



SIKA FORCE[®]-315

SUPER FAST PLASTIC AND METAL ADHESIVE

SikaForce[®]-315 is a two-component, very fast-setting polyurethane adhesive designed to offer a single product solution for bonding most small components such as rearview mirror tabs, clips, moldings, cowl pins, door glass, side view mirrors, and more.

PRODUCT BENEFITS

- High strength adhesive
- Excellent adhesion to a wide range of substrates
- Very fast setting
- Minimal surface preparation
- Excellent environmental resistance
- Syringe-style cartridge for easy dispensing

NEW AND IMPROVED DELIVERY SYSTEM

- Easier dispensing by hand
- More precise application
- Smaller mixer - less waste



Product	Part #	Packaging	Quantity
SikaForce [®] -315	599138	25 ml ctg	10
Static Mixers	Contact Local Distributor	Bag	10

SIKAFORCE[®]-315 | APPLICATION INSTRUCTIONS



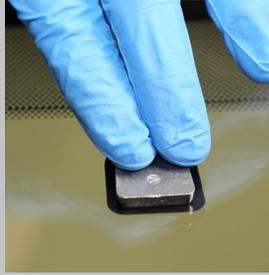
1 Make sure all surfaces are clean, dry and free of dust or grease before bonding. For bonding plastic, metal, or paint, abrade bonding surface with Scotch-Brite™ pad or sandpaper (80 - 120 grit) and dry wipe to clean any debris.



6 After applying, a small amount of excess material may discharge from the static mixer due to back pressure. If this occurs, wipe excess material off mixer tip with paper towel. DO NOT pull back on the plunger as this may pull mixed material back into the syringe.



2 While holding syringe upward, remove the grey end cap located at the top of the syringe.



7 Bond part to glass or vehicle body within open time (50 seconds at 73°F)¹. Compress the adhesive to 0.5 - 1.0 mm (0.02" - 0.04") and scrape away any excess material. Tape can be applied, but is not required for most applications.



3 Purge dime-sized amount of material to level plungers before attaching static mixer.



8 Allow 5-10 minutes for material to set, afterwards the bonded part will be ready for use¹. Product fully cures in 24 hours at 73°F.



4 Attach a static mixer. Purge 1" of material to ensure proper mixing.



9 Leave static mixer on syringe or secure grey end cap back onto syringe until next use. Never leave the syringe uncapped as this can cause curing in cartridge or lead to accidental dispensing.



5 Apply adhesive to part.

NOTE: Fast curing nature of product will cause material to harden in static mixer within one minute. When this happens, discard and replace the static mixer, purge 1" of material (step 4 above) before continuing work or starting a new application.

¹ Open time and setting time will be longer at lower temperatures and shorter at higher temperatures.