

## PRODUCT DATA SHEET

# SikaForce®-302

Purform® based superfast-curing plastic repair adhesive

**TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)**

Properties	SikaForce®-302 (A)	SikaForce®-302 (B)
Chemical base	Polyol	Isocyanate
Colour (CQP001-1)	Black	White
	mixed	Black
Density	1.29 kg/l	1.21 kg/l
	mixed	1.25 kg/l
Mixing ratio	by volume 1 : 1	
Non-sag properties	Good	
Application temperature	15 – 30 °C	
Working time	1.5 minutes <sup>A</sup>	
Mixer open time	45 seconds <sup>A</sup>	
Clamp time	5 minutes <sup>A</sup>	
Sanding time	10 minutes <sup>A</sup>	
Shore D hardness (ASTM D2240)	73	
Tensile strength (ISO 527)	26 MPa	
Elongation at break (ISO 527)	58 %	
Shelf life	24 months	

CQP = Corporate Quality Procedure

<sup>A)</sup> 23 °C / 50 % r.h.

**DESCRIPTION**

SikaForce®-302 (Purform®) is based on Purform®, an industry-leading polyurethane with less than 0.1 % monomeric diisocyanate for better health protection and occupational safety.

SikaForce®-302 (Purform®) is specifically designed to repair plastic parts in an automotive workshop. It provides good adhesion on various plastic types and is over-paintable with nearly all types of paint.

**PRODUCT BENEFITS**

- Less than 0.1 % monomeric diisocyanate for better health protection and occupational safety
- Good adhesion on a wide variety of substrates
- Very fast curing at room temperature
- Suitable to sand after just 10 minutes
- Over paintable
- No sagging or dripping
- No shrinkage

**AREAS OF APPLICATION**

SikaForce®-302 (Purform®) is used in the automotive workshop for plastic repair work such as damage on bumpers, bonding of plastic parts and brackets, recreating of plastic clips, or filling of unused sensor openings and small holes.

This product is suitable for experienced professional users only. Tests with actual substrates and conditions have to be performed ensuring adhesion and material compatibility.

## CURE MECHANISM

The curing of SikaForce®-302 (Purform®) takes place by chemical reaction of the two components. It cures at ambient temperature. The curing speed can be accelerated by temperature using infrared lamps or ovens for a minimum of 5 minutes. However, it must be ensured that the applied adhesive does not heat up to more than 50 °C.

## METHOD OF APPLICATION

### Surface Preparation

Clean and degrease entire bonding surfaces widely with Sika® Cleaner G+P and a clean towel. Afterwards abrade surfaces with 80 – 180 grit sanding paper.

Clean entire bonding surfaces once again with Sika® Cleaner G+P and a clean towel. Make sure the surface is completely dry and no moisture remains before the next process step.

Spray a thin coat SikaForce®-300 Primer on both sides and flash off for at least 5 minutes. Additional surface treatment depends on the specific nature of the substrates.

### Application

SikaForce®-302 (Purform®) has to be processed between 15 °C and 30 °C (product, ambient, and substrate temperature).

Extrude the adhesive without the mixer to equalize the levels. Attach the static mixer, dispense one-third of the mixer length, and dispose of it prior to starting the adhesive application onto the bonding surfaces.

Dispense SikaForce®-302 (Purform®) with adequate piston guns. In order to achieve proper mixing, Mixer Tips for SikaForce®-302 (part of the packaging and sold separately) are required.

After dispensing, leave the mixer on the cartridge until the adhesive is used again. The remainder of the adhesive will have a shelf life of several weeks if stored properly.

To start using SikaForce®-302 (Purform®) again, remove the static mixer and dispose of it properly. Carefully clean the cartridge outlet. Afterwards, connect a new mixer and start dispensing as described above.

Sika Contouring Film and Reinforcement Mesh are available for reshaping and modeling tasks.

### Removal

Uncured SikaForce®-302 (Purform®) may be removed from tools and equipment with Sika® Remover-208 or another suitable solvent. Once cured, the material can only be removed mechanically.

Hands and exposed skin have to be washed immediately using hand wipes such as Sika® Cleaner-350H or a suitable industrial hand cleaner and water.

Do not use solvents on skin.

### STORAGE CONDITIONS

Uncured SikaForce®-302 (Purform®) has to be kept between 15 °C and 30 °C in a dry place. Do not expose it to direct sunlight or frost.

### FURTHER INFORMATION

The information herein is offered for general guidance only. Advice on specific applications is available on request from the Technical Department of Sika Industry.

Copies of the following publications are available on request:

- Safety Data Sheets
- Application manual Bonding Plastic Parts
- Application manual Rebuild Broken Eyelet
- Application manual Reshape and Model Plastic Clips

### PACKAGING INFORMATION

Dual cartridge	50 ml
Mixer Quadro 73 mm	

## BASIS OF PRODUCT DATA

All technical data stated in this document are based on laboratory tests. Actual measured data may vary due to circumstances beyond our control.

## HEALTH AND SAFETY INFORMATION

User must read the most recent corresponding Safety Data Sheets (SDS) before using any products. The SDS provides information and advice on the safe handling, storage and disposal of chemical products and contains physical, ecological, toxicological and other safety-related data.

## DISCLAIMER

The information, and, in particular, the recommendations relating to the application and end-use of Sika products, are given in good faith based on Sika's current knowledge and experience of the products when properly stored, handled and applied under normal conditions in accordance with Sika's recommendations. In practice, the differences in materials, substrates and actual site conditions are such that no warranty in respect of merchantability or of fitness for a particular purpose, nor any liability arising out of any legal relationship whatsoever, can be inferred either from this information, or from any written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. The proprietary rights of third parties must be observed. All orders are accepted subject to our current terms of sale and delivery. Users must always refer to the most recent issue of the local Product Data Sheet for the product concerned, copies of which will be supplied on request.

## PRODUCT DATA SHEET

SikaForce®-302  
Version 02.01 (03 - 2024), en\_GB  
012104533023001000

## SIKA LIMITED

Watchmead  
Welwyn Garden City  
Hertfordshire, AL7 1BQ  
Tel: 01707 394444  
Web: [www.sika.co.uk](http://www.sika.co.uk)  
Twitter: @SikaLimited

