

Sikaflex® Primers

429/202, 449/203, 260/205

Description Sikaflex® primers are specially formulated to be used on specific substrates with Sikaflex® polyurethane sealants. Most substrates require a primer only if testing shows need and where the sealant will be underwater after cure. Some substrates do require a primer under all conditions.

Sikaflex® Primer 202
Sikaflex® 202 is used to promote adhesion to clean, sound and dry concrete, masonry and wood including teak and mahogany prior to placing Sikaflex® sealants.

Sikaflex® Primer 203
Sikaflex® 203 is used to promote adhesion to PVC, solvent-based enamel, PPG's fluorocarbon Duranar finish, and some plastics such as ABS and Plexiglas/Lucite.

Sikaflex® Primer 205
Sikaflex® 205 is a dual-purpose clear, almost colourless primer. It is used for promoting adhesion of polyurethane sealants to various metallic, non-metallic and glass substrates.

- Advantages**
- One-component primer packaged in 473 mL (16 fl oz) tin, ready to use.
 - Easily applied by brush, dauber or spray.

Technical Data

Packaging	473 mL tin (16 fl oz), 6/case		
Colour	Clear (almost colourless)		
Yield per 473 mL (16 fl oz) tin	202	203	205
	Linear meter (Linear foot)		
13 x 13 mm (1/2 x 1/2 in) joint	90 (295)	90-150 (295-490)	90-150 (295-490)
Coverage m ² /L (ft ² /US gal.) (approx.)	5 (14)	5-8 (14-23)	5-8 (14-23)
Shelf Life	6 months in original, unopened package. Store dry at 5° - 32°C (41° - 89°F). Condition product to 18° - 27°C (65° - 81°F) before using.		

Properties at 23°C (73°F) and 50% R.H.

		Sikaflex® Primers		
		202	203	205
Specific Gravity		1	0.9	0.8
Viscosity	NO.2 Zahn (sec.)	-	17	12-16
	Brookfield, MPa.s (cps)	135	-	-

How to Use

Surface Preparation The key to good adhesion with Sikaflex® sealants is surface preparation. Specifically, all surfaces must be dry and free of dirt, grease, form release agent, loose mortar, laitance and any foreign matter. If the joint contains old sealant, it must be removed and the substrate cleaned by mechanical means. Apply primers at substrate temperatures of 4°C (39°F) and rising. Surface must be frost-free.

Application Shake primer well before using. Apply to dry, clean, oil-free surface with a brush, dauber or spray. Drying time before installing sealant:

- Sikaflex® Primers**
- 202 & 205** between 1-8 h*
 - 203** between 30 min-8 h*

Primer should not be used if starting to gel in container.
*If sealant cannot be installed within 8 h of priming, re-prime.

- Limitations**
- Protect Sikaflex® Primers from moisture.
 - Once container has been opened, use content immediately.
 - Do not attempt to use partial containers.
 - Do not reseal or re-use.
 - Resealing may cause moisture contamination and gelling.

Caution Flammable - Contains volatile solvents. Avoid contact with skin, eyes and clothing. Wear suitable protective clothing. Avoid breathing vapours. Operations should be performed in well-ventilated areas. Consult product label for additional information.

First Aid In case of skin contact, wash with soap and water. For eye contact flush immediately with plenty of water for at least 15 min. Contact a physician. For respiratory problems, transport victim to fresh air. Remove contaminated clothing and wash before re-use.

For more information, consult Sika Material Safety Data Sheet.

KEEP OUT OF REACH OF CHILDREN
FOR INDUSTRIAL USE ONLY



RECOMMENDATIONS - PRIMERS AND SEALANTS

		SikaBond® Constr. Adhesive					
CONSTRUCTION SUBSTRATE	SURFACE PREPARATION	Sikaflex® 1a	REQUIRED PRIMER	Sikaflex® 15LM	REQUIRED PRIMER	Sikaflex® 2C NS EZ/SL	REQUIRED PRIMER
Concrete & Masonry	Surfaces must be clean, sound, dry and free of form oils, grease, or treatments that prevent proper adhesion. Mechanical abrasion may be required.	Acceptable	N.R. Sikaflex® 202 (If necessary)	Acceptable	N.R. Sikaflex® 202 (If necessary)	Acceptable	N.R. Sikaflex® 202 (If necessary)
Concrete block		↓	↓	↓	↓	↓	↓
Placed concrete		↓	↓	↓	↓	↓	↓
Precast concrete	Substrate conditions will change for each job and a test application is recommended to establish the need for or type of preparation required. For best results, primer may be required, on some jobs.	↓	↓	↓	↓	↓	↓
Mortar		↓	↓	↓	↓	↓	↓
Grout		↓	↓	↓	↓	↓	↓
Brick	Surfaces must be clean and dry. Test applications are recommended to determine need for and type of surface preparation Primer may be required.	Acceptable	N.R. Sikaflex® 202 (If necessary)	Acceptable	N.R. Sikaflex® 202 (If necessary)	Acceptable	N.R. Sikaflex® 202 (If necessary)
SikaTops		↓	↓	↓	↓	↓	↓
Stone	Surfaces must be clean and dry. Wipe the surface with a clean rag to remove any dust. Since the paint formulation may change, a test application is recommended.	Acceptable	N.R. Sikaflex® 202 (If necessary)	Acceptable	N.R. Sikaflex® 202 (If necessary)	Acceptable	N.R. Sikaflex® 202 (If necessary)
Granite		↓	↓	↓	↓	↓	↓
Marble		↓	Sikaflex® 205 (If necessary)	↓	Sikaflex® 205 (If necessary)	↓	Sikaflex® 205 (If necessary)
Paints		Do not use	N/A	Do not use	N/A	Do not use	N/A
Acrylic Latex		↓	↓	↓	↓	↓	↓
Emulcoat 33		↓	↓	↓	↓	↓	↓
DeSoto Fluorpon		↓	↓	↓	↓	↓	↓
PPG Duracron S600		↓	↓	↓	↓	↓	↓
Solvent-based enamel	Surfaces must be clean and dry. Dry and/or solvent-wipe* with clean rags.	Acceptable	Sikaflex® 203	Acceptable	Sikaflex® 203	Acceptable	Sikaflex® 203
PPG Fluorcarbon		↓	↓	↓	↓	↓	↓
Duramar		↓	↓	↓	↓	↓	↓
Plastic		Acceptable	Sikaflex® 203	Acceptable	Sikaflex® 203	Acceptable	Sikaflex® 203
PVC		↓	↓	↓	↓	↓	↓
ABS		↓	↓	↓	↓	↓	↓
Plexiglas		↓	↓	↓	↓	↓	↓
Plexiglas DR		↓	↓	↓	↓	↓	↓
Lucite		↓	↓	↓	↓	↓	↓
Rovel Plastic1		↓	↓	↓	↓	↓	↓
Lexan		↓	Sikaflex® 205	↓	Sikaflex® 205	↓	Sikaflex® 205
Teflon		Do not use	N/A	Do not use	N/A	Do not use	N/A
Polyethylene	Surfaces must be dry and free of all contaminants.	↓	↓	↓	↓	↓	↓
Polypropylene	Surfaces should be dry and/or solvent-wipe.* The solvent used should be checked for compatibility with adjacent materials that it will contact.	Acceptable	N.R. Sikaflex® 203 (If necessary)	Acceptable	N.R. Sikaflex® 203 (If necessary)	Acceptable	N.R. Sikaflex® 203 (If necessary)
Tuffak		Acceptable	↓	Acceptable	↓	Acceptable	↓
Polyester/ Fibreglass		Acceptable	↓	Acceptable	↓	Acceptable	↓
Glass		Acceptable		Acceptable		Acceptable	
Glass-sheet, float or plate	Surfaces must be dust- and oil-free. Dry and/or solvent-wipe* with clean rags.	↓	↓	↓	↓	↓	↓
Porcelain		↓	N.R. Sikaflex® 205 (If necessary)	↓	N.R. Sikaflex® 205 (If necessary)	↓	N.R. Sikaflex® 205 (If necessary)
Ceramic tile	Dry and/or solvent-wipe* with clean rags.	↓	↓	↓	↓	↓	↓
	Dry and/or solvent-wipe* with clean rags.	↓	↓	↓	↓	↓	↓
Metal	Remove oxide by sanding. Dry and/or solvent-wipe* with clean rags.	Acceptable	N.R. Sikaflex® 205 (If necessary)	Acceptable	N.R. Sikaflex® 205 (If necessary)	Acceptable	N.R. Sikaflex® 205 (If necessary)
Aluminium - anodized		↓	↓	↓	↓	↓	↓
Aluminium - mill finish	Dry and/or solvent-wipe* with clean rags.	↓	↓	↓	↓	↓	↓
Lead	Dry and/or solvent-wipe* with clean rags.	↓	↓	↓	↓	↓	↓
Copper	Dry and/or solvent-wipe* with clean rags.	↓	↓	↓	↓	↓	↓
Brass	Dry and/or solvent-wipe* with clean rags.	↓	↓	↓	↓	↓	↓
Zinc	Dry and/or solvent-wipe* with clean rags.	↓	↓	↓	↓	↓	↓
Tinplate	Due to varying formulations, test applications are necessary in each case to determine compatibility.	↓	↓	↓	↓	↓	↓
Steel (bright/clean)	Surfaces must be clean and dry. Treated wood must be tested for adhesion.	↓	↓	↓	↓	↓	↓
Steel (stainless)		↓	Sikaflex® 205	↓	Sikaflex® 205	↓	Sikaflex® 205
Steel (galvanized)		↓	Sikaflex® 205	↓	Sikaflex® 205	↓	Sikaflex® 205
Rubber	N/A		N.R. Sikaflex® 203 (If necessary)		N.R. Sikaflex® 203 (If necessary)		N.R. Sikaflex® 203 (If necessary)
Urethane		Acceptable	↓	Acceptable	↓	Acceptable	↓
Wood			N.R. Sikaflex® 202 (If necessary)		N.R. Sikaflex® 202 (If necessary)		N.R. Sikaflex® 202 (If necessary)
Unfinished wood		Acceptable	↓	Acceptable	↓	Acceptable	↓
Others			N/A		N/A		N/A
Asphaltic substrates		Do not use	↓	Do not use	↓	Do not use	↓

N/A = Not applicable

N.R. = Sealant has been found to bond to the surface without need of primer.

1 = Slight surface attack may result from primer

* = Solvent handling requirements - Do not use alcohol or alcohol - containing solvents.

Solvents are volatile and flammable and should be kept away from heat and open flames. Use only with adequate ventilation and avoid prolonged breathing of vapour. Avoid contact of vapour with open flame or sparks. When these solvents are used, as described, proper safety precautions must be observed. All solvents must be considered toxic and should be used only in well-ventilated areas. Prolonged exposure to solvent vapours must be avoided. If flammable solvents are used, storage, mixing and use must be in areas away from open flames or other sources of ignition. The selection of any solvent, particularly chlorinated hydrocarbon solvents, will require consideration of applicable federal, provincial and local regulations. Material Safety Data Sheets outlining the known hazards and safety precautions associated with the product or solvent used, are published for most materials and may be obtained from appropriate suppliers and used accordingly.

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, within their shelf life. 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 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 or can be accessed in the Internet under www.sika.ca.

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