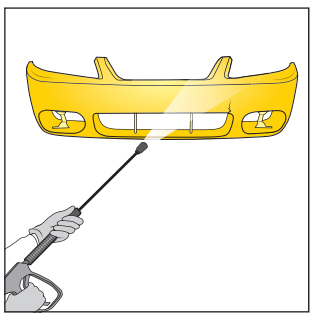
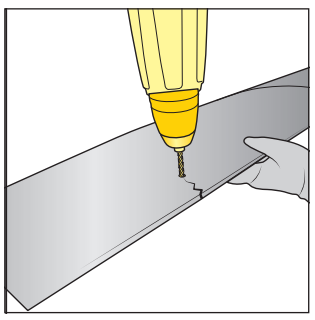
SIKA PLASTIC ADHESIVE FAST
REPAIR OF PLASTIC BUMPER

1



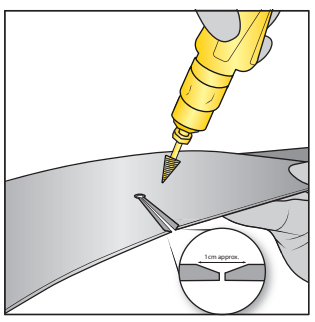
- Rinse the front and backside of the part with a high-pressure cleaner

2



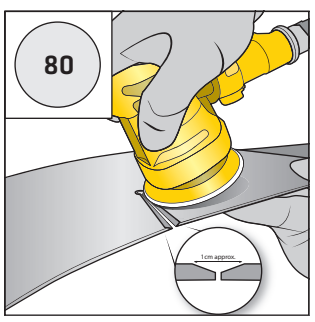
- Drill a hole at the end of the crack on the front

3



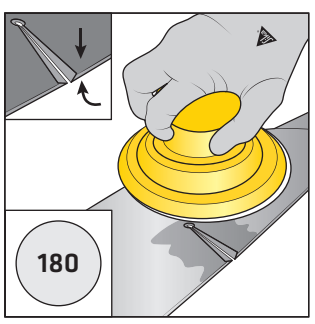
- Mill a V-groove (approx. 1 cm wide) into the side edges from the front side

4



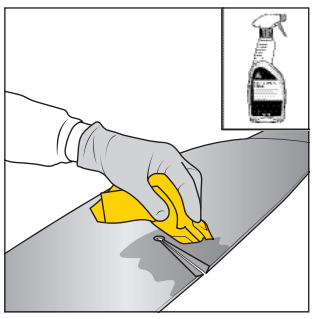
- Roughen the surface of the V-groove with 80 grit sandpaper

5



- Sand the surfaces on the front and backside with 180 grit sandpaper

6



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

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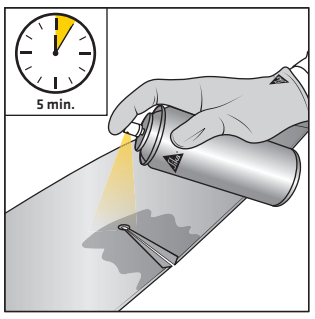
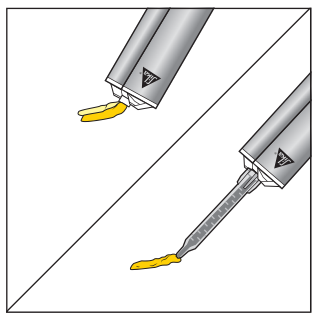


- Spray a thin coat of Plastic Primer on both sides and let it flash-off for 5 min [1)]

8



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

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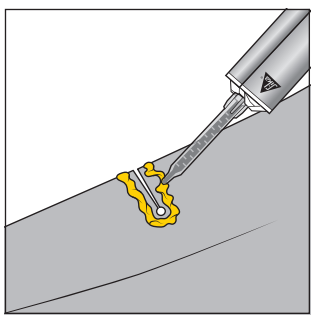

- Apply Plastic Adhesive Fast around the crack to the backside of the part

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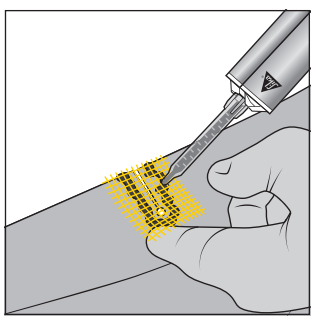

- Position the pre-cut reinforcement mesh into the adhesive

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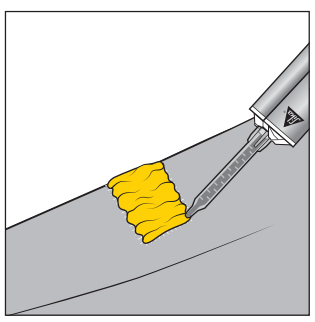

- Apply the adhesive bubble-free on the reinforcement film mesh until it is completely covered

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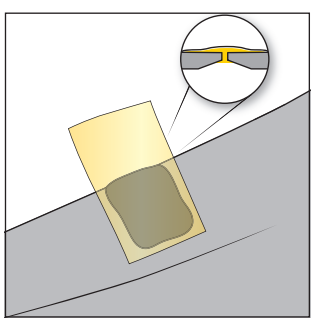
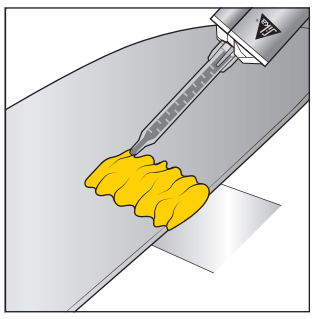


- Cover the adhesive with the Sika Contouring Film
- Spread the adhesive with a spatula or manually from the middle to the edges to avoid blistering

13



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

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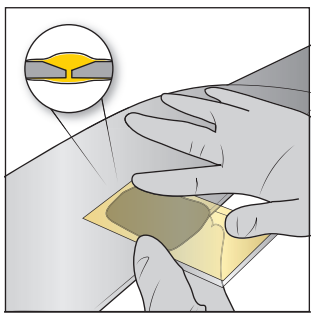
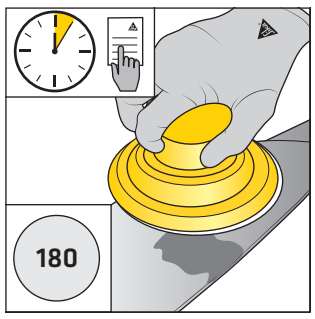


- Cover the adhesive with the Sika Contouring Film
- Spread the adhesive with a spatula or manually from the middle to the edges to avoid blistering. Allow the adhesive to cure

15



- After curing, sand the surface and follow the OEM guidelines or the paint manufacturer's guidelines for the further repair process.

	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 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

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