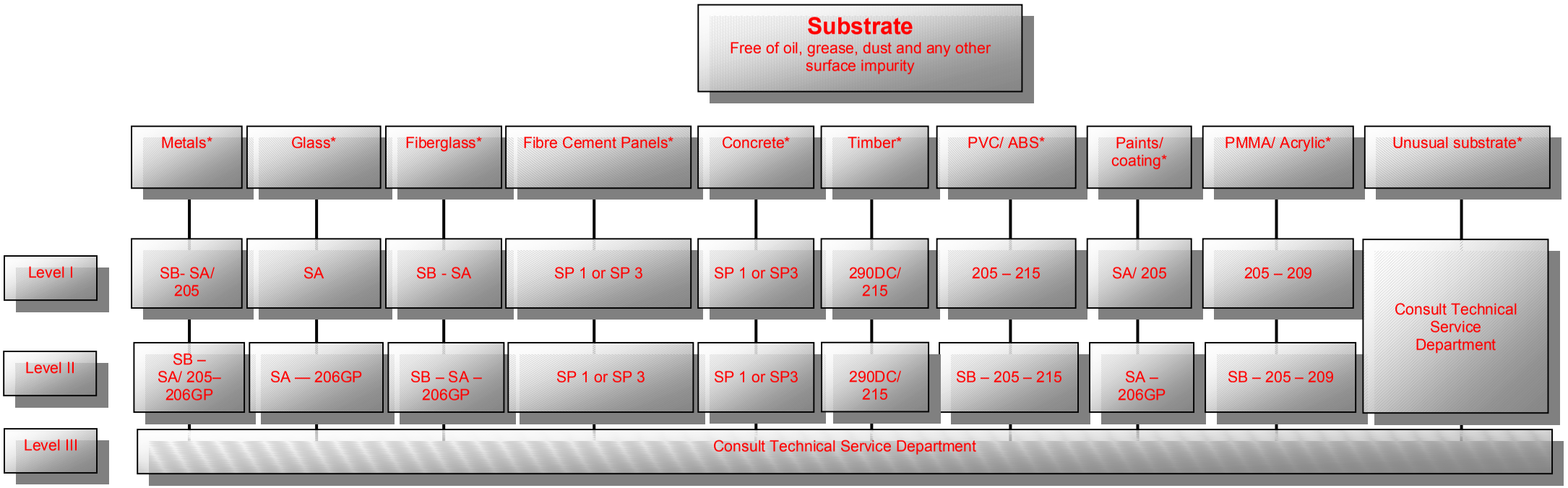
Primer Selection Guide

Revised: December 2004

Surface Preparation Flowchart



	Description	Example
Level I Sealing & Bonding Application	a) General sealing applications. Small components where there is no joint movement b) Non-structural interior bonding applications, no exposure to temperature extremes, and not in contact with water	a) Sealing of interior linings b) Bonding of interior linings, floors that are not in contact with water, etc
Level II Sealing & Bonding Application	a) Sealing applications involving large components where there is joint movement. b) Interior and exterior bonding applications under normal environmental conditions	a) Cover plates and trims, wheel arches, windshields, side windows, etc
Level III Critical Bonding Application	Exterior applications in highly corrosive environments or areas and applications where there is a high risk of corrosion or chemical stress.	Subfloor assemblies in contact with salt water and/or road spray, sundry ventilation duct, etc

DESCRIPTION	Sika Primers are required on substrates where maximum adhesion is required for Sikaflex Sealants and Adhesives. Not all joints or fillets require priming and the following notes should be used as a reference “guide” only for what substrates require priming. If in doubt, always contact our Technical Department.
PRIMER TYPES	
SA	**Sika Aktivator** a) Wipe bond faces with a clean lint-free cloth or absorbent paper towel moistened with Sika® Aktivator. b) Wipe off the excess using a clean lint free cloth. Allow a minimum of 10 minutes to dry and a maximum of 24 hours at temperature over 15°C or minimum of 30 min to 24 h at temperatures below 15°C.
205	**Sika Cleaner 205 (Adhesive Promoter)** Apply very thinly with a clean polishing cloth or tissue NOT a brush. Change cloth frequently. Allow a minimum of 10 minutes to dry and a maximum of 24 hours.
SP 1	**Sika Primer 1** Apply Sika Primer 1 in a thin coat to the prepared surface by brush. Allow the primer to dry for at least one hour but not longer than 5 hours before placing the sealant .If ventilation is poor eg. joints are narrow – wait 2 hours before applying sealant.
SP 3	**Sika Primer 3** Apply Sika Primer 3 in a thin coat to the prepared surface by brush. Allow the primer to dry for at least 30 minutes but not longer than 8 hours before placing the sealant .If ventilation is poor eg. joints are narrow – wait 1 hour before applying the sealant.
206 G+P	**Sika Primer 206 G+P** a) Shake the can of Sika Primer-206 G+P very thoroughly until the paint mixing ball is heard to rattle freely. b) The primer may be applied with a brush, primer applicator or other suitable implement. Apply sparingly: a single thin coat of Sika Primer-206 G+P is sufficient. Reseal container tightly immediately after use. Allow primer to dry at least 20 min but not longer than 24 hours before placing sealant.
209	**Sika Primer 209** Shake thoroughly to ensure all black pigment is dispersed. Apply a moderate coat and allow 20 minutes to dry. Do not spray apply. Repeat coats until film is opaque to bright sunlight. Apply sealant within 24 hours.
210T	**Sika Primer 210T** Apply by brush in a thin coat to the prepared surface. Allow the primer to dry for at least 30 minutes for non-porous substrates or 60 minutes for porous mineral substrates, but no longer than 24 hours before application of sealants.
290DC/ 215	**Sika Primer 290DC/215** For Timber: a) Thoroughly de-oil timber surface with Acetone or Thinner C. Apply thin coat with a clean brush. Ideally apply when substrate temperature is falling. Allow a minimum of 60 minutes to dry before applying sealant and a maximum of 24 hours. For PVC & ABS: For plastic substrates allow to dry for a minimum of 30 minutes and a maximum of 24hours before applying sealant.
SB	Scotch-Brite (Very fine grade) sanding material. Generally used to remove oxide from steel as well as to increase bonding surface area.

*Explanatory notes on substrates definition.

Substrate Classification	Include:	Description
Metals	Aluminium, Stainless Steel, Galvanised Steel, Copper, Brass, Steel	Metals are reactive materials which oxidize on exposure to air. Hence it is necessary to apply abrasion to the surfaces to remove the oxide layer before pretreatment. Sika Primers do not provide corrosion protection to metals. Where corrosion protection is a critical requirement, we recommend to contact our Technical Service department.
Mineral Glass		For ceramic banded glass we recommend applying Sika Activator. If ceramic band is not used, we recommend UV shielding tape to protect the adhesive.
Fibreglass	Gel Coated and Raw GRP	These materials consist for the most part of thermosetting plastics derived from unsaturated polyesters, epoxy resin or polyurethane. Surfaces may contain release agent, hence it is necessary to abrade the surface thoroughly before priming.
Fibre Cement Panels	MDF panels, etc	Fibre cement is a pre-fabricated product which is commonly used in construction of external as well as internal walls. Fibre cement panels generally have low moisture content. Make sure surface is free of dust or any other impurity that may affect adhesion properties.
Concrete	Concrete, Besser block, lightweight block, claybrick, ceramic tiles, sandstones, epoxy mortar.	The most common construction materials in the market. Generally have medium to high moisture content. Surface must be clean and sound before any application of primer.
Timber	Untreated hardwood, untreated softwood, corks, particle board.	Timbers generally have high moisture content and it is considered a porous material. Two coats of primer may be required for highly absorbent timber.
PVC/ABS		Most PVC and ABS have some surface oil from the manufacturing process, hence it is necessary to remove the surface impurity by abrasion.
Paints	Epoxy paints, polyurethane paints	Preliminary trials are necessary before attempting to bond substrate. As a general rule, reactive systems that cure thermally or by addition polymerization can be successfully bonded with Sikaflex® products with the correct surface pre-treatment.
PMMA and Acrylics		Sikaflex 222UV or Sikaflex 295 UV should be used in conjunction with UV shielding tape with this type of material.
Unusual Substrates		Please contact our Technical Department for advice and laboratory testing.

Note:

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