



Primer Selection Guide



Revised June 2008

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| Description | | Sika Primers are required on substrate where maximum adhesion is required for Sikaflex Sealants and Adhesives. Not all joints or fillets require priming and the following notes should be used as a reference "guide" only for what substrates require priming. If in doubt, always contact our Technical Department. |
| Primer Types | | |
| | SA | <p>Sika Aktivator</p> <p>a) Wipe bond faces with a clean lint- free cloth or absorbent paper towel moistened with Sika Aktivator.</p> <p>b) Wipe off the excess using a clean lint free cloth.</p> <p>Allow a minimum of 10 minutes to dry and a maximum of 24 hours at temperature over 15° C or minimum of 30 min to 24 h at temperatures below 15° C.</p> |
| | 205 | <p>Sika Cleaner 205 (Adhesive Promoter)</p> <p>Apply very thinly with clean polishing cloth or tissue NOT a brush. Change cloth frequently. Allow a minimum of 10 minutes to dry and a maximum of 24 hours.</p> |
| | SP 1 | <p>Sika Primer 1 - Dry Concrete</p> <p>Apply Sika Primer 1 in a thin coat to the prepared surface by brush. Allow the primer to dry for at least one hour but not longer than 5 hours before placing the sealant. If ventilation is poor eg. joints are narrow - wait 2 hours before applying sealant.</p> |
| | SP 3 | <p>Sika Primer 3N - Damp concrete & Metal</p> <p>Apply Sika Primer 3 in a thin coat to the prepared surface by brush. Allow the primer to dry for at least 30 minutes but not longer than 8 hours before placing the sealant. If ventilation is poor eg. joints are narrow - wait 1 hour before applying the sealant.</p> |
| | 206 G+P | <p>Sika Primer 206 G + P</p> <p>a) Shake the can of Sika Primer 206 G+P very thoroughly until the paint mixing ball is heard to rattle freely.</p> <p>b) The primer may be applied with a brush, primer applicator or other suitable implement.</p> <p>Apply sparingly: a single thin coat of Sika Primer 206 G+P is sufficient. Re-seal container tightly immediately after use. Allow primer to dry at least 20 min but not longer than 24 hours before placing sealant.</p> |
| | 209 | <p>Sika Primer 209</p> <p>Shake thoroughly to ensure all black pigment is dispersed. Apply a moderate coat and allow 20 minutes to dry. Do not spray apply. Repeat coats until film is opaque to bright sunlight. Apply sealant within 24 hours.</p> |
| | 210T | <p>Sika Primer 210T</p> <p>Apply by brush in a thin coat to the prepared surface. Allow the primer to dry for at least 30 minutes for non-porous substrates or 60 minutes for porous mineral substrates, but no longer than 24 hours before application of sealants.</p> |
| | 290DC/215 | <p>Sika Primer 290DC/215</p> <p>For Timber:</p> <p>a) Thoroughly de-oil timber surface with Acetone or Thinner C. Apply a thin coat with a clean brush. Ideally apply when substrate temperature is falling. Allow a minimum of 60 minutes before applying sealant and a maximum of 24 hours.</p> <p>For PVC & ABS:</p> <p>For plastic substrates allow to dry for a minimum of 30 minutes and a maximum of 24 hours before applying sealant.</p> |
| | SB | Scotch-Brite (Very Fine Grade) sanding material. Generally used to remove oxide from steel as well as to increase bonding surface area. |

| Substrate Classification | Include: | Description |
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| Metals | Aluminium, Stainless Steel, Galvanised Steel, Copper, Brass, Steel | Metals are reactive materials which oxidize on exposure to air. Hence it is necessary to apply abrasion to the surfaces to remove the oxide layer before pretreatment. Sika Primers do not provide corrosion protection to metals. Where corrosion protection is a critical requirement, we recommend to contact our Technical Service department. |
| Mineral glass | | For ceramic banded glass we recommend applying Sika Activator. If ceramic band is not used, we recommend UV shielding tape to protect the adhesive. |
| Fibreglass | Gel Coated and Raw GRP | These materials consist for the most part of thermosetting plastics derived from unsaturated polyesters, epoxy resin or polyurethane. Surfaces may contain release agent, hence it is necessary to abrade the surface thoroughly before priming. |
| Fibre Cement Panels | MDF panels, etc | Fibre cement is a pre-fabricated product which is commonly used in construction of external as well as internal walls. Fibre cement panels generally have low moisture content. Make sure surface is free of dust or any other impurity that may affect adhesion properties. |
| Concrete | Concrete, Besser block, light-weight block, claybrick, ceramic tiles, sandstones, epoxy mortar. | The most common construction materials in the market. Generally have medium to high moisture content. Surface must be clean and sound before any application of primer. |
| Timber | Untreated hardwood, untreated softwood corks, particle board. | Timbers generally have high moisture content and it is considered a porous material. Two coats of primer may be required for highly absorbent timber. |
| PVC/ABS | | Most PVC and ABS have some surface oil from the manufacturing process, hence it is necessary to remove the surface impurity by abrasion. |
| Paints | Epoxy paints, polyurethane paints | Preliminary trials are necessary before attempting to bond substrate. As a general rule, reactive systems that cure thermally or by addition polymerization can be successfully bonded with Sikaflex® products with the correct surface pre-treatment. |
| PMMA and Acrylics | | Sikaflex 222 UV or Sikaflex 295 UV should be used in conjunction with UV shielding tape with this type of material. |
| Unusual Substrates | | Please contact our Technical Department for advice and laboratory testing. |

Note: 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 the normal conditions. In practice, the differences in materials, substrates and actual site conditions a result 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 proprietary rights of third parties must be observed. All orders are accepted subject to our current terms and conditions of sale. Users should always refer to the most recent issue of the Technical Data Sheet for the product concerned, copies of which will be supplied on request. PLEASE CONSULT OUR TECHNICAL DEPARTMENT FOR FURTHER INFORMATION.

1 Sika Cleaner-205

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| Product Description | 1-comp. cleaner with adhesion promoters, transparent |
| Application Method | Cloth or absorbent paper towel. Apply very thinly turn cloth several times to ensure that dirt is not spread. |
| Description/Technical Data | Transparent alkyl titanate in an alcohol situation; Density 0.08kg/l (ISO 2811 -1) |
| Uses | To clean and activate the following non-porous substrates: metals, plastics, glazed ceramics, painted surfaces |
| Flash off Time | 15 min to 6 hrs |
| Yield per Litre | 9-18 m ² |
| Running Meter Joint Per Litre | 300-400 m |
| Container Content | 250 ml, 1 Ltr |
| Shelf Life Store in sealed container in a cool dry place | 12 month |

2 Sika Primer-3 N

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| Product Description | 1-comp. primer, transparent |
| Application Method | Brush |
| Description/Technical Data | Transparent solvent based reactive epoxy resin compound, Density 0.98kg/l (ISO 2811 -1) |
| Uses | To slightly damp or dry, porous, absorbent materials and metals. |
| Flash off Time | minimum 30 min, maximum 8 hrs |
| Yield per Litre | On porous substrates 5 m ² On metals 8 m ² |
| Running Meter Joint Per Litre | On porous substrates 220 - 300m On metals 400m |
| Container Content | 250 ml, 1 Ltr |
| Shelf Life Store in sealed container in a cool dry place | 9 months |

3 Sika Primer-215

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| Product Description | 1-comp. primer, transparent |
| Application Method | Brush |
| Description/Technical Data | Transparent with a yellowish tint solvent based polyurethane reactive primer Density 1.0kg/l (ISO 2811 -1) |
| Uses | To plastics, varnishes, lacquers and porous, absorbent materials. Preferred for joints around windows where a variety of materials are encountered. |
| Flash off Time | minimum 30 min, maximum 8 hrs |
| Yield per Litre | 8 m ² |
| Running Meter Joint Per Litre | 300m |
| Container Content | 250 ml, 1 Ltr |
| Shelf Life Store in sealed container in a cool dry place | 9 months |

4 Sika Primer 206 G + P

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| Product Description | 1-comp. primer, black |
| Application Method | Brush |
| Description/Technical Data | Black pigmented solvent based reactive epoxy resin compound, Density 1.05kg/l (ISO 2811 -1) |
| Uses | Special Primer for adhesives on glass and painted substrates where the primed areas due to the colour have to be easily checked. |
| Flash off Time | minimum 15 min, maximum 8 hrs |
| Yield per Litre | 8 m ² |
| Running Meter Joint Per Litre | 300m |
| Container Content | 250 ml, 1 Ltr |
| Shelf Life Store in sealed container in a cool dry place | 9 months |