

**Product Data Sheet**  
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Sikaflex Sealant/Adhesive Primers

# Sikaflex® Sealant/Adhesive Primers

## 260/205, 429/202, 449/203

<b>Description</b>	Sikaflex primers are special materials formulated to improve the bond of Sikaflex urethane sealants when applied to specific substrates.								
<b>Sikaflex Primer 260/205</b>	Sikaflex Primer 260/205 promotes adhesion of urethane sealants to various metallic, non-metallic, and plastic substrates.								
<b>Sikaflex Primer 429/202</b>	Sikaflex Primer 429/202 promotes adhesion to clean, sound, and dry concrete, masonry, Exterior Insulation Finish Systems (EIFS), and wood — including teak and mahogany.								
<b>Sikaflex Primer 449/203</b>	Sikaflex Primer 449/203 is used to promote adhesion to pvc, solvent-based enamel, PPG's fluoro-carbon Duranar-finish, and certain plastics such as ABS and Plexiglass.								
<b>Where to Use</b>	Most substrates require a primer only if testing shows need for it or where the sealant will be underwater after cure. Certain substrates do require a primer under all conditions.								
<b>Advantages</b>	<ul style="list-style-type: none"> <li>■ Single-component, ready to use.</li> <li>■ Easily applied by brush, dauber, or spray.</li> </ul>								
<b>Coverage</b>	<p>Following are average coverages, depending on porosity of substrate:</p> <table border="1"> <thead> <tr> <th>Sikaflex Primer</th> <th>Coverage per pint lin. ft. 1/2-x 1/2 in. joint</th> </tr> </thead> <tbody> <tr> <td>260/205</td> <td>300-500</td> </tr> <tr> <td>429/202</td> <td>300</td> </tr> <tr> <td>449/203</td> <td>300-500</td> </tr> </tbody> </table>	Sikaflex Primer	Coverage per pint lin. ft. 1/2-x 1/2 in. joint	260/205	300-500	429/202	300	449/203	300-500
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260/205	300-500								
429/202	300								
449/203	300-500								
<b>Packaging</b>	<p><b>Sikaflex 260/205 and 449/203</b> primers are available in pints, 6/carton.</p> <p><b>Sikaflex 429/202</b> primer is available in pints, 6/carton; and gallons, 4/carton.</p>								

Substrate	Primer Required	Recommended primer if necessary
<b>Concrete and Masonry</b>		
Concrete Block	No	Sikaflex 429 primer
Placed Concrete	No	Sikaflex 429 primer
Precast Concrete	No	Sikaflex 429 primer
Mortar	No	Sikaflex 429 primer
Grout	No	Sikaflex 429 primer
Brick	No	Sikaflex 429 primer
SikaTops	No	Sikaflex 429 primer
<b>Stone</b>		
Granite	No	Sikaflex 429 primer
Marble	No	Sikaflex 260 primer
<b>Paints</b>		
Acrylic Latex	No Bond Achieved	
Emercoat 33	No Bond Achieved	
DeSoto Fluoropon	No Bond Achieved	
PPG Duracon S600	No Bond Achieved	
Solvent-based Enamel	Yes	Sikaflex 449 primer
PPG Fluorocarbon	Yes	Sikaflex 449 primer
Duranar	Yes	Sikaflex 449 primer
PPG Polycron	Yes	Sikaflex 449 primer
Kynar	Yes	Sikaflex 449 primer
Siliconized Polyester	Yes	Sikaflex 260 primer
Alucobond	Yes	Sikaflex 260 primer
<b>Plastics</b>		
PVC	Yes	Sikaflex 449 primer
ABS	Yes	Sikaflex 449 primer
Plexiglass	Yes	Sikaflex 449 primer
Plexiglass DR	Yes	Sikaflex 449 primer
Lucite	Yes	Sikaflex 449 primer
Rovel Plastic	Yes	Sikaflex 449 primer

Substrate	Primer Required	Recommended primer if necessary
<b>Plastics cont'd</b>		
Lexan	Yes	Sikaflex 260 primer
Teflon	No Bond Achieved	
Polyethylene	No Bond Achieved	
Polypropylene	No Bond Achieved	
Tuffak	Yes	Sikaflex 449 primer
Polyester/Fiberglass	No	Sikaflex 449 primer
<b>Glass</b>		
Glass - Sheet, float or plate	No	Sikaflex 260 primer
Porcelain	No	Sikaflex 260 primer
Ceramic tile	No	Sikaflex 260 primer
<b>Metals</b>		
Aluminum - AYesdized	No	Sikaflex 260 primer
Aluminum - Mill Finish	No	Sikaflex 260 primer
Lead	No	Sikaflex 260 primer
Copper	No	Sikaflex 260 primer
Brass	No	Sikaflex 260 primer
Zinc	No	Sikaflex 260 primer
Tinplate	No	Sikaflex 260 primer
Steel (Bright/Clean)	No	Sikaflex 260 primer
Steel - Stainless	Yes	Sikaflex 260 primer
Steel - Galvanized	Yes	Sikaflex 260 primer
<b>Rubber</b>		
Urethane	No	Sikaflex 449 primer
<b>Woods</b>		
Unfinished Woods	No	Sikaflex 429 primer
<b>EIFS**</b>		
Dryvit	Yes	Sikaflex 429 primer
Sto	Yes	Sikaflex 429 primer
Synergy	Yes	Sikaflex 429 primer

\*\* Product will bond without primer however primer is recommended by EIFS manufacturers to properly seal substrate. Follow EIFS manufacturer's primer recommendations.

### Typical Data (Material and curing conditions 73°F and 50% R.H.)

<b>Color</b>	Clear
<b>Shelf life</b>	6 months in original, unopened containers.



## How to Use Surface Preparation

The key to good bondability with Sikaflex sealants/primers is surface preparation. Specifically, all surfaces must be dry and free of dirt, grease, mold release agents, loose mortar, laitance, and any foreign matter. If the joint contains old sealant, it and all extraneous material must be removed and the substrate cleaned by mechanical means. Apply primers at substrate temperatures of 40°F and rising. Surface must be frost free.

## Application

Shake or stir primer well before using. Apply to dry, clean, oil free surface with a brush, dauber or spray.

Sikaflex Primer	Dry time before installing sealant	
260/205	>1 hr.	<8 hrs.*
429/202	>1 hr.	<8 hrs.*
449/203	>30 min.	<8 hrs.*

\* If sealant cannot be installed within 8 hours of priming, reprime.

## Limitations

- Primer should not be used if it starts to gel in container.
- Protect Sikaflex primers from moisture. Once container has been opened, use contents immediately.
- Do not attempt to use partial containers.
- Do not reseal or reuse. Resealing may cause moisture contamination and gelling.

## Caution

### Sikaflex Primer 260/205

**Flammable; Irritant; Poison** - Contains methanol. May cause skin/eye/respiratory irritation. Avoid contact. Methanol is a poison and may cause blindness if ingested. Use only with adequate ventilation. Use of safety goggles and chemical resistant gloves is recommended. In case of exceedance of PELs, use an appropriate, properly fitted NIOSH approved respirator. Remove contaminated clothing. Keep away from heat, sparks, and open flames.

### Sikaflex Primer 429/202

**Flammable; Irritant; Sensitizer** - Contains aromatic polyisocyanate, xylene, PGMEA, TDI. May cause skin/eye/respiratory irritation. May cause skin and/or respiratory sensitization after prolonged or repeated contact. Avoid contact. May cause headaches, dizziness or other CNS effects. TDI is a suspect carcinogen (IARC, NTP). Use only with adequate ventilation. Use of safety goggles and chemical resistant gloves is recommended. In case of exceedance of PELs, use an appropriate, properly fitted NIOSH approved respirator. Remove contaminated clothing. Keep away from heat, sparks, and open flames.

### Sikaflex Primer 449/203

**Flammable; Irritant; Sensitizer** - Contains xylene, butyl acetate, methylethyl ketone, toluene. May cause skin/eye/respiratory irritation. May cause skin and/or respiratory sensitization after prolonged or repeated contact. Avoid contact. May cause headaches, dizziness or other CNS effects. Use only with adequate ventilation. Use of safety goggles and chemical resistant gloves is recommended. In case of exceedance of PELs, use an appropriate, properly fitted NIOSH approved respirator. Remove contaminated clothing. Keep away from heat, sparks, and open flames.

## First Aid

In case of skin contact, wash immediately and thoroughly with soap and water. If symptoms persist, consult physician. For eye contact, flush immediately with plenty of water for at least 15 minutes; contact a physician. For respiratory problems, remove person to fresh air; if symptoms persist, consult physician. In case of ingestion, consult a physician immediately - methanol is a poison. Remove contaminated clothing.

## Clean Up

In case of spill or leaks, wear suitable protective equipment, contain spill, collect with absorbent material, and transfer to suitable container. Ventilate area. Avoid contact. Dispose of in accordance with current, applicable, local, state and federal regulations.

### KEEP CONTAINER TIGHTLY CLOSED • KEEP OUT OF REACH OF CHILDREN • NOT FOR INTERNAL CONSUMPTION • FOR INDUSTRIAL USE ONLY

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