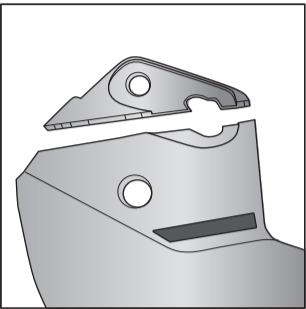
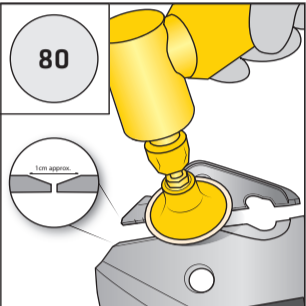

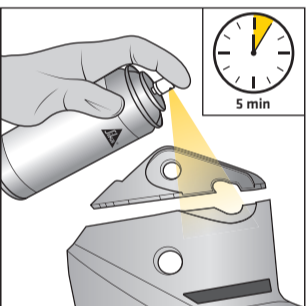


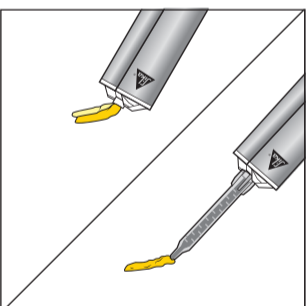
# SIKA PLASTIC ADHESIVE SUPERFAST AND ULTRAFAST BONDING OF PLASTIC PARTS

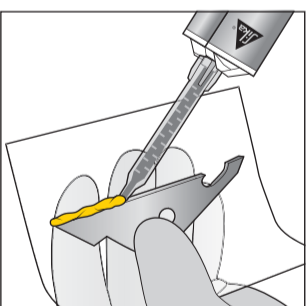
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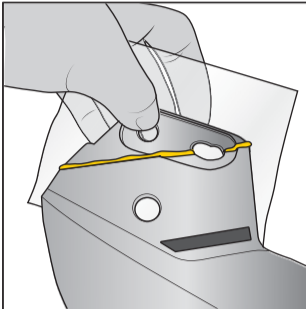
1 ■ Damaged plastic part
- 

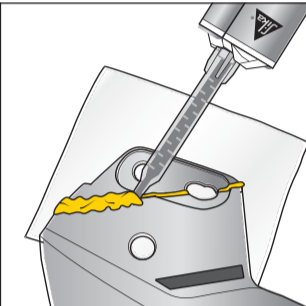
2 ■ Grind a V-groove (1 cm) along the side edges using 80 grit sandpaper
- 

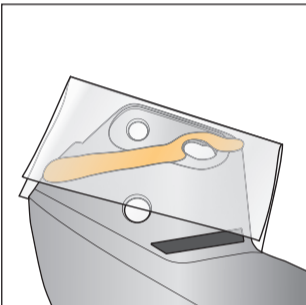
3 ■ Thoroughly clean the entire work area with Sika® Cleaner G+P, ensuring it is completely dry and free of moisture
- 

4 ■ Spray a thin coat of Plastic Primer on both sides and allow it to flash-off for 5 min <sup>1)</sup>
- 

5 ■ Prepare adhesive: Before attaching the mixer, extrude material until both parts A and B flow evenly.  
■ Attach the static mixer and dispense one third of its mixer length to ensure homogeneous mixing
- 

6 ■ Position the broken part on the Sika Contouring Film and apply Plastic Adhesive Superfast or Plastic Adhesive Ultrafast directly to the break
- 

7 ■ Align and fix both parts together
- 

8 ■ Fill the break completely with adhesive
- 

9 ■ Bend the film to compress the adhesive and allow it to cure



	PLASTIC ADHESIVE SUPERFAST SikaForce®-302	PLASTIC ADHESIVE ULTRAFAST SikaForce®-303
Article No.	736291	839192
Working Time <sup>1)</sup>	90 sec	30 sec
Clamp Time <sup>1)</sup>	5 min	3 min
Sanding Time <sup>1)</sup>	10 min	5 min
Content	50 ml + 3 mixers	50 ml + 3 mixers
Mixing Ratio	1:1	1:1
Color	Black	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 73 mm	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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