

Primer Table Sikaflex[®] / Sikasil[®]

Descriptions of Sika Primers.

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1 Sika Aktivator-205

Product Description	1-comp. cleaner with adhesion promoters, transparent
Application Method	Cloth or absorbent paper towel. Apply very thinly turn cloth several times to ensure that dirt is not spread.
Description / Technical Data	Transparent alkyl titanate in an alcohol solution; Density 0.80 kg/l (ISO 2811-1)
Uses	To clean and activate the following non-porous substrates: metals, plastics, glazed ceramics, painted surfaces
Flash Off Time*	15 min to 6 hours
Yield per Litre	9 - 18 m ²
Running Meter Joint Per Litre	300 - 600 m
Container Content	1 litre
Shelf Life Store in Sealed Container	12 months in a cool dry place

2 Sika Primer-3 N

Product Description	1-comp. primer, transparent
Application Method	Brush
Description / Technical Data	Transparent solvent based reactive epoxy resin compound, Density 0.98 kg/l (ISO 2811-1)
Uses	To slightly damp or dry, porous, absorbent materials and metals.
Flash Off Time*	min. 30 min., max 8 hours
Yield per Litre	On porous substrates 5 m ² , On metals 8 m ²
Running Meter Joint Per Litre	On porous substrates 220 - 300 m, On metals 400 m
Container Content	250 ml, 1 litre
Shelf Life Store in Sealed container	9 months in a cool dry place

3 Sika MultiPrimer Marine

Product Description	1-comp adhesion promoter for use with Sikaflex [®] and Sikasil [®] products on various substrates.
Application Method	Brush, felt or foam applicator
Description / Technical Data	Colourless, slightly yellow solvent based adhesion promoter, Density 1.0 kg/l (CQP ¹ 006-3 / ISO 2811-1)
Uses	To plastics, varnishes, lacquers and porous, absorbent materials. Preferred for joints around windows where a variety of materials are encountered
Flash Off Time*	10 min. – 24 hours at >15°C. 30 min. – 24 hours at <15°C
Coverage	50 – 150 ml / m ² approx. depending on substrate porosity.
Container Content	250 ml, 1 litre
Shelf Life Store in Sealed container	9 months in a cool dry place

4 SikaTack-Panel Primer

Product Description	1-comp. primer, black - for use only with SikaTack [®] -Panel adhesive.
Application Method	Brush
Description / Technical Data	Black pigmented solvent based reactive epoxy resin compound, Density 1,05 kg/l (ISO 2811-1)
Uses	Special Primer for SikaBond adhesives on porous and non porous substrates where the primed areas due to the colour have to be easily checked
Flash Off Time*	min. 15 min., max 8 h
Yield per Litre	5 - 8 m ²
Running Meter Joint Per Litre	220 - 400m
Container Content	250 ml 1 litre
Shelf Life Store in Sealed Container	9 months in a cool dry place

5 Sika Primer-115

Product Description	1-comp. primer, transparent – for use only with Sikaflex [®] -68 TF.
Application Method	Brush
Description / Technical Data	Transparent solvent based reactive epoxy resin compound. Density 0.98 kg/l (ISO 2811-1)
Uses	Special primer for use with Sikaflex [®] -68 TF only.
Flash Off Time*	min. 30 mins, max. 8 hours (depending on ambient temp.)
Yield per Litre	On porous substrates approx. 5m ²
Running Meter Joint Per Litre	On porous substrates, 220 – 300m
Container Content	1 litre
Shelf Life Store in Sealed Container	9 months in a cool dry place

*flash off' time at Temperatures > +15°C
Application temperature +5°C to +35°C



6 1-Component Polyurethanes and 1-Component Silan-Terminated-Polyurethanes

Substrate	Sikaflex Sealants	Sikaflex - AT Technology
	11 FC / Tank N ***	Sikaflex AT Range
Mineral substrates		
Concrete	3N	3N
Aerated concrete, sandstone	3N	3N
Granite, clay bricks	3N	3N
Plaster, thermally- insulating plaster	3N / MPM **	3N
Plaster, cement render	3N / MPM **	3N
Fibre cement	3N	3N
Glazed tiles	Aktivator-205	Aktivator-205
Unglazed tiles	3N	3N
Enamel	Aktivator-205	Aktivator-205
Non ferrous metals		
Aluminium uncoated	A + 3N	A+Aktivator-205
Aluminium anodised	A + 3N	Aktivator-205
Copper	A + 3N	A + 3N
Titaniumzinc	A + 3N	A + 3N
Iron / metals		
Structural steel (St 37), uncoated	A + 3 N	A + 3N
Steel zinc coated	A + 3 N	A+Aktivator-205
Stainless steel (V2A, V4A)	A + 3 N	A+Aktivator-205
Plastics		
Epoxy mortar	A+Aktivator-205	A+Aktivator-205
Epoxy coatings	A+Aktivator-205	A+Aktivator-205
GRP (based on UP, EP, PU)	A+Aktivator-205	A+Aktivator-205
UPVC	MPM	Aktivator-205
Wood not weathered		
Hardwood, untreated	0	0
Softwood, planed, untreated	0	0
Plywood	0	0
Wood weathered		
Hardwood, untreated	3N	3N
Plywood	3N	3N
Softwood, planed, pressure impregnated or untreated	3N	3N
Varnishes / lacquers		
UP- or PU-2-pack varnishes	A+Aktivator-205	A+Aktivator-205
Alkyd resin wood stain	A+Aktivator-205	A+Aktivator-205
DD-varnishes	A+Aktivator-205	A+Aktivator-205
Powder coatings	A+Aktivator-205	A+Aktivator-205

* not suitable for long term water immersion

** Sika MultiPrimer Marine for connection joints between UPVC and Plaster

*** Not valid for Sikaflex Tank N, according to the approval use Sika MultiPrimer Marine (see also Technical data sheet).

Abbreviations:

/ or -	Dependent on the requirements. Contact Sika Technical Services Department for advice
0	Application without Primer
-	Select other Sika sealant / adhesives
A	Gently rub down substrate in single pass with abrasive pad and clean with Aktivator-205
Aktivator-205	Clean with Sika Aktivator-205
3 N	Prime with Sika Primer-3 N
MPM	Prime with Sika MultiPrimer Marine
STPP	Prime with SikaTack Panel Primer

GRP = Glass-fibre Reinforced Plastics, UP = Polyester, EP = Epoxy; PU = Polyurethane



7 1-Component Silicone*

Substrate	Sikasil® acetic curing silicones	Sikasil® neutral curing silicones
Mineral substrates		
Concrete	-	3N*
Aerated Concrete, sandstone	-	3N*
Granite, clay bricks	-	3N*
Plaster, thermally insulating plaster	-	3N*
Plaster, cement render	-	3N*
Fibre cement (surface only)	-	-
Glazed tiles	3N*	3N*
Unglazed tiles	3N*	3N*
Enamel	Aktivator-205	Aktivator-205
Non ferrous metals		
Aluminium uncoated	-	Aktivator-205
Aluminium anodised	-	Aktivator-205
Copper	-	Aktivator-205
Titanium / Zinc	-	Aktivator-205
Iron / metals		
Structural steel (St 3 N 7), uncoated	-	Aktivator-205
Steel zinc coated	-	Aktivator-205
Stainless steel (V2A, V4A)	Aktivator-205	Aktivator-205
Plastics		
Epoxy mortar	A + Aktivator-205	A + Aktivator-205
Epoxy coatings	A + Aktivator-205	A + Aktivator-205
GRP (based on UP, EP, PU)	A + Aktivator-205	A + Aktivator-205
UPVC	Aktivator-205	Aktivator-205
Wood not weathered		
Hardwood, untreated	3N	3N
Softwood, planed, pressure untreated	3N	3N
Plywood	3N	3N
Wood weathered		
Hardwood, untreated	3N	3N
Softwood, planed, pressure limpregnated or untreated	3N	3N
Plywood	3N	3N
Varnishes / lacquers		
UP- or PU-2-pack varnishes	Aktivator-205	Aktivator-205
Alkyd resin wood stain	0	0
DD-varnishes	0	0
Powder coatings	Aktivator-205	Aktivator-205

* no suitable for longterm water immersion

Abbreviations:

/ or -	Dependent on the requirements. Contact Sika Technical Department for advice
0	Application without Primer
-	Select other Sika sealant / adhesives
A	Gently rub down substrate in single pass with abrasive pad and clean with Aktivator-205
Aktivator-205	Prime with Sika Aktivator-205
3 N	Prime with Sika Primer-3 N
MPM	Prime with Sika MultiPrimer Marine
STPP	Prime with SikaTack Panel Primer

GRP = Glass-fibre Reinforced Plastics, UP = Polyester, EP = Epoxy; PU = Polyurethane

Important Notes:

- Primers are only adhesion promoters. They neither substitute for the correct cleaning of the surface nor improve their strength significantly. Primers improve long term performance of a sealed joint / bonded joint.
- Bonding surfaces must be cleaned prior to application of primer.
- For absorbent substrates(concrete, wood) - Dry cleaning (free from dust and other loose or friable particles)
- For non-absorbent substrates (metals etc.) - Damp cleaning (e.g. using, Sika Thinner C)
- For rubbing down we recommend Scotch Brite abrasive pads very fine
- For optimum adhesion and critical, high performance applications such as multi story building work, for high stress bonding joints or in case of extreme weather exposure substrate primers and cleaners must be used. If in doubt apply product in test area first.

