

# Sika® Primer Table for adhesives and sealants

Priming recommendations to ensure durable bonding with Sika adhesives and sealants

Substrate	1-comp. PU		1-comp. silicone	
	SikaBond adhesives	Sikaflex sealants	Sikasil E-plus	Sikasil N, B
<b>Mineral substrates</b>				
Concrete Aerated concrete, sandstone Granite, clay bricks Self-levelling screeds	3/2		-	3/21
Plaster, thermally-insulating plaster				
Plaster, cement render	2/21			
Fibre cement (surface only)	2			-
Glazed tiles	HR 1		0	0
Unglazed tiles	3/2			
<b>Non-ferrous metals</b>				
Aluminium, uncoated or anodised	A + 35		SSP/HR 1	SSP/HR 1
Copper	24/35		-	SSP
Brass	A + 24			SSP/HR 1
Lead	24			SSP
<b>Ferrous metals</b>				
Structural steel (St 37), uncoated	A + 24/35		-	SSP/HR 1
Steel, uncoated or zinc-coated	A + 35			
Stainless steel (V2A, V4A)	A + 35		SSP/HR 1	
<b>Plastics</b>				
Epoxy mortar Epoxy coatings	A+ HR 1		A	A
UP/epoxy/PU-based GRP	A+ HR 1			
Enamel	HR 1		0/HR 1	0/HR 1
PVC-U	21		HR 1	HR 1
<b>Wood</b>				
Hardwood, untreated	0/3		3	3
Softwood, planed, pressure impregnated or untreated				
Plywood				
<b>Varnishes/lacquers</b>				
UP lacquers or PU 2-pack varnishes	HR 1		0	0
Alkyd resin woodstain				
Powder coatings	A+ HR 1		HR 1	HR 1

**Note:**

Bonding surfaces must be cleaned prior to application of primer. The primer is no substitute for cleaning.

For absorbent substrates (concrete, wood)

- Dry cleaning (free from dust and other loose particles)

For non-absorbent substrates (metals etc.)

- Damp cleaning (e.g. using Sika-Reinigungsmittel 5)

For rubbing down, we recommend e.g. Scotch Brite abrasive pad, very fine.

**Abbreviations:**

/ Or – depending on requirements

0 Application without Primer

- Select other sealant

A Gently rub down substrate in single pass with abrasive pad and clean with HR 1

HR1 Prime using Sika-Haftreiniger 1

2 Prime using Sika-Primer 2

3 Prime using Sika-Primer 3

21 Prime using Sika-Primer 21

24 Prime using Sika-Primer 24

35 Prime using Sika-Primer 35

SSP Prime using Sikasil-Primer



## Overview of Sika primers and cleaners

Primer	Application method	Use	Drying time approx.	Yield per container		Container contents ml
				Area approx. (m <sup>2</sup> )	Joint 20 x 15 mm approx. (m)	
<b>Sika-Primer 2</b> 1-comp. Primer	Brush	To dry, porous, absorbent materials.	min. 30 min. max. 8 h	3	160	1000
<b>Sika-Primer 3</b> 1-comp. Primer	Brush	To slightly damp or dry, porous, absorbent materials.	min. 30 min. max. 8 h	5	220	1000
<b>Sika-Primer 21</b> 1-comp. Primer	Brush	To plastics, varnishes, lacquers and porous, absorbent materials. Preferred for joints around windows where a variety of materials are encountered.	min. 30 min. max. 8h	8	300	1000
<b>Sika-Primer 24</b> 1-comp. Primer	Brush	To non-ferrous metals, e.g. lead, copper, brass.	min. 60 min. max. 5 h	1	60	250
<b>Sika-Primer 35</b> 1-comp. Primer	Brush	To metals, e.g. steel, aluminium.	min. 30 min. max. 8 h	5	200	1000
<b>Sika-Haftreiniger 1</b> 1-comp. with no aggressive solvents	Cloth	To metals, plastics, varnishes and lacquers. Apply very thinly using soft cloth or blotting paper; turn cloth several times to ensure that dirt is not spread.	min. 15 min. max. 6 h	9	300	1000
<b>Sika-Reinigungsmittel 5</b> 1-comp.	Cloth	For pre-cleaning of non-absorbent substrates to remove dust, oil and grease; turn cloth several times to ensure that dirt is not spread.	min. 15 min.	15	500	1000
<b>Sikasil-Primer</b>	Brush	To metals and some plastics	min. 15 min. max. 8 h	2	80	250

“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 upon request.”