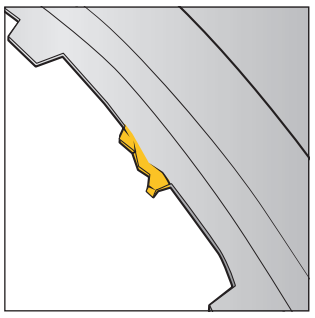
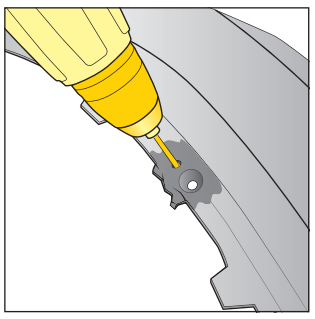
# SIKA PLASTIC ADHESIVE SUPERFAST AND ULTRAFAST
# RESHAPE AND MODEL PLASTIC CLIPS

**1**



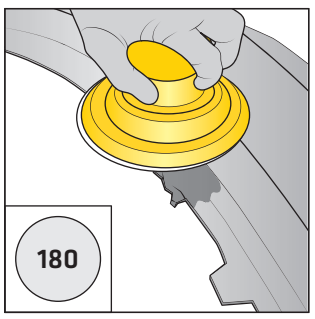
- Damage: a broken plastic clip

**2**



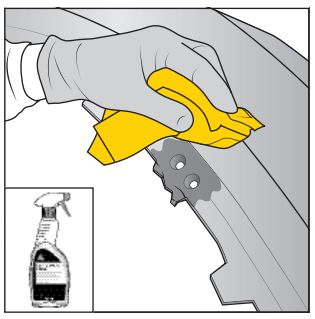
- Drill several holes with V-Neck shape

**3**



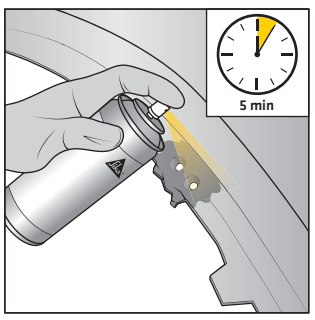

- Sand the area around the broken clip on the front and backside, use 180 grit sandpaper

**4**



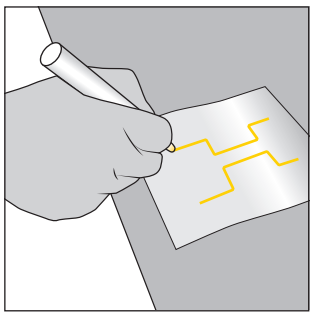
- Thoroughly clean the entire work area using Sika® Cleaner G+P, ensuring it is completely dry and free of moisture

**5**



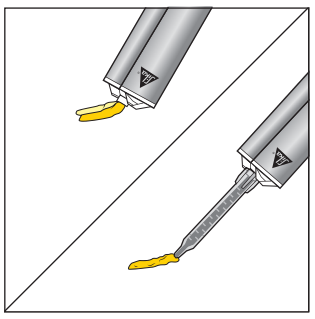

- Spray a thin coat of Plastic Primer on both sides, flash-off for 5 min[1)]

**6**



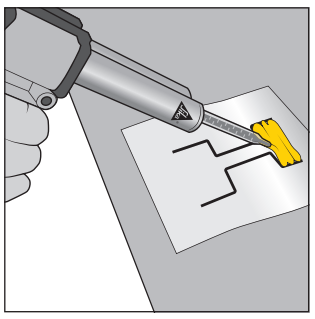
- Draw the shape of the clip and bonding-areas on the Sika Contouring Film

**7**



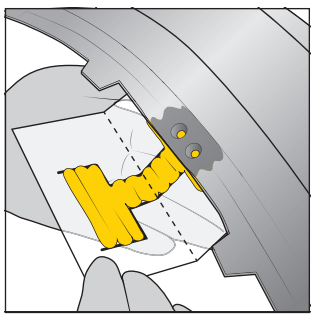
- Before attaching mixer, extrude some material until both parts A and B flow evenly
- Attach static mixer and dispense one third of it's length to ensure homogenous mixing

**8**



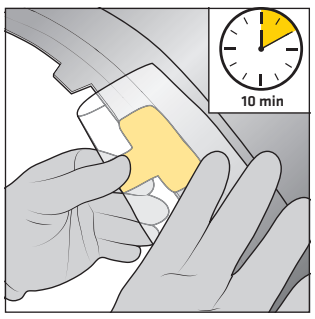
- Apply Plastic Adhesive Superfast or Plastic Adhesive Ultrafast within the marked area, consider the corresponding working time

**9**



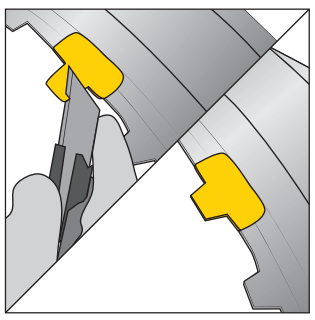
- Press the Contouring Film with the adhesive on the backside of the area and bend it in the middle

**10**




- Press other side on the top and wait for curing

**11**



- Once cured, cut the new clip to the required shape. The adhesive can be cut to shape more easily before it is fully cured

| | PLASTIC ADHESIVE SUPERFAST SikaForce®-302 | PLASTIC ADHESIVE ULTRAFAST SikaForce®-303 |
|---|---|---|
| Article No. | 736291 | 839192 |
| Working Time[1)] | 90 sec | 30 sec |
| Clamp Time[1)] | 5 min | 3 min |
| Sanding Time[1)] | 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 |

[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**

**BUILDING TRUST**