

## PRODUCT DATA SHEET

# Sika® Primer-503

Pigmented, solvent-based primer for metal substrates

**TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)**

Chemical base	Solvent-based Epoxy solution
Color (CQP001-1)	Ochre
Solid content	35 %
Application temperature	5 – 40 °C
Application method	Brush or foam applicator
Consumption	depending on substrate porosity 50 ml/m <sup>2</sup>
Flash-off time	minimum 30 minutes <sup>A</sup> maximum 8 hours <sup>A</sup>
Shelf life	12 months <sup>B</sup>

CQP = Corporate Quality Procedure <sup>A)</sup> in specific application, temperature and flash-off time may be different

<sup>B)</sup> stored in sealed container in up-right position in a dry place at ≤ 25 °C, protected from sunlight

**DESCRIPTION**

Sika® Primer-503 is a solvent-based ochre primer, which reacts with moisture and forms a thin layer. This layer acts as a link between substrates and adhesives. Sika® Primer-503 is specifically formulated for the treatment of bond faces prior to application of Sika's adhesives (SikaForce®, SikaPower®). This primer might provide excellent adhesion without previous activation step on certain substrates.

**PRODUCT BENEFITS**

- 1-component primer
- Fast drying
- Easy to use

**AREAS OF APPLICATION**

Sika® Primer-503 is used to improve adhesion on metals like degreased steel, phosphated steel or aluminum. Sika® Primer-503 is not suitable as an anticorrosion paint. This product is suitable for experienced professional users only. Tests with actual substrates and conditions have to be performed ensuring adhesion and material compatibility.

METHOD OF APPLICATION

Surfaces must be clean, dry and free from grease, oil, dust and contaminants. Adhesion on substrates may be improved by adding and/or combining pre-treatment processes such as scuffing, cleaning and activating.

Application

Shake the Sika® Primer-503 can very thoroughly until mixing ball rattles freely. Continue shaking for another minute and apply a thin but covering coat with a brush or foam applicator. Ideal application and surface temperature are between 15 °C and 25 °C. Sika® Primer-503 has to be applied once only. Care must be taken to ensure that this single application gives adequately dense coverage. The primer has to be applied in a very thin layer. Consumption and method of application depend on the specific nature of the substrates. Tightly reseal container immediately after each use.

IMPORTANT NOTE

Sika® Primer-503 is a moisture reactive system. In order to maintain product quality it is important to reseal the container with the inner plastic liner immediately after use. Once the surface pre-treatment operation is completed, the cap has to be screwed on. Dispose of product approx. one month after opening if used frequently or after two months in case of infrequent use. If gelling, separation or a significant increase in viscosity is noted, discard the primer immediately. Never dilute or mix this product with any other substances described in this document.

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 Industry. Copies of the following publications are available on request:

- Safety Data Sheets

PACKAGING INFORMATION

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BASIS OF PRODUCT DATA

All technical data stated in this document 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.

DISCLAIMER

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.

