



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
Colour (CQP001-1)	Beige	Black
Density	individual components	1.32 kg/l
	mixed	1.29 kg/l
Mixing ratio	A:B by volume 1:1	
Non-sag properties	good	
Application temperature	10 – 30 °C	
Working time	50 seconds <sup>A</sup>	
Mixer open time	30 seconds <sup>A</sup>	
Shore D hardness (ASTM D-2240)	70	
Tensile strength (ISO 527)	20 MPa	
Elongation at break (ISO 527)	170 %	
Service temperature	-40 – 120 °C	
Shelf life	12 months <sup>B</sup>	

CQP = Corporate Quality Procedure

<sup>A)</sup> 23 °C / 50 % r.h.

<sup>B)</sup> stored below 25 °C

**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) using infrared lamps or ovens, e.g. 10 °C 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 (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.

## 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 recommendations, or from any other advice offered. The information contained herein does not relieve the user of the products from testing them for the intended application and purpose. 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 or may be downloaded from our website at: [www.sika.ca](http://www.sika.ca)

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