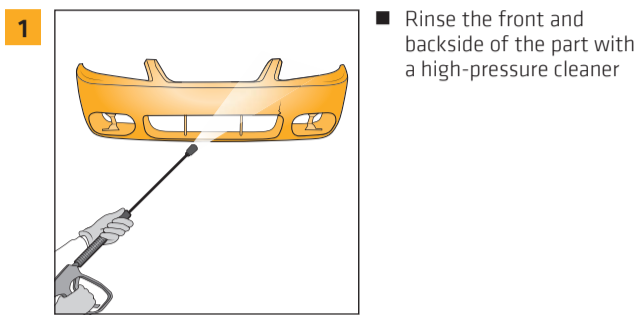
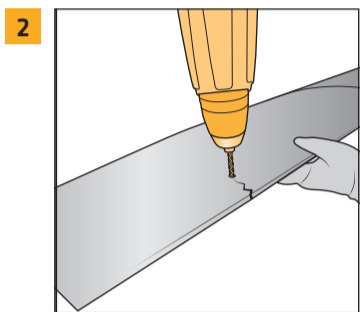


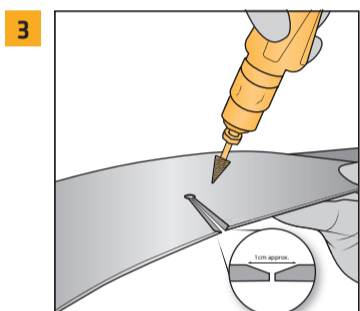
SIKA PLASTIC ADHESIVE FAST REPAIR OF PLASTIC BUMPER



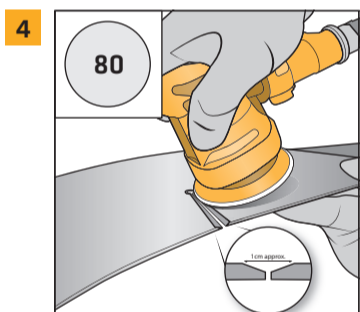
- 1 Rinsing the front and backside of the part with a high-pressure cleaner



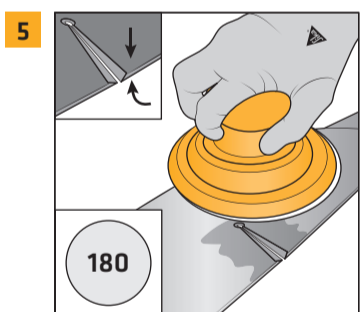
- 2 Drilling a hole at the end of the crack on the front



- 3 Milling a V-groove (approx. 1 cm wide) into the side edges from the front side



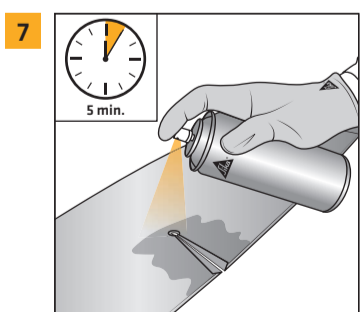
- 4 Roughening the surface of the V-groove with 80 grit sandpaper



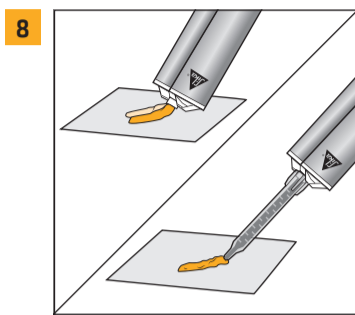
- 5 Sanding the surfaces on the front and backside with 180 grit sandpaper



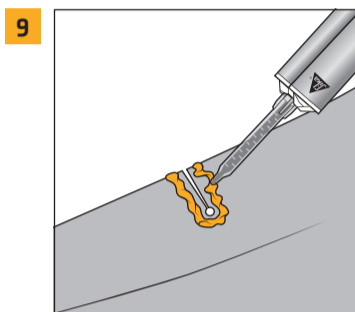
- 6 Clean entire work area using Sika Cleaner G+P, making sure the surface is completely dry and no moisture remains



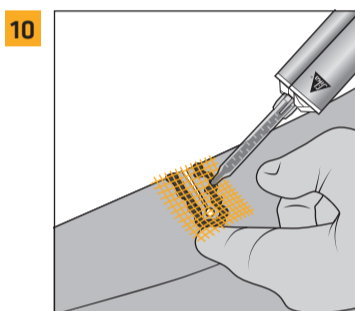
- 7 Spray a thin coat of Plastic Primer on both sides, flash-off for 5 min¹⁾



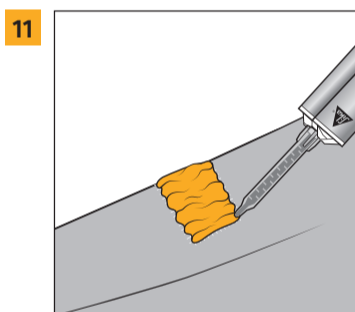
- 8 Before attaching mixer, extrude some material until both parts A and B flow evenly
- 8 Attach static mixer and dispense one third of mixer length



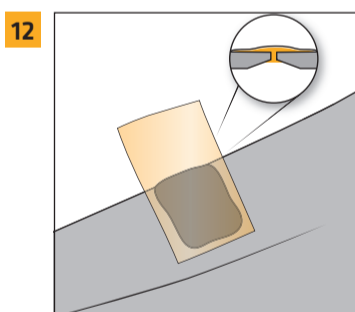
- 9 Apply Plastic Adhesive Fast around the crack to the backside of the part



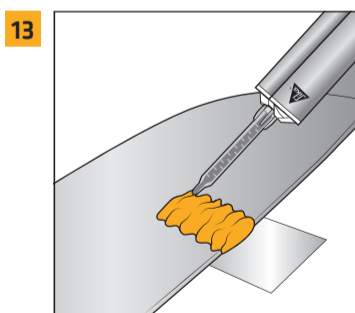
- 10 Position the pre-cut reinforcement mesh into the applied adhesive



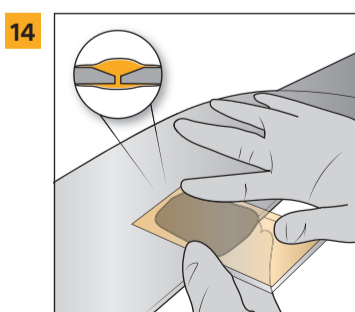
- 11 Apply the adhesive bubble-free on the reinforcement film until it is completely covered



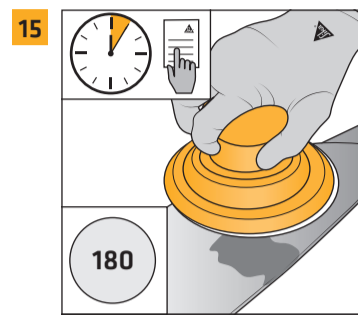
- 12 Cover the adhesive with the Sika Contouring Film
- 12 Spread the adhesive with a spatula or manually from the middle to the edges to avoid blistering



- 13 Fill the damaged area on the front side bubble-free with adhesive



- 14 Cover the adhesive with the Sika Contouring Film
- 14 Spread the adhesive with a spatula or manually from the middle to the edges to avoid blistering



- 15 Sand the surface and proceed with filling and painting
- 15 Respect curing time¹⁾ as per product label



PLASTIC ADHESIVE FAST SikaForce®-301

Article No.	736294
Working Time ¹⁾	3.5 min
Clamp Time ¹⁾	15 min
Sanding Time ¹⁾	30 min
Content	50 ml + 3 mixers
Mixing Ratio	1:1
Color	Black

ACCESSORIES	Article No.	Content	Box Content
Sika Cleaner G+P	527420	500 ml	12 pc
SikaForce®-300 Primer	736000	200 ml	6 pc
Sika Contouring Film	505296	360 cm	30 pc
Sika Reinforcement Mesh	505297	360 cm	20 pc
Sika Mixer Quadro 73mm	751521	12 pc / bag	20 bags
Sika Dispensing Gun	512113	-	1

¹⁾ All time indications are related to 23°C (ambient and substrate). Product curing behavior is temperature dependent and increases with higher temperature and vice versa. Curing speed might be accelerated by using infrared lamps or ovens. However, it must be ensured that the applied adhesive does not heat up to more than 50 °C as higher temperature can lead to blistering.

Our most current General Sales Conditions shall apply.
Please consult the most current local Product Data Sheets prior to any use.

www.sika.com/aftermarket

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