

## Sika® Primer-215

### Technical Product Data:

Chemical base	Solvent-based polyurethane compound
Colour	Transparent with a yellowish 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 mPas approx.
Flash point (CQP 007-1 / ISO 13736)	-4°C
Solids content	34% approx.
Application temperature	10-35°C
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 min. above 15°C 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 Procedure

<sup>2)</sup> 23°C / 50% r.h.

<sup>3)</sup> 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® 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.

Industry



**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:**

Copies of the following publications are available on request:

- Sika Primer Chart
- Safety Data Sheet

**Packaging information:**

Can	250 ml, 1000 ml
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**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:**

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 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 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 Australian version of the Technical Data Sheet for the product concerned, copies of which will be supplied on request.



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