

PRODUCT DATA SHEET

Sika® Primer-215

Non-pigmented, solvent-based primer for plastics and wood

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base	Solvent-based Polyurethane solution
Color (CQP001-1)	Colorless, slightly yellow
Solid content	34 %
Application temperature	5 – 40 °C (41 – 104 °F)
Application method	Brush, felt or foam applicator
Consumption	depending to substrate porosity 50 g/m ²
Flash-off time	≥ 15 °C (59 °F) 30 minutes ^A < 15 °C (59 °F) 60 minutes ^A maximum 24 hours ^A
Shelf life	12 months ^B

CQP = Corporate Quality Procedure ^{A)} for specific application, temperature and flash-off time may be different
^{B)} stored in sealed container in up-right position in a dry place at ≤ 25 °C (77 °F)

DESCRIPTION

Sika® Primer-215 is a solvent-based colorless to slightly yellow primer, which reacts with moisture and forms a thin layer. This layer acts as a link between substrates and adhesives.

Sika® Primer-215 is specifically formulated for the treatment of bond faces prior to application of Sika's 1-component Polyurethanes.

AREAS OF APPLICATION

Sika® Primer-215 is used to improve adhesion on many plastics and wood such as GRP, epoxy resins, PVC, ABS and timber.

Due to the wide variety of plastics it is mandatory to perform preliminary tests on original substrates under production conditions.

Seek manufacturer's advice and perform tests on original substrates before using Sika® Primer-215 on materials prone to stress cracking.

This product is suitable for experienced professional users only. Tests 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, dust and contaminants.

Adhesion on substrates might be improved by adding and/or combining pre-treatment processes such as scuffing, cleaning and activating prior the primer application.

Application

Apply a thin but covering coat of Sika® Primer-215 with a brush, felt or foam applicator.

Ideal application and surface temperature is between 15 °C and 25 °C (59 °F and 77 °F).

Sika® Primer-215 has to be applied once only. Care must be taken to ensure that this single application gives adequately dense coverage. Consumption and method of application depend on the specific nature of the substrates. Tightly reseal container immediately after each use.

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Version 02.01 (03 - 2023), en_US

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IMPORTANT NOTE

Sika® Primer-215 is a moisture reactive system. In order to maintain product quality it is important to reseal the container with the inner plastic liner immediately after use. Once the surface pre-treatment operation is completed, the cap has to be screwed on.

Dispose of product approx. one month after opening if used frequently or after two months in case of infrequent use.

If gelling, separation or a significant increase in viscosity is noted, discard the primer immediately.

Never dilute or mix this product with any other substances.

If used on transparent or translucent substrates such as plastics, etc., an adequate UV protection is mandatory.

FURTHER INFORMATION

The information herein is offered for general guidance only. Advice on specific applications is available on request from the Technical Department of Sika Industry.

Copies of the following publications are available on request:

- Safety Data Sheets

PACKAGING INFORMATION

Can	250 ml
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BASIS OF PRODUCT DATA

All technical data stated in this document are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

ENVIRONMENTAL, HEALTH AND SAFETY

For further information and advice regarding transportation, handling, storage and disposal of chemical products, user should refer to the actual Safety Data Sheets containing physical, environmental, toxicological and other safety related data. User must read the current actual Safety Data Sheets before using any products. In case of an emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

LEGAL DISCLAIMER

Prior to each use of any product of Sika Corporation, its subsidiaries or affiliates ("SIKA"), the user must always read and follow the warnings and instructions on the product's most current product label, Product Data Sheet and Safety Data Sheet which are available at usa.sika.com or by contacting SIKA's Technical Service Department via email at tsmh@us.sika.com. Nothing contained in any SIKA literature or materials relieves the user of the obligation to read and follow the warnings and instructions for each SIKA product as set forth in the current product label, Product Data Sheet and Safety Data Sheet prior to use of the SIKA product.

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within the product's shelf life. User determines suitability of product for intended use and assumes all risks. User's and/or buyer's sole remedy shall be limited to the purchase price or replacement of this product exclusive of any labor costs. **NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS.** Sale of SIKA products are subject to the Terms and Conditions of Sale which are available at <https://usa.sika.com/en/group/SikaCorp/termsandconditions.html> or by calling +1 800-933-7452.

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