

PRODUCT DATA SHEET

Sika® Primer-541 M

(formerly M(M-300), M(RC-50E))

Pigmented, solvent-based Primer for paints or plastics

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base	Solvent-based polyurethane solution
Color (CQP001-1)	Black
Solid content (JASO M338-89)	24 %
Viscosity (JASO M338-89)	(#4 Ford cup) 11 seconds
Application temperature	5 – 40 °C
Application method	Brush
Flash-off time	above 5 °C 2 minutes maximum 8 hours ^A
Shelf life	depending on the packaging 6 – 9 months

CQP = Corporate Quality Procedure ^{A)} in specific application, temperature and flash-off time may be different

DESCRIPTION

Sika® Primer-541 M is a solvent-based black primer, which reacts with moisture and forms a thin layer. This layer acts as a link between substrates and adhesives.

Sika® Primer-541 M is specifically formulated for the treatment of bond faces prior to application of Sika's 1-component polyurethanes. The primer might provide adhesion without previous activation step on many substrates.

PRODUCT BENEFITS

- One-step application
- Very good adhesion to paints or plastics
- Easy to use

AREAS OF APPLICATION

Sika® Primer-541 M is used to improve adhesion on different substrates such as paints or plastics.

Seek manufacturer's advice and perform tests on original substrates before using Sika® Primer-541 M 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 ensuring adhesion and material compatibility.

METHOD OF APPLICATION

Preparation

Surfaces must be clean, dry and free from grease, oil, dust and contaminants.

Adhesion on substrates may be improved by adding and/or combining pre-treatment processes such as scuffing, cleaning and activating.

Application

Shake the Sika® Primer-541 M container thoroughly before use. Use a shaker (40 mm amplitude, 300 rpm) for at least 10 minutes, or shake vigorously by hand (5 Hz) for at least 60 seconds.

Apply a thin, uniform, and continuous coat using a soft brush.

Sika® Primer-541 M must be applied once only. Care must be taken to ensure that this single application gives adequately dense coverage. Consumption and method of application depends on the specific nature of the substrates. Tightly reseal container immediately after each use.

IMPORTANT NOTE

Sika® Primer-541 M 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.

If the container remains open for more than 2 hours, the product must be discarded. If the primer is used and the container is resealed after opening, the remaining primer must be disposed of within 24 hours.

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 float glass, plastics, etc., an adequate UV protection is mandatory.

STORAGE CONDITIONS

Sika® Primer-541 M must be stored in sealed container, in an up-right position at temperature $\leq 10^{\circ}\text{C}$ in a dry place. Do not expose it to direct sunlight.

After opening of the packaging, the content has to be protected against humidity.

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	800 grams
Pail	5 gal (US)

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.

PRODUCT DATA SHEET

Sika® Primer-541 M
Version 02.01 (06 - 2026), en_US
014761013330243613

Sika Corporation
30800 Stephenson Highway
Madison Heights, MI 48071
U.S.A.
Telephone: +1 248-577-0020
Email: tsmh@us.sika.com
www.sikausa.com

