



TBP Converting, Inc.  
Sika Primer 206 G+P PDS

# Sika® Primer-206 G+P & Sika® Primer-206 Stix

## Technical Product Data (typical values)

Chemical base	Pigmented solvent-based polyisocyanate solution
Color	Black
Density (uncured)	8.8 lb/gal
VOC content	5.04 lb/gal
VOC content	604 grams / liter
Flash point	25°F (-4°C)
Solid content	40%
Application temperature	41 - 110°F (5- 43°C)
Application method	Brush from can. Direct for Stix
Coverage	0.47 oz/ft <sup>2</sup>
Drying time <sup>1</sup> over 41°F (5°C)	10 min
below 41°F (5°C)	30 min
maximum dry time (temperature independent)	2 hr
Storage	Store in sealed container in a cool dry place
Shelf life (storage between 50 - 75°F (10 - 24°C))	9 months, unopened 250 ml can 13 months, unopened stix

<sup>1)</sup> Allow additional drying time at cooler temperatures or for porous substrates.

### Description

Sika® Primer-206 G+P is a black, moisture-curing liquid primer specifically formulated for the treatment of bond faces in direct glazing work prior to application of Sika® polyurethane direct glazing adhesives and to improve adhesion of other Sika products. Sika® Primer-206 G+P is manufactured in accordance with ISO 9001 / 14001 quality assurance system and with the Responsible Care Program.

### Product Benefits

- One component
- Fast drying
- Wide temperature range
- Available in 250 ml cans or in convenient single use applicator stix

### Areas of Application

Sika® Primer-206 G+P is used to touch-up pinchweld scratches, and also act as a corrosion inhibitor on metals. May also be used when a frit band is not available on the perimeter of the glass part to provide partial UV protection to the polyurethane. It is also used as a general purpose primer which is used to promote adhesion to

- Glass
- FRP
- ABS
- Plastics
- Aluminum
- Steel
- Paints

Industry



### Method of Application

Surfaces must be of sound quality, clean, dry and free from all traces of grease, oil and dust. In most instances, surfaces must be treated with Sika®-Cleaner 226\* or Sika® Aktivator PRO prior to use of Sika®Primer-206 G+P. Sika®Primer-206 G+P may be applied with a dauber, brush, approved flow through applicator or a melamine foam pad. This product is suitable for experienced professional users only. Tests with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

\*Note: Sika®-Cleaner 226 is not appropriate for use in any direct glazing applications.

### 250ml bottle:

Shake the can of Sika®Primer-206 G+P very thoroughly until paint mixing ball is heard to rattle freely. Continue shaking for an additional 10 seconds and then apply a thin but covering coat with a brush or felt pad. Reseal container tightly immediately after use. Ideal application and surface temperature is 41 - 110°F. Allow to dry 10 minutes but not more than 2 hours before applying adhesive.

### Sika®Primer-206 Stix:

Shake individual Stix vigorously prior to use for a minimum of 30 seconds. Point tip toward the ground and pinch the tube just above the tip with thumb and forefinger to break the internal vial and release primer into the tip. With tip down, gently squeeze the tube to wet out the tip being careful not to squeeze too hard creating a drip. When the tip is fully saturated, begin priming the pinchweld immediately. Allow to dry 10 minutes but not more than two hours before applying adhesive.

Note: Sika® Primer-206 G+P may be applied below 40°F, however, required drying time will exceed 10 minutes. Ensure product is dry prior to urethane application.

- Discard any Sika®Primer-206 G+P & Sika®Primer-206 Stix that has gelled or separated, or if it gets limp.
- Do not use 250 ml bottle if primer is gelled or Stix if they are beyond expiration.
- Contact with alcohol will inhibit cure.

### Limitations

Because paints and plastics vary in their chemical composition, preliminary trials are necessary.

- Do not apply on frozen surfaces or through standing water.
- Do not apply over silicones or in the presence of curing silicones.
- Not recommended as a primary UV barrier for marine or other non-automotive applications.
- In general direct glazing applications, Sika®Primer-206 G+P is not intended to be used as the sole form of UV protection
- Discard any product that has gelled or separated
- Contact with alcohol will inhibit cure.
- Sika®Primer-206 G+P 250 ml cans may be used up to 6 months after opening can or the expiration date, or whichever comes first.

**DANGER: EXTREMELY FLAMMABLE, IRRITANT, SENSITIZER:** Contains Ethyl Acetate (CAS 141-78-6), Glycol Ether PM Acetate (CAS 108-68-9), HDI Homopolymer (CAS 28182-81-2), N-Butyl Acetate (CAS 123-86-4), Tris (p-Isocyanatophenyl) Thiophosphate (CAS 4151-51-3), Xylene (CAS 1330-20-7).

**Keep away from heat, sparks, sunlight, electrical equipment, flame or other sources of ignition. VAPORS MAY IGNITE AND EXPLODE. DO NOT SMOKE.** Use only in well ventilated areas. Open doors and windows during use. Causes eye/respiratory irritation. May cause skin irritation. Prolonged and/or repeated exposure may cause skin/respiratory sensitization. Harmful if swallowed. Reports have associated repeated and prolonged exposure to some of the chemicals in this product with permanent brain, liver, kidney and nervous system damage. Headaches and dizziness may result. **Intentional misuse by deliberate concentration and inhalation of vapors may be harmful or fatal.**

### HMIS

Health	*2
Flammability	3
Reactivity	1
Personal Protection	H

**FIRST AID: Eyes** – Hold eyelids apart and flush thoroughly with water for 15 minutes. **Skin** – Remove contaminated clothing. Wash skin thoroughly for 15 minutes with soap and water. **Inhalation**

– Remove to fresh air. **Ingestion** – Do not induce vomiting. Dilute with water. Contact physician. **In all cases contact a physician immediately if symptoms persist.**

### Further Information

Copies of the following publications are available on our website [www.sikaindustry.com](http://www.sikaindustry.com).

- Material Safety Data Sheets
- Product Data Sheet
- Sika Primer Chart
- Instructions for Hot/Cold-Applied Adhesives Technical Training Manual
- General Guidelines for Bonding and Sealing with Sika® Products

### In case of emergency (call)

**Chemtec: 800-424-9300**  
**International: 703-527-3887**

For further information and advice regarding transportation, handling, storage and disposal of chemical products, users should refer to the actual Material Safety Data Sheets containing physical, ecological, toxicological and other safety related data. It is highly recommended to read the actual Material Safety Data Sheet before using the product.

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

### Packaging Information

Can	100 ml
Can	250 ml can
Single Use Stix	1.4 ml

### Value Basis

All technical data stated on this Product Data Sheet are based on the results of laboratory tests only. Actual measured data in the field may vary due to site specific conditions which are not known to Sika and beyond our control.

### Handling & Storage

Keep away from heat, sparks, sunlight, electrical equipment or flame. VAPORS MAY IGNITE AND EXPLODE. DO NOT SMOKE. Open doors and windows during use. Use adequate local and mechanical ventilation. Wear protective equipment (chemical resistant goggles/gloves/clothing) to prevent direct contact with skin and eyes. Use properly fitted NIOSH vapor cartridge respirator.



Sika® Primer-206 G+P & Sika Primer-206

ventilation is poor. Wear personal protective equipment (chemical resistant goggles/gloves/clothing). Wash thoroughly with soap and water after use. Remove contaminated clothing and launder before reuse. Store product in tightly sealed containers in a cool, dry well ventilated area at temperatures between 50°F and 75°F (10°C-24°C) away from ignition sources.

#### Clean up

In case of spill, eliminate all ignition sources. Ventilate area. Open doors and windows. Wear chemical resistant gloves/goggles/clothing. In absence of proper ventilation use properly fitted NIOSH respirator. Confine spill, collect using absorbent material and place in properly sealed container. Dispose of excess product in accordance with applicable local, state and federal regulations.

#### Limited Material Warranty

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. **NO OTHER WARRANTIES IMPLIED OR EXPRESS SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS.**

#### Legal Notes/Disclaimer

All information provided by Sika Corporation ("Sika") concerning Sika products, including but not limited to, any recommendations and advice relating to the application and use of Sika products, is given in good faith based on Sika's current experience and knowledge of its products when properly stored, handled and applied under normal conditions in accordance with Sika's instructions. In practice, the differences in materials, substrates, storage and handling

conditions, actual site conditions and other factors outside of Sika's control are such that Sika assumes no liability for the provision of such information, advice, recommendations or instructions related to its products, nor shall any legal relationship be created by or arise from the provision of such information, advice, recommendations or instructions related to its products. The user of the Sika product(s) must test the product(s) for suitability for the intended application and purpose before proceeding with the full application of the product(s).

Sika reserves the right to change the properties of its products without notice.

Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, product label and Material Safety Data Sheet which are available at [www.sika.com](#). Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instruction for each Sika product as set forth in the current Product Data Sheet, product label and Material Safety Data Sheet prior to product use.



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