lin. ft/unit) as 3-5 mils coat Steel: 335 – 395 lin. m/unit (1100 – 1300 lin. ft/unit) as 2-3 mils coat						
Shelf Life	1 year in original, unopened packaging. Store dry between 18 and 27 °C (65 and 80 °F).						

Application Temperature

Ambient	5 to 35 °C (40 to 95 °F)
Substrate	5 °C (41 °F) above dew point
Mix Ratio	1:1 by volume

Properties at 25 °C (77 °F) and 50 % R.H.

Volume Solids	65 %
Pot Life	3 hours
Waiting Time before Sealing	
Concrete	Min. 2 hours / Max. 36 hours
Steel	Min. 4 hours / Max. 36 hours
VOC Content	50 g/L

Note: Material cures more slowly at cooler temperatures, and working time will be substantially reduced at higher temperatures. In hot weather, material should be cooled to between 18 and 27 °C (65 and 80 °F) prior to mixing and application to improve workability and avoid shortened pot life.
Product properties are typically averages, obtained under laboratory conditions. Reasonable variations can be expected on-site due to local factors, including environment, preparation, application, curing and test methods.

HOW TO USE

Surface Preparation

Concrete: Apply only to clean, dry and sound substrates that are free of all coatings, sealers, curing compounds, oils, greases or any other contaminants which would impede penetration or adhesion. All surface irregularities, including cracks or substrate details, such as expansion joints and control joints, should be properly addressed prior to application. New concrete should be cured a minimum of 28 days with laitance and any weak surface layers removed.

Concrete that has been contaminated with chemicals or other foreign matter must be neutralized or removed.

Concrete should have a minimum surface tensile strength of at least 2 MPa (300 psi) as per ASTM D4541 and a surface profile of CSP 3-5 (a profile equal to 60-grit sandpaper, or coarser) in accordance with the International Concrete Repair Institute (ICRI) standard guideline #03732 for coating concrete. Prepare surface by mechanical means to achieve this desired profile.

Concrete surfaces potentially subject to out-gassing should be primed when the temperature of the substrate is dropping. Alternatively, double priming will greatly reduce the effects of out-gassing by additionally filling the pores in the concrete.

Steel: For service in an immersed environment, abrasive blast with an anchor profile of 2 - 4 mils in accordance with Steel Structures Painting Council Specification SP-5-63 or NACE No. 1, to achieve a "White Metal" finish. For splash and spillage exposure, "Near White" SP-10-63 or NACE No. 2 is required.

Mixing	<p>Individually stir the contents of each component of Sika® Duoflex Primer-5050 until a uniform consistency and colour has been produced in each.</p> <p>Pour contents of Component B (Hardener) into the container in which Component A (Resin) is held and thoroughly mix by hand using a clean pallette/flat knife or similar for a minimum of two (2) minutes until the blended liquid is of a consistent colour (no streaking) and uniform consistency.</p> <p>Note: When initially pouring Component B (Hardener) into Component A (Resin), ensure all hardener is emptied from the container into the resin.</p> <p>While mixing, use a suitable tool to scrape the side and bottom of the container in which the blended resin and hardener are held to ensure the entire product has been properly mixed. Any unmixed material will not cure and will potentially cause the subsequent installation of Sika® Duoflex® NS/SL sealants to fail.</p>
Application	<p>Apply Sika® Duoflex® Primer-5050 by brush at approximately 210 - 240 lin. m/unit (700 - 800 lin. ft/unit) as 3-5 mils coat onto concrete and 335 - 395 lin. m/unit (1100 - 1300 lin. ft/unit) as 2-3 mils coat onto steel.</p> <p>Sika® Duoflex® Primer-5050 must be dry to the touch, following a drying time of typically 2 hours at 25 °C (77 °F) on concrete and 4 hours at 25 °C (77 °F) on steel. Do not allow the waiting time to exceed 36 hours before proceeding with the installation of Sika® Duoflex® NS/SL sealants. Where the maximum waiting time is exceeded, do not seal but contact Sika Canada Inc, Technical Services for guidance.</p> <p>Note: Observe the above waiting times after priming and before installation of the sealant. Installation of the sealant too soon or too late will jeopardize the adhesion and performance of Sika® Duoflex® NS/SL.</p>
Clean Up	<p>For best results, clean tools and equipment with Sika® Epoxy Cleaner, a non-flammable and non-evaporating cleaner. Always wear gloves when using this product.</p>
Limitations	<ul style="list-style-type: none"> ▪ Do not thin with solvents unless advised to do so by Sika Canada. ▪ Confirm with Sika Canada that the product is suitable for specific chemical environments, prior to use. ▪ Prepare substrate according to "Surface Preparation" portion of this document. ▪ Minimum application temperature of 5 °C above dew point must be observed; do not apply onto damp surfaces. ▪ Moisture content of substrates must be < 4 % (Tramex meter reading) and vapour transmission should be 3 pounds or less per 1000 square feet over 24 hours as confirmed through appropriate ASTM testing and quantitative relative humidity (RH) testing should confirm concrete RH results of < 75 %. ▪ For industrial and commercial use only; to be handled by experienced or trained personnel only. ▪ For use only with Sika® Duoflex® sealants, as supplied by Sika Canada Inc.
Health and Safety Information	<p>For information and advice on the safe handling, storage and disposal of chemical products, users should refer to the most recent SAFETY DATA SHEET containing physical, ecological, toxicological and other safety-related data.</p>

KEEP OUT OF REACH OF CHILDREN
FOR INDUSTRIAL USE ONLY

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 shelflife. 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 information contained herein does not relieve the user of the products from testing them for the intended application and purpose. 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 or may be downloaded from our website at: www.sika.ca

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