

PRODUCT DATA SHEET

Sika® Primer-219

Detectable long open time primer for PU-RIM and plastics

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

| | |
|--------------------------------|--|
| Chemical base | Solvent-based polyurethane solution |
| Color (CQP001-1) | Black |
| Solid content | 26 % |
| Application temperature | 5 – 40 °C |
| Application method | Brush, felt or foam applicator |
| Consumption | depending on substrate porosity 50 ml/m ² |
| Flash-off time | above 5 °C 5 minutes ^A |
| Open time | maximum 4 months ^B |
| Shelf life | 12 months ^C |

CQP = Corporate Quality Procedure ^{A)} in specific application, temperature and flash-off time may be different

^{B)} 23 °C / 50% r.h.

^{C)} stored in sealed container in up-right position in a dry place ≤ 25 °C

DESCRIPTION

Sika® Primer-219 is a solvent-based, black, one-step long open time (LOT) primer, which reacts with moisture and forms a thin layer. This layer acts as a link between substrates and adhesives.

Sika® Primer-219 is specifically formulated for the treatment of plastics and PU-RIM encapsulations prior to application of Sika's 1-component polyurethanes. It may also be used for other adhesive technologies.

Sika® Primer-219 is not suitable for applications on inorganic surfaces like glass, ceramics and metals.

This primer might provide very good adhesion without previous activation step on many substrates.

Sika® Primer-219 fluoresces under long-wave UV light for a limited period of time. This feature is used for in-process control.

PRODUCT BENEFITS

- Long open time up to 4 months (23 °C / 50 % r.h.) without reactivation
- Visible under UV light
- One-step application

AREAS OF APPLICATION

Sika® Primer-219 is used to improve adhesion on glasses with PU-RIM encapsulation and a very broad range of different plastics.

Under certain conditions Sika® Primer-219 can be used as a long open time primer. If used as long open time primer it has to be protected from UV, sun light and contaminants. Tests on original substrates with the appropriate adhesive under long open time conditions have to be performed prior the application.

Seek manufacturer's advice and perform tests on original substrates before using Sika® Primer-219 on materials prone to stress cracking.

This product is suitable for experienced professional users only. Tests with actual substrates and conditions have to be performed ensuring adhesion and material compatibility.

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METHOD OF APPLICATION

Surfaces must be clean, dry and free from grease, oil, dust and contaminants.

Adhesion on substrates may be improved by adding and/or combining pre-treatment processes such as scuffing, cleaning and activating.

Application

Shake the Sika® Primer-219 can very thoroughly for twenty seconds prior using the product. There are no mixing balls inside. Apply a thin but covering coat with a brush, felt or foam applicator.

Ideal application and surface temperature are between 15 °C and 25 °C.

Sika® Primer-219 has to be applied once only. Care must be taken to ensure that this single application gives adequately dense coverage. Consumption and method of application depend on the specific nature of the substrates. Tightly reseal container immediately after each use.

IMPORTANT NOTE

Sika® Primer-219 is a moisture reactive system. In order to maintain product quality it is important to reseal the container with the inner plastic liner immediately after use. Once the surface pre-treatment operation is completed, the cap has to be screwed on.

Dispose of product one month after opening if used frequently or after two months in case of infrequent use.

If gelling, separation or a significant increase in viscosity is noted, discard the primer immediately.

Never dilute or mix this product with any other substances.

If used on transparent or translucent substrates such as float glass, plastics, etc., an adequate UV protection is mandatory.

DETECTION OF THE LUMINESCENCE

Sika® Primer-219 can be visualized by using a light source with a wavelength of 320 to 420 nm as inline control. By reducing foreign light such as sunlight or artificial light during the detecting process the quality of the detection can be increased significantly.

Note: The luminescent effect will degrade with time.

FURTHER INFORMATION

The information herein is offered for general guidance only. Advice on specific applications is available on request from the Technical Department of Sika Industry.

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:

- Safety Data Sheets

PACKAGING INFORMATION

| | |
|-----|---------|
| Can | 1000 ml |
|-----|---------|

BASIS OF PRODUCT DATA

All technical data stated in this document are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

HEALTH AND SAFETY INFORMATION

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

DISCLAIMER

The information, and in particular, the recommendations relating to the application and enduse 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 accordance with Sika's recommendations. 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 user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

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