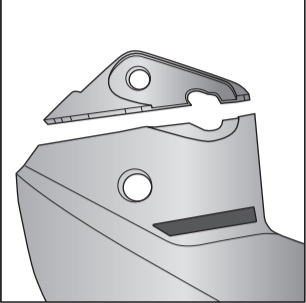
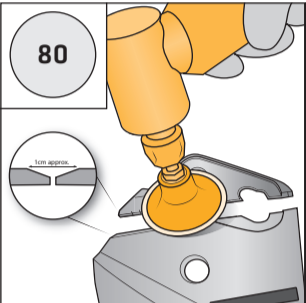

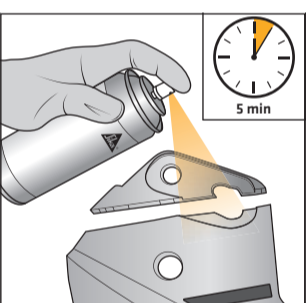
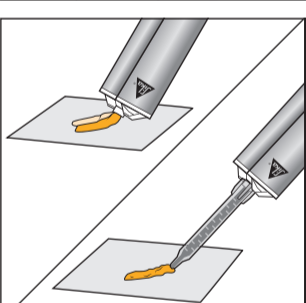
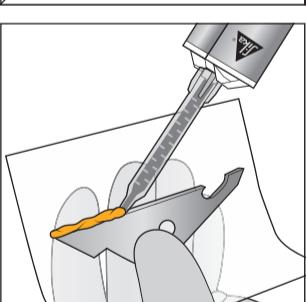
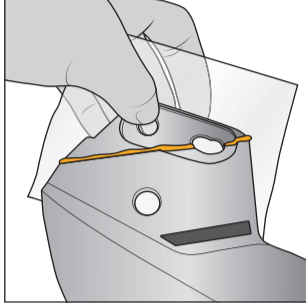
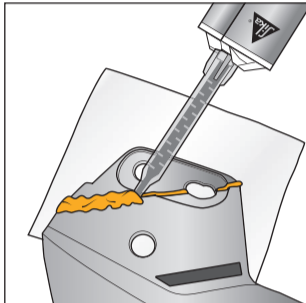
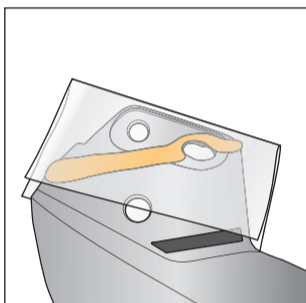


# SIKA PLASTIC ADHESIVE SUPERFAST BONDING OF PLASTIC PARTS

- 
  - Damage: a broken piece of plastic
- 
  - Grind a V-groove (1 cm approx.) into the side edges, use 80 grit sandpaper
- 
  - Clean entire work area using Sika® Cleaner G+P, making sure the surface is completely dry and no moisture remains
- 
  - Spray a thin coat of Plastic Primer on both sides, flash-off for 5 min<sup>1)</sup>
- 
  - Before attaching mixer, extrude some material until both parts A and B flow evenly
  - Attach static mixer and dispense one third of mixer length
- 
  - Position the broken part on the Sika Contouring Film and apply Plastic Adhesive Superfast on the breaking point
- 
  - Fix both parts
- 
  - Fill up the break with adhesive
- 
  - Bend the film and compress adhesive and wait for adhesive to be cured according to product label



## PLASTIC ADHESIVE SUPERFAST SikaForce®-302

Article No.	736291
Working Time <sup>1)</sup>	90 sec
Clamp Time <sup>1)</sup>	5 min
Sanding Time <sup>1)</sup>	10 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

<sup>1)</sup> 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](http://www.sika.com/aftermarket)

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