PRE-TREATMENT CHART Sikaflex®-200 AND SikaTack® SERIES

VERSION 7 (08/2016)

Substrate	Mechanical 1	Adhesion Promoter / Cleaner	Primer	Mechanical 2	Adhesion Promoter	Primer	3
Aluminum (AlMg3, AlMgSi1 and similar)	AP-C AP-C	SA-100	 SP-207	AP-C AP-C	SA-205	SP-204 N SP-207	
Aluminum (anodized)		SA-100	 SP-207	 AP-C	SA-205	SP-204 N SP-207	
Steel (mild)		SA-205 SA-100	SP-204 N SP-206 GP	AP-C AP-C	SA-205	SP-204 N SP-207	
Steel (stainless)		SA-100	 SP-207	AP-C AP-C	SA-205	SP-204 N SP-207	
Steel (hot-dip galvanized, electrogalvanized)		SA-205	 SP-207	AP-C AP-C	SA-205	SP-204 N SP-207	
Non-ferrous metals (copper, brass, bronze,...)	AP-C	SA-205	SP-210	AP-C	SA-205	SP-210	
Two-component top coat, water- and solvent based (PUR, acrylic)		SA-100	 SP-207			SP-207 SP-206 GP	
Powder coat (Polyester (PES), EP/PES)		SA-100	 SP-207	AP-C AP-C		SP-207 SP-206 GP	
Two-component paint primer, water- and solvent based (PUR, acrylic, epoxy)		SA-100	 SP-207			SP-207 SP-206 GP	
Cathode dip coating (e-coating)		SCP SA-100				SP-207	
Coil coating, mainly Polyester		SA-205 SCA		AP-C	SA-205 SCA	 SP-206 GP	
FRP (unsaturated polyester) gelcoat side or SMC		SA-100	 SP-207	AP-C	SA-100	 SP-207	
FRP (unsaturated polyester) lay-up side	AP-C AP-C		SP-207 SP-206 GP	GR-V GR-V		SP-207 SP-215	
FRP (Epoxy-matrix), CFRP	AP-C AP-C		SP-207 SP-206 GP	AP-C AP-C		SP-207 SP-206 GP	
ABS			SP-209 D SP-206 GP		SA-100 SA-100	SP-209 D SP-206 GP	
Hard PVC			SP-215 SP-207		SA-205	SP-215 SP-207	
PMMA/PC (without anti-scratch coating)			SP-209 D SP-207	AP-C AP-C		SP-209 D SP-207	
Glass			SP-207 SA-100			SP-207 SA-100	
Ceramic screen print			SP-207 SA-100			SP-207 SA-100	
Wood / Plywood						SP-215	

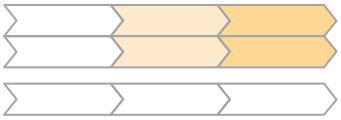
CONTACT SIKA TECHNICAL DEPARTMENT INDUSTRY

PRECONDITION:
Surfaces have to be clean, dry and free of oil, fat, dust and loose particles. Depending on the nature of soiling, Sika® Remover-208, Sika® Cleaner P, water based cleaners or steam washer, etc. may be used. For soiled substrates, it might be necessary to grind the surface down to sound material. Verify compatibility with cleaning products.

Levels	Description
1	■ General sealing applications, small components with low level of stress exposure ■ Non-structural interior bonding applications, no exposure to temperature extremes, no contact with water
2	■ Sealing applications involving large components where higher joint movements are to be expected ■ Interior and exterior bonding applications under normal environmental conditions
3	■ Other applications, not covered under Level 1 and 2, where additional requirements are specified ■ Serial application

Abbreviation	Product/Explanation
AP-C	Abrasive Pad, very fine (e.g. from 3M) + cleaning step by dry wipe, SCP or similar
GR-V	Grinding (60 – 80 grit) and vacuum cleaning
SCP	Sika® Cleaner P
SA-100	Sika® Aktivator-100
SA-205	Sika® Aktivator-205
SCA	Sika® Coating Aktivator
SP-204 N	Sika® Primer-204 N
SP-206 GP	Sika® Primer-206 G+P
SP-207	Sika® Primer-207
SP-209 D	Sika® Primer-209 D
SP-210	Sika® Primer-210
SP-215	Sika® Primer-215

* **Note:** Product name was changed from Sika® Aktivator to Sika® Aktivator-100



1st Process = Recommended process
2nd Process = Alternative

No surface preparation required, but preconditions must be respected.