

PRODUCT DATA SHEET

SikaMelt®-285 Primer

Hot melt primer for foam injected panels

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Chemical base	Thermoplastic rubber
Color (CQP001-1)	Light honey color, clear or opaque
Cure mechanism	Physical hardening
Density	0.98 kg/l
Viscosity (by Brookfield)	at 190 °C 7 000 mPa·s
Softening temperature (CQP538-5)	132 °C
Application temperature	170 – 190 °C short term max. 1 hour 200 °C ^A
SAFT (CQP560-1)	100 °C
Coverage	30 – 50 g/m ²
Shelf life	24 months

CQP = Corporate Quality Procedure

^{A)} only valid for nozzle**DESCRIPTION**

SikaMelt®-285 Primer is a thermoplastic hot applied primer product with 100 % solids content. It is formulated as an adhesion promoter for foam injected panels.

PRODUCT BENEFITS

- Solvent and Isocyanate free
- Good adhesion on metals and plastics
- High cohesion
- Very high heat resistance
- Good hydrolysis resistance

AREAS OF APPLICATION

SikaMelt®-285 Primer is used to give improved adhesion of injected foams to coated and bare metallic and various plastic surfaces. The product is designed as an alternative to isocyanate primer systems used for foam injected panels.

SikaMelt®-285 Primer is not to be used on substrates containing monomeric plasticizer. This product is suitable for experienced professional users only. Tests with actual substrates and conditions have to be performed ensuring adhesion and material compatibility.

CURE MECHANISM

SikaMelt®-285 Primer is a physically hardening primer.

CHEMICAL RESISTANCE

SikaMelt®-285 Primer is resistant to aqueous surfactant solutions, weak acids and caustic solutions.

The chemical resistance is influenced by several factors such as chemical composition, concentration, period of exposure and temperature. Therefore a project related testing in case of chemical or thermal exposure is required.

METHOD OF APPLICATION

Surface preparation

Surfaces must be clean, dry and free from grease, oil and dust.

Based on the surface and type of material, a physical or chemical pre-treatment might be required. Type of pre-treatment must be determined by preliminary tests.

Application

SikaMelt®-285 Primer is applied directly on the substrate. It can be applied as film or by spray application.

For automated applications a suitable filter system is required.

To meet the required application properties the adhesive viscosity can be adjusted by adapting the application temperature (see diagram 1).

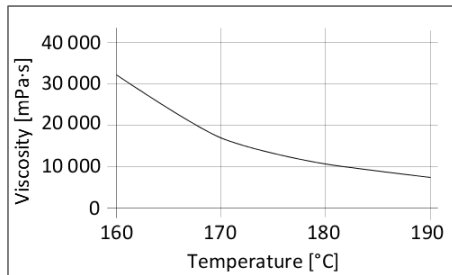


Diagram 1: Viscosity as function of temperature

During breaks SikaMelt®-285 Primer is to be processed as follows:

For breaks ≥ 1 h the heating needs to be lowered to 80 °C and for breaks ≥ 4 h the heating needs to be switched off.

To ensure a constant quality during the whole production process it is recommended to protect the adhesive in the melting tank with nitrogen or carbon dioxide (to avoid possible reaction of the product with oxygen).

For advice on selecting and setting up suitable processing equipment contact the System Engineering Department of Sika Industry.

Removal

SikaMelt®-285 Primer may be removed from tools and equipment with Sika® Remover-208 or another suitable solvent.

Hands and exposed skin have to be washed immediately using hand wipes such as Sika® Cleaner-350H or a suitable industrial hand cleaner and water.

Do not use solvents on skin.

STORAGE CONDITIONS

SikaMelt®-285 Primer has to be stored at temperature below 40 °C in a dry place.

For transportation purposes, the storage temperature can be exceeded for a period of max. 4 weeks up to 60 °C.

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

Drum	170 kg
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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 enduse 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.