

Primer Table

Sikaflex / SikaBond

Descriptions of Sika Primers.

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The information contained herein and any other advice 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. The information only applies to the application(s) and product(s) expressly referred to herein. In case of changes in the parameters of the application, such as changes in substrates etc., or in case of a different application, consult Sika's Technical Service prior to using Sika products. The information contained herein does not relieve the user of the products from testing them for the intended application and purpose. 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.



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1 Sika Cleaner-205

Product Description	1-comp. cleaner with adhesion promoters, transparent
Application Method	Cloth or absorbent paper towel. Apply very thinly turncloth several times to ensure that dirt is not spread.
Description / Technical Data	Transparent alkyl titanate in an alcohol solution; Density 0,80 kg/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 h
Yield per Litre	9 - 18 m ²
Running Meter Joint Per Litre	300 - 400 m
Container Content	250 ml, 1liter
Shelf Life Store in Sealed Container in a Cool Dry Place	12 months

2 Sika Primer-3 N

Product Description	1-comp. primer, transparent
Application Method	Brush
Description / Technical Data	Transparent solvent based reactive epoxy resin compound, Density 0,98 kg/l (ISO 2811-1)
Uses	To slightly damp or dry, porous, absorbent materials and metals.
Flash Off Time*	min. 30 min., max 8 h
Yield per Litre	On porous substrates 5 m ² On metals 8 m ²
Running Meter Joint Per Litre	On porous substrates 220 - 300 m On metals 400 m
Container Content	250 ml 1 litre
Shelf Life Store in Sealed Container in a Cool Dry Place	9 months

3 Sika Primer-215

Product Description	1-comp. primer, transparent
Application Method	Brush
Description / Technical Data	Transparent with a yellowish tint solvent based polyurethane reactive primer, Density 1,0 kg/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*	min. 30 min., max 8 h
Yield per Litre	8 m ²
Running Meter Joint Per Litre	300m
Container Content	250 ml 1 litre
Shelf Life Store in Sealed Container in a Cool Dry Place	9 months

4 SikaTack-Panel Primer

Product Description	1-comp. primer, black
Application Method	Brush
Description / Technical Data	Black pigmented solvent based reactive epoxy resin compound, Density 1,05 kg/l (ISO 2811-1)
Uses	Special Primer for SikaBond adhesives on porous and non porous substrates where the primed areas due to the colour have to be easily checked
Flash Off Time*	min. 15 min., max 8 h
Yield per Litre	8 m ²
Running Meter Joint Per Litre	300m
Container Content	250 ml 1 litre
Shelf Life Store in Sealed Container in a Cool Dry Place	9 months

*flash off' time at Temperatures > +15°C
Application temperature +5°C to +35°C



5 1-Component Polyurethanes and 1-Component Silane-Terminated-Polyurethanes

Substrate	SikaBond Adhesives	Sikaflex Sealants	SikaBond - AT technology	Sikaflex - AT technology
	SB-T1 / -T2	SF PRO / 11 FC	SB AT Range	SF AT Range
Mineral substrates				
Concrete	3N / STPP	3N	3N / STPP	3N
Aerated Concrete, sandstone	3N / STPP	3N	3N / STPP	3N
Granite, clay bricks	3N / STPP	3N	3N / STPP	3N
Plaster, thermally-insulating plaster	-	3N / 215 **	-	3N
Plaster, cement render	-	3N / 215 **	-	3N
Fibre cement (surface only)	3N / STPP	3N	3N / STPP	3N
Glazed tiles	Cleaner-205	Cleaner-205	Cleaner-205	Cleaner-205
Unglazed tiles	3N / STPP	3N	3N / STPP	3N
Enamel	Cleaner-205	Cleaner-205	Cleaner-205	Cleaner-205
Non ferrous metals				
Aluminium uncoated	A + 3N / A + STPP	A + 3N	A+Cleaner-205	A+ Cleaner-205
Aluminium anodised	A + 3N / A + STPP	A + 3N	Cleaner-205	Cleaner-205
Copper	A + 3N / A + STPP	A + 3N	A + 3N SikaBond-T14: Cleaner-205	A + 3N
Titaniumzinc	A + 3N / A + STPP	A + 3N	A + 3N SikaBond-T14: Cleaner-205	A + 3N
Iron / metals				
Structural steel (St 37), uncoated	A + 3N / A + STPP	A + 3 N	A + 3N A + STPP	A + 3N
Steel zinc coated	A + 3N / A + STPP	A + 3 N	A+Cleaner-205	A+Cleaner-205
Stainless steel (V2A, V4A)	A + 3N / A + STPP	A + 3 N	A+Cleaner-205	A+Cleaner-205
Plastics				
Epoxy mortar	A + Cleaner-205	A + Cleaner-205	A+Cleaner-205	A+Cleaner-205
Epoxy coatings	A + Cleaner-205	A + Cleaner-205	A+Cleaner-205	A+Cleaner-205
GRP (based on UP, EP, PU)	A + 215	A + Cleaner-205	A+Cleaner-205	A+Cleaner-205
UPVC	215	215	Cleaner-205	Cleaner-205
Wood not weathered				
Hardwood, untreated	0	0	0	0
Softwood, planed, untreated	0	0	0	0
Plywood	0	0	0	0
Wood weathered				
Hardwood, untreated	3N / STPP	3N	3N / STPP	3N
Plywood	3N / STPP	3N	3N / STPP	3N
Softwood, planed, pressure impregnated or untreated	3N / STPP	3N	3N / STPP	3N
Varnishes / lacquers				
UP- or PU-2-pack varnishes	A + Cleaner-205	A + Cleaner-205	A + Cleaner-205	A + Cleaner-205
Alkyd resin wood stain	A + Cleaner-205	A + Cleaner-205	A + Cleaner-205	A + Cleaner-205
DD-varnishes	A + Cleaner-205	A+Cleaner-205	A + Cleaner-205	A + Cleaner-205
Powder coatings	A + Cleaner-205	A + Cleaner-205	A + Cleaner-205	A + Cleaner-205

* no suitable for long-term water immersion

** SikaPrimer-215 for connection joints between UPVC and Plaster

Abbreviations:

/ or -	Dependent on the requirements. Contact Sika Technical Services Department for advice
0	Application without Primer
-	Select other Sika sealant / adhesives
A	Gently rub down substrate in single pass with abrasive pad and clean with Cleaner-205
Cleaner-205	Prime with Sika Cleaner-205
3 N	Prime with Sika Primer-3 N
215	Prime with Sika Primer-215
STPP	Prime with Sika Tack Panel Primer

GRP = Glass-fibre Reinforced Plastics, UP = Polyester, EP = Epoxy; PU = Polyurethane



6 1-Component Silicone*

Substrate	Sikasil Acetic acid systems	Sikasil Neutral curing
	Sikasil-E / -AC / Sanisil	Sikasil-C / -MP / Firesil-N
Mineral substrates		
Concrete	-	3N*
Aerated Concrete, sandstone	-	3N*
Granite, clay bricks	-	3N*
Plaster, thermally insulating plaster	-	3N*
Plaster, cement render	-	3N*
Fibre cement (surface only)	-	-
Glazed tiles	3N*	3N*
Unglazed tiles	3N*	3N*
Enamel	Cleaner-205	Cleaner-205
Non ferrous metals		
Aluminium uncoated	-	Cleaner-205
Aluminium anodised	-	Cleaner-205
Copper	-	Cleaner-205
Titanium / Zinc	-	Cleaner-205
Iron / metals		
Structural steel (St 3 N 7), uncoated	-	Cleaner-205
Steel zinc coated	-	Cleaner-205
Stainless steel (V2A, V4A)	Cleaner-205	Cleaner-205
Plastics		
Epoxy mortar	A	A
Epoxy coatings	A	A
GRP (based on UP, EP, PU)	A	A
UPVC	Cleaner-205	Cleaner-205
Wood not weathered		
Hardwood, untreated	3N	3N
Softwood, planed, pressure untreated	3N	3N
Plywood	3N	3N
Wood weathered		
Hardwood, untreated	3N	3N
Softwood, planed, pressure Impregnated or untreated	3N	3N
Plywood	3N	3N
Varnishes / lacquers		
UP- or PU-2-pack varnishes	0	0
Alkyd resin wood stain	0	0
DD-varnishes	0	0
Powder coatings	Cleaner-205	Cleaner-205

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Cleaner-205	Prime with Sika Cleaner-205
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215	Prime with Sika Primer-215
STPP	Prime with Sika Tack Panel Primer

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Important Note:

Primers are only adhesion promoters. They neither substitute for the correct cleaning of the surface nor improve their strength significantly. Primers improve long term performance of a sealed joint / bonded joint.

Bonding surfaces must be cleaned prior to application of primer.

For absorbent substrates (concrete, wood) - Dry cleaning (free from dust and other loose or friable particles)

For non-absorbent substrates (metals etc.) - Damp cleaning (e.g. using, Sika ColmaCleaner)

For rubbing down we recommend Scotch Brite abrasive pads very fine

For optimum adhesion and critical, high performance applications such as multi story building work, for high stress bonding joints or in case of extreme weather exposure substrate primers and cleaners must be used. If in doubt apply product in test area first.



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