



SILANE TERMINATED POLYMERS SIKA PRE-TREATMENT CHART

FOR SILANE TERMINATED POLYMERS (STP) – Sikaflex®-500 SERIES

UTILISATION OF SIKA PRE-TREATMENT CHART

The information about the pre-treatment of surfaces in this document serves as a guideline only and must be verified by tests on original substrates. Project specific pre-treatment recommendations, based on laboratory tests, are available from Sika upon request. Always consult additional information.

GENERAL RECOMMENDATIONS FOR Sikaflex®-500 SERIES

PRECONDITION:

Surfaces have to be clean, dry and free of oil, grease, dust and loose particles. Depending on the nature of soiling, Sika® Remover-208, Sika® Cleaner P or another suitable cleaning solution may be used. For substrates that are prone to oxidation and/or have a weak surface layer it might be necessary to abrade the surface down to sound material. Verify compatibility with cleaning products.

Levels	Description
1	<ul style="list-style-type: none"> General sealing applications, small components with low level of stress exposure Non-structural interior bonding applications, no exposure to temperature extremes, no contact with water
2	<ul style="list-style-type: none"> Sealing applications involving large components where higher joint movements are to be expected Interior and exterior bonding applications under normal environmental conditions
3	<ul style="list-style-type: none"> Other applications, not covered under Level 1 and 2, where additional requirements are specified Serial application

Substrate	EN*	1			2			3
		Mechanical	Adhesion Promoter/Cleaner	Primer	Mechanical	Adhesion Promoter/Cleaner	Primer	
Aluminum (AlMg3, AlMgSi1 and similar)	1		SA-205 SA-100		AP-C AP-C	SA-205 SA-100		
Aluminum (anodized)	2		SA-205 SA-100				SP-210 SP-207	
Steel (mild)	3		SA-205 SA-100		AP-C AP-C		SP-210 SP-207	
Steel (stainless)	4		SA-205 SCP			SA-205 SA-100		
Steel (hot-dip galvanized, electrogalvanized)	5		SA-205 SCP			SA-205 SA-100		
Non-ferrous metals (copper, brass, bronze,...)	6	AP-C	SA-205	SP-210	AP-C	SA-205	SP-210	
2-Component top coat, water- and solvent based (PUR, acrylic)	7		SA-205 SCP			SA-205 SA-100		
Powder coat (Polyester (PES), EP/PES)	7		SA-205 SCP		AP-C AP-C	SA-205 SA-100		
2-Component paint primer, water- and solvent based (PUR, acrylic, epoxy)	7		SA-205 SCP			SA-205 SCP		
Cathode dip coating (e-coating)	7		SCP			SA-205 SCP		
Coil coating, mainly Polyester	8		SA-205			SA-205 SCA		
FRP (unsaturated polyester) gelcoat side or SMC	9		SA-205 SCP		AP-C AP-C	SA-205 SCP		
FRP (unsaturated polyester) lay-up side	9	AP-C AP-C	SA-205 SCP		AP-C AP-C	SA-205	SP-210	
ABS	10			SP-207 SA-205 SP-215			SP-207 SA-205 SP-215	
Hard PVC	10		SA-100			SA-100	SP-207	
Glass	11		SCP			SA-205 SCP		
Ceramic screen print	11		SA-205 SCP			SA-205 SA-100		
Wood / Plywood	12			SP-207			SP-207 SP-215	

CONTACT SIKA TECHNICAL DEPARTMENT INDUSTRY

* EN = Explanatory notes see page 4.



PRODUCT DATA AND ABBREVIATIONS


The following product information is an abbreviated version of the current Product Data Sheets.

Sika® Aktivator	-100	-205	Sika® Coating Aktivator
Color of container cap	orange	yellow	white
Color of product	colorless to slight yellow	colorless, clear	colorless to slight yellow
Type of product	Adhesion promoter		
Application temperature	The general range is 10 – 35 °C. For specific values always refer to the most recent Product Data Sheet.		
Application	Wipe with a clean and lint-free paper towel (Sika Aktivator®-100 wipe on / wipe off application is required)		
Consumption	Approximately 20 ml/m ² (depending on application method).		
Flash-off time (23 °C / 50 % r.h.)	The minimal range of the flash-off time varies from 10 to 30 minutes depending on product, substrate and climatic conditions. For specific values always refer to the most recent Product Data Sheet.		

Sika® Primer	-207	-210	-215
Color of container cap	black	grey	dark blue
Color of product	black	transparent, yellowish	transparent, yellowish
Type of product	Primer		
Application temperature	General range is 10 – 35 °C. For specific values refer always to the most recent Product Data Sheet.		
Preparation for use	Shake bottle vigorously until the mixing balls rattle freely. Then continue shaking for an additional minute.	n.a.	
Application	Brush / felt / foam applicator		
Consumption	Approximately 50 ml/m ² (depending on application method and substrate porosity).		
Flash-off time (23 °C / 50 % r.h.)	The minimal range of the flash-off time varies from 10 to 30 minutes depending on product, substrate and climatic conditions. For specific values always refer to the most recent Product Data Sheet.		

Notice: Sika® activators and primers are moisture reactive systems. In order to maintain product quality it is important to reseal the container immediately after use. With frequent use i.e. opening and closing several times, it is recommend disposing of the product one month after the first opening. With infrequent use, it is recommend disposing of the product two months after opening.

When selecting a foam applicator, the solvent resistance must be considered. Suitable products include Sika® Cleaner PCA or melamine foam Basotect from BASF.

Abbreviation	Product/Explanation
	No special pre-treatment required
AP-C	Abrasive Pad, very fine (e.g. from Sia or 3M) followed by cleaning step, dry wipe or SCP
SCP	Sika® Cleaner P
SA-100	Sika® Aktivator-100
SA-205	Sika® Aktivator-205
SCA	Sika® Coating Aktivator
SP-207	Sika® Primer-207
SP-210	Sika® Primer-210
SP-215	Sika® Primer-215

Always consult additional information, such as General Guidelines "Bonding and Sealing with Sikaflex®", current Product Data Sheets, Safety Data Sheets, additional Product- and Technical Information, etc. prior to use of the products. Project oriented solutions are documented in Technical Service reports. These solutions can vary from the table opposite and take priority over the general recommendations provided in this Pre-Treatment Chart.

LEGAL DISCLAIMER

The information contained herein and any other advice 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. The information only applies to the application(s) and product(s) expressly referred to herein and is based on laboratory tests which do not replace practical tests. In case of changes in the parameters of the application, such as changes in substrates etc., or in case of a different application, consult Sika's Technical Service prior to using Sika products. The information contained herein does not relieve the user of the products from testing them for the intended application and purpose. 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 can be downloaded on your local sika company website or will be supplied on request.

