

# Sika® Primer-210

## Technical Product Data

Chemical base	Solvent-based adhesion promoter
Colour	Colourless, slightly yellow
Density (CQP <sup>1</sup> 006-3 / ISO 2811-1)	1.0 kg/l approx.
Viscosity <sup>2</sup> (CQP 029-3 / ISO 3219)	10 mPa·s approx.
Flash point (CQP 007-1 / ISO 13736)	-4°C (25°F)
Solid content	34%
Application temperature	5 - 40°C (40 - 105°F)
Application	Brush, felt or foam applicator
Coverage	50 - 150 ml/m <sup>2</sup> approx. depending on substrate porosity
Flash-off time <sup>2/3</sup>	above 15°C (60°F) 10 min below 15°C (60°F) 30 min maximum 24 hours
Storage	Store in sealed container in a cool, dry place below 25°C (77°F)
Shelf life	9 months

<sup>1)</sup> CQP = Corporate Quality Procedure

<sup>2)</sup> 23°C (73°F) / 50% r.h.

<sup>3)</sup> In specific applications temperature and flash-off time may be different

### Description

Sika® Primer-210 is a low viscosity liquid primer to improve adhesion of Sikaflex® products on various substrates. Sika® Primer-210 is manufactured in accordance with ISO 9001/14001 quality assurance system and the responsible care program.

### Areas of Application

Sika® Primer-210 is used to improve the adhesion of Sikaflex® adhesives on many metals such as aluminum and galvanized steel, plastics and paint-primed substrates. This primer is also suitable to enhance the adhesion of Sikasil® sealants and adhesives on porous and non-porous substrates. 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. Pre-treat the bond face of non-porous substrates with Sika® Cleaner-205 and leave to dry. For use with Sikasil® products on non-porous substrates pre-treatment with Sika® Cleaner-P (wipe-on/wipe-off) is also possible. Apply a thin but covering coat of Sika® Primer-210 with a brush, felt or foam applicator. It shall be applied once only. Care must be taken to ensure that this single application gives adequately dense coverage. Sika® Primer-210 exhibits thermoplastic behaviour for up to 3 days following application. Ideal application and surface temperature is between 15°C and 25°C (60°F to 75°F). Consumption and method of application depend on the specific nature of the substrates and manufacturing process.



Tightly re-seal container immediately after each use.

#### Important Note

Discard any primer that has gelled (remarkable increase of viscosity), separated or is not homogenous.

#### Further Information

Working instructions issued for a defined application may further specify technical data contained in this Product Data Sheet. Copies of the following publications are available on request:

- Material Safety Data Sheets
- Sika Pre-Treatment Chart

#### Packaging Information

Can	250 ml
	1 l

#### Value Bases

All technical data stated in this Product Data Sheet are laboratory test based. Current measured values may vary do to factors beyond our influences.

#### Health and Safety Information

For information and advice regarding transportation, handling, storage and disposal of chemical products, users shall refer to the actual Material Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

#### Legal Notes

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



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

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