

# Sika® Primer-210T

## Technical Product Data

Chemical base	Solvent based epoxy resin compound
Colour	Transparent, straw coloured
Density (CQP <sup>1</sup> 006-3 / ISO 2811-1)	0.92 kg/l approx.
Viscosity <sup>2</sup> (CQP 029-3 / ISO 3219)	7 mPas approx.
Flash point (CQP 007-1 / ISO 13736)	-10°C approx.
Solid content	23%
Application temperature	10°C to 35°C
Application method	Brush or felt
Coverage	100 ml/m <sup>2</sup> approx.
Drying time <sup>3</sup>	minimum 30 min. maximum 24 h
Storage	Store in sealed container in a cool dry place
Shelf life	12 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 drying time may be different

Industry

### Description

Sika® Primer-210 T is a liquid primer of low viscosity for use on aluminum, galvanized steel sheet and some plastics prior to bonding or sealing with Sikaflex® products. Sika® Primer-210T is manufactured in accordance with ISO 9001/14001 quality assurance system and with the responsible care program.

### Areas of Application

Sika® Primer-210 T is used to improve the adhesion of Sikaflex® adhesives on many metals, plastics and paint primed substrates. This primer is not suitable for use on porous surfaces.

### Method of Application

Surfaces must be clean, dry and free from all traces of grease, oil and dust. Wipe the bond face with Sika® Cleaner-205 and leave to dry. Apply a thin but covering coat with a brush or felt. Do not apply at temperatures below 10°C or above 35°C. Sika® Primer-210 T 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. SikaPrimer®-210 T has, at an early stage after application, a thermoplastic behaviour. Therefore larger objects should not be exposed to more than 40°C during the first 3 days after bonding. This product is suitable for professional experienced users only. Test with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.



### Important Note

Immediately after use, reseal container tightly. Prolonged exposure to atmospheric moisture will cause Sika®Primer-210T to become inactive.

Discard any primer that has gelled or separated or has become cloudy or opaque.

### Further Information

Copies of the following publications are available on request:

- Material Safety Data Sheets
- Sika Primer Chart

### Packaging Information

Can	250 ml 1 l
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### 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 on the safe handling, storage and disposal of chemical products, users should refer to the most recent Material Safety Data Sheet 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.co.uk](http://www.sika.co.uk)  
[www.sika.com](http://www.sika.com)

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