

PRODUCT DATA SHEET

Sika Primer-503

PRIMER FOR METAL STANDS

DESCRIPTION

Metal primer allows to increase performances of bonded metallic assemblies such as degreased steel, phosphated steel or aluminium.

PROPERTIES

- One component primer
- Fast drying

PHYSICAL PROPERTIES

Aspect	Liquid
Colour	Ocre
Density	1.03 ± 0.03
Solid content by weight	35 ± 0.03 %

DRYING TIME ⁽¹⁾

Touch dry	10 to 15 min at 23 °C / 50% HR
Drying time before recovering	25 to 30 min at 23 °C / 50% HR
Complete drying	6 h at 23 °C / 50% HR
Oven drying	20 min at 50 °C or 10 min at 100°C

(1) For a primer film with thickness 20 µm

APPLICATION CONDITIONS

Temperature	10°C to 35 °C
Maximal Hygrometry	75 %

PROCESSING

- Before use of the primer, for maximum performances, the surface to be bonded must be clean and dry. The previous application of the Adekit Cleaner is recommended in order to get a surface free from contaminants (dust, grease, etc).
- **Then, follow instructions:**
 - **Shake the bottle of Primer before use**
 - **Close it immediately after use**
 - **The product must be used within the recommended period**
- Sika Primer-503 can be applied with a paintbrush without thinning or with an airless gun. Allow primer to dry before applying the adhesive.

HANDLING PRECAUTIONS

Normal health and safety precautions should be observed when handling these products:

- Ensure good ventilation.
- Wear gloves, glasses and protective clothes.

For further information, please consult the Safety Data Sheets.

STORAGE CONDITIONS

This product can be stored 12 months in a dry place in original unopened containers at a temperature between 15 to 25°C.

PACKAGING

- Sika Primer-503 1 litre

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 Advanced Resins. Copies of the following publications are available on request: Safety Data Sheets.

VALUE BASES

All technical data stated in this Product Data Sheet 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.

LEGAL NOTICE

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 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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