

## PRODUCT DATA SHEET

# SikaForce®-315

Super fast plastic and metal adhesive

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

Properties	SikaForce®-315 A	SikaForce®-315 B
Chemical base	Isocyanate	Polyol
Color (CQP001-1)	Beige	Black
Density	individual components mixed	1.32 kg/l 1.29 kg/l
Mixing ratio	A:B by volume	1:1
Non-sag properties	good	
Application temperature	10 – 30 °C (50 – 86 °F)	
Working time	50 seconds <sup>A</sup>	
Mixer open time	30 seconds <sup>A</sup>	
Shore D hardness (ASTM D2240)	70	
Tensile strength (ISO 527)	20 MPa (2 900 psi)	
Elongation at break (ISO 527)	170 %	
Service temperature	-40 – 120 °C (-40 – 248 °F)	
Shelf life	12 months <sup>B</sup>	

CQP = Corporate Quality Procedure

<sup>A</sup>) 23 °C (73 °F) / 50 % r.h.<sup>B</sup>) stored below 25 °C (77 °F)
**DESCRIPTION**

SikaForce®-315 is a 2-component polyurethane adhesive with very good adhesion properties. It is specifically designed for bonding small plastic and metal components.

**PRODUCT BENEFITS**

- Good adhesion to a wide variety of substrates
- Fast curing
- No running or dripping

**AREAS OF APPLICATION**

SikaForce®-315 is suitable for bonding small plastic and metal components such as moldings, clips, and rearview mirror tabs. This product is suitable for experienced professional users only. Test with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

## CURE MECHANISM

The curing of SikaForce®-315 takes place by chemical reaction of the two components. It cures at ambient temperature. The curing speed can be accelerated by temperature (max. up to 60 °C [140 °F]) using infrared lamps or ovens, e.g. 10 °C (18 °F) higher temperatures would result in approx. doubling the curing speed and cutting in half the pot-life.

## METHOD OF APPLICATION

### Surface Preparation

Lightly abrade metal and plastic substrates. Clean and de-grease the surfaces before applying adhesive. Additional surface treatment depends on the specific nature of the substrates. The above information is offered for general guidance only. Advice on specific applications will be given on request.

### Application

SikaForce®-315 can be dispensed from the dual mini syringes without the need for an applicator gun. In order to achieve a proper mixing, Mixer Tips (provided with product or sold separately) are required.

Extrude adhesive without mixer to equalize the filling levels, attach the mixer and dispose of the first few cm of the bead.

SikaForce®-315 has to be processed between 10 °C and 30 °C (50 °F and 86 °F) (product, ambient, and substrate temperature).

## Removal

Uncured SikaForce®-315 may be removed from tools and equipment with Sika® Remover-208 or other suitable solvents. Once cured, the material can only be removed mechanically. Hands and exposed skin shall be washed immediately using a suitable industrial hand cleaner. Do not use solvents on skin.

## 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 Sheet

## PACKAGING INFORMATION

Mini dual syringe	25 ml
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## 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.

## ENVIRONMENTAL, HEALTH AND SAFETY

For further information and advice regarding transportation, handling, storage and disposal of chemical products, user should refer to the actual Safety Data Sheets containing physical, environmental, toxicological and other safety related data. User must read the current actual Safety Data Sheets before using any products. In case of an emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

## LEGAL DISCLAIMER

Prior to each use of any product of Sika Corporation, its subsidiaries or affiliates ("SIKA"), the user must always read and follow the warnings and instructions on the product's most current product label, Product Data Sheet and Safety Data Sheet which are available at [usa.sika.com](http://usa.sika.com) or by contacting SIKA's Technical Service Department via email at [tsmh@us.sika.com](mailto:tsmh@us.sika.com). Nothing contained in any SIKA literature or materials relieves the user of the obligation to read and follow the warnings and instructions for each SIKA product as set forth in the current product label, Product Data Sheet and Safety Data Sheet prior to use of the SIKA product.

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