

## Surface pre and post treatment Primer, Cleaner

### Areas of Application

- For pretreatment and cleaning of surfaces at manufacture of mouldings, models and negatives in model, tool and mould making

### Description

- **Icosit® KC330 Primer**

#### Processing Data

Colour	yellowish-transparent, colourless drying	
Description	low viscosity one-component-PUR-system	
Density	g/cm <sup>3</sup>	1.0
Consumption	g/m <sup>2</sup>	50 - 200 (coating by brush)
Drying time	min	60 - 120
Main application	for increasing of adhesion of PUR-synthetic resins on grinded metal and different plastic surfaces	

- **Sika® Coating Activator**

#### Processing Data

Colour	colourless, clear	
Description	solvent based primer	
Density	g/cm <sup>3</sup>	~ 0.7
Consumption	g/m <sup>2</sup>	30 (with cotton cloth/paper mat)
Drying time	min	10
Main application	for increasing of adhesion at bonding of SikaBlock tooling boards with PUR adhesives (e. g. Biresin Kleber® blau for SikaBlock® M960)	

- **Sika® Aktivator-205 (Cleaner-205)**

#### Processing Data

Colour	colourless	
Description	one-component alcohol solvent containing a bond-activating substance	
Density	g/cm <sup>3</sup>	~ 0.8
Consumption	g/m <sup>2</sup>	~ 50 (with brush or lint-free paper towel)
Drying time	min	> 10 (max. 2 h)
Main application	for increasing of adhesion of PUR-synthetic resins, e. g. Biresin® U1320 NT on nonporous, grinded Aluminium surfaces	

## ■ Sika® Reinigungsmittel 5

Processing Data	
Colour	clear-transparent
Description	mild, ecological solvent mixture
Density	g/cm <sup>3</sup> ~ 0.8
Main application	Cleaning of devices and surfaces, e. g. from release agent remains

Packaging		
Individual components	<b>Icosit® KC330 Primer</b>	3 l
	<b>Sika® Primer-3 N</b>	1 l, 0.25 l
	<b>Sika® Cleaner-205</b>	5 l; 1 l, 0.25 l
	<b>Sika® Reinigungsmittel 5</b>	10 l; 5 l; 1 l; 0.25 l

- ### Processing
- The material, processing and substrate temperature must be from 18 to 25°C.
  - Pay attention to the processing conditions of the SikaBlock® board materials, Biresin® resins and auxiliary materials.

- ### Storage
- Minimum shelf life is 12 month under room condition (18 - 25°C), when stored in original un-opened containers.
  - Containers must be closed immediately after use. The residual material has to be used up as soon as possible.

### Health and Safety Information

For information and advice on the safe handling, storage and disposal of chemical products, users shall refer to the most recent Safety Data Sheet (SDS) containing physical, ecological, toxicological and other safety related data.

### Disposal considerations

Product Recommendations: Must be disposed of in a special waste disposal unit in accordance with the corresponding regulations.  
Packaging Recommendations: Completely emptied packagings can be given for recycling. Packaging that cannot be cleaned should be disposed of as product waste.

### 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.

### 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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