

# Sika® Primer-215

## One-component polyurethane

### Technical Product Data (typical values)

Chemical base	Solvent-based polyurethane compound
Color	Transparent with a slightly yellowish tint
Density (uncured)	8.3 lb/gal
VOC (EPA Method 24)	5.3 lb/gal
Viscosity	20 cps
Flash point	25 °F (-4 °C)
Solid content	34%
Application temperature	product 50 °F to 95 °F (+10 °C to +35 °C)
Application method	Brush or dauber
Coverage	0.16 - 0.48 oz/ft <sup>2</sup> , depending on substrate porosity
Drying time <sup>1</sup>	30 minutes to 24 hours <sup>2</sup>
Storage	Store in sealed container in a cool dry place
Shelf life (storage below 80 °F (27 °C))	12 months

1) 73F/50%RH. 2) In specific applications dry times may different

### Description

Sika® Primer-215 is a transparent, pale yellow liquid of low viscosity that dries by reaction with atmospheric moisture. It is used to prime various plastics, timber and other porous materials prior to bonding with Sika® products. Sika® Primer-215 is manufactured in accordance with ISO 9001 / 14001 quality assurance system and with the Responsible Care Program.

### Product Benefits

- One Component
- Fast Drying

### Areas of Application

Sika® Primer-215 is suitable for application to the following substrates: plastics such as GRP, epoxy resins, PVC, ABS, various non-metallic substrates, FRP, plywood, timber and wooden fixtures. 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. Tests with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

Industry



## Method of Application

Apply a thin but covering coat of Sika® Primer-215 with a brush or dauber. Do not apply at temperatures below 50°F or above 95°F. For application at lower or higher temperatures, consult with Sika Technical Service at 1-888-832-7452. Allow primer to dry for a minimum of 30 minutes at 73°F and 50% relative humidity. Ambient temperature and substrate porosity affect drying time. Surface should be tack-free before Sikaflex® application. For best results, apply Sikaflex® within two hours after priming. Avoid repriming. Sika® Primer-215 should be applied once only. Care must be taken to ensure that this single application gives adequately dense coverage. Reseal container tightly immediately after use.

## Important Note

Discard any Sika® Primer-215 that has gelled or separated, or if it gets limp.

## Limitations

Because paints and plastics vary in their chemical composition, preliminary trials are necessary.

- Do not apply on frozen surfaces or through standing water.
- Do not apply over silicones or in the presence of curing silicones.
- Avoid contact with alcohol and solvents containing alcohol during cure.

## CAUTION:

**Flammable; Irritant, Sensitizer, CNS Effects:** Contains ethyl acetate, methyl ethyl ketone, polyisocyanate prepolymers and adducts. Flammable liquid. May cause skin/eye/respiratory irritation. May cause skin sensitization after prolonged or repeated contact. Avoid contact. May cause headaches, dizziness, or other CNS effects. Use only with adequate ventilation. Use of safety goggles and chemical resistant gloves is recommended. In case of

exceedance of PEL's, use an appropriate, properly fitted NIOSH/MHSA approved respirator. Remove contaminated clothing. Keep away from heat, sparks and open flame.

## HMIS

Health	*2
Flammability	3
Reactivity	0
Personal Protection	D

## First Aid

In case of skin contact, wash immediately and thoroughly with soap and water. In case of eye contact, rinse eyes immediately with plenty of water for at least 15 minutes, contact a physician. For respiratory problems, remove person to fresh air; if symptoms persist, contact a physician. In case of ingestion, consult physician immediately. Remove contaminated clothing.

## Further Information

Copies of the following publications are available on our website [www.sikaindustry.com](http://www.sikaindustry.com):

- Material Safety Data Sheets
- Product Data Sheet
- Sika Primer Chart
- General guidelines for bonding and sealing with Sika products

## In case of emergency call:

**Chemtec: 800-424-9300**  
**International: 703-527-3887**

For further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Material Safety Data Sheets containing physical, ecological, toxicological and other safety related data. It is highly recommended to read the actual Material Safety Data Sheet before using the product.

- KEEP OUT OF REACH OF CHILDREN**
- NOT FOR INTERNAL CONSUMPTION**
- FOR INDUSTRIAL USE ONLY**
- KEEP CONTAINER TIGHTLY CLOSED**

## Packaging Information

Can	250 ml; 6 per carton
Can	30 ml; 24 per carton

## Value Basis

All technical data stated on this Product Data Sheet are based on the results of laboratory tests only. Actual measured data in the field may vary due to site specific conditions which are not known to Sika and beyond our control.

## Clean Up

In case of spills or leaks, wear suitable protective equipment, eliminate sources of ignition, collect with absorbent material, and transfer to suitable container. Ventilate area. Avoid contact. Dispose of in accordance with current, applicable local, state and federal regulations.

## Limited Material Warranty

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 shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. **NO OTHER WARRANTIES IMPLIED OR EXPRESS 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.**

Further information available at:  
[www.sikaindustry.com](http://www.sikaindustry.com)

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## Legal Notes/Disclaimer

All information provided by Sika Corporation ("Sika") concerning Sika products, including but not limited to, any recommendations and advice relating to the application and use of Sika products, is given in good faith based on Sika's current experience and knowledge of its products when properly stored, handled and applied under normal conditions in accordance with Sika's instructions. In practice, the differences in materials, substrates, storage and handling conditions, actual site conditions and other factors outside of Sika's control are such that Sika assumes no liability for the provision of such information, advice, recommendations or instructions related to its products, nor shall any legal relationship be created by or arise from the provision of such information, advice, recommendations or instructions related to its products. The user of the Sika product(s) must test the product(s) for suitability for the intended application and purpose before proceeding with the full application of the product(s).

Sika reserves the right to change the properties of its products without notice. All sales of Sika product(s) are subject to its current terms and conditions of sale which are available at [www.sikacorp.com](http://www.sikacorp.com) or by calling 201-933-8800.

Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, product label and Material Safety Data Sheet which are available at [www.sikaindustry.com](http://www.sikaindustry.com). Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Product Data Sheet, product label and Material Safety Data Sheet prior to product use.

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