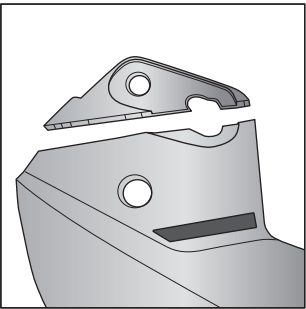


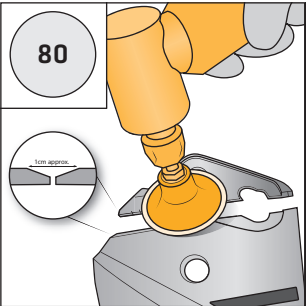
# SIKA PLASTIC ADHESIVE SUPERFAST

## BONDING OF PLASTIC PARTS

- 1



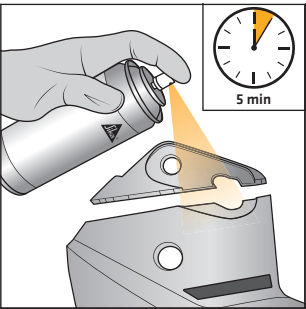
■ Damage: a broken piece of plastic
- 2



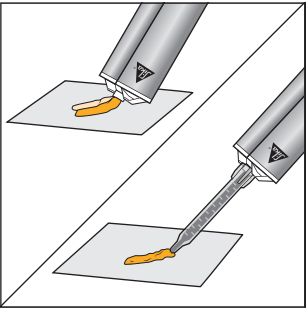
■ Grind a V-groove (1 cm approx.) into the side edges, use 80 grit sandpaper
- 3



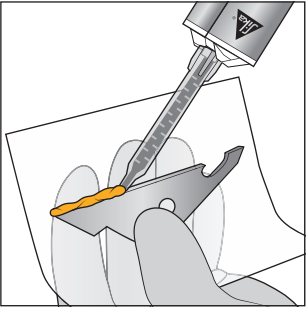
■ Clean entire work area using Sika® Cleaner G+P, making sure the surface is completely dry and no moisture remains
- 4



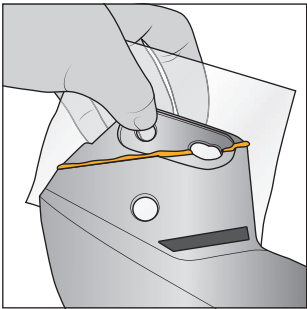
■ Spray a thin coat of Plastic Primer on both sides, flash-off for 5 min<sup>1)</sup>
- 5



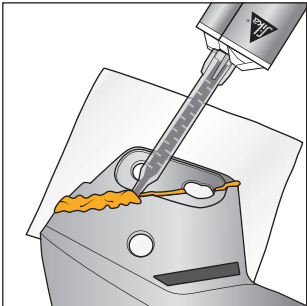
■ Before attaching mixer, extrude some material until both parts A and B flow evenly  
■ Attach static mixer and dispense one third of mixer length
- 6



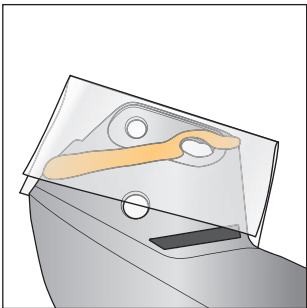
■ Position the broken part on the Sika Contouring Film and apply Plastic Adhesive Superfast on the breaking point
- 7



■ Fix both parts
- 8



■ Fill up the break with adhesive
- 9



■ 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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