



PRODUCT DATA SHEET

SikaFast®-306

Very fast curing, toughened, low to medium modulus, structural adhesive

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Properties	SikaFast®-306 (A)	SikaFast®-306 (B)
Chemical base	Methacrylate	
Colour (CQP001-1)	Milky-white	Black
	mixed Black	
Cure mechanism	Radical polymerization	
Density (uncured)	0.94 kg/l	1.06 kg/l
	mixed (calculated) 0.95 kg/l	
Mixing ratio	by volume 10 : 1	
	by weight 8.9 : 1	
Consistency	Thixotropic paste	
Application temperature	10 – 35 °C	
Open time (CQP526-2)	3 minutes ^A	
Peak exotherm time / Temperature	5 minutes / 100 °C ^A	
Shore D hardness (CQP023-1 / ISO 48-4)	65	
Tensile strength (ASTM D638)	10 MPa	
E-Modulus (ASTM D638)	elongation 0.1 – 1.0 %	450 MPa
Tensile lap-shear strength (CQP046-6 / ISO 4587)	15 MPa	
Service temperature (CQP513-1)	-40 – 80 °C	
Shelf life	9 months ^B	

CQP = Corporate Quality Procedure

^{A)} 23 °C / 50 % r. h.

^{B)} stored at temperature below 25 °C protect from direct sun light

DESCRIPTION

SikaFast®-306 is a very fast curing time, 10:1 ratio 2-component adhesive based on methyl methacrylate (MMA) polymer technology. Uncured SikaFast®-306 is a thixotropic, non-sagging paste which allows an easy and precise application.

PRODUCT BENEFITS

- Strength development within minutes after application
- Non-sagging and thixotropic formulation
- Adhesion to a wide range of substrates without or with limited surface preparation
- Good strength and impact / peel resistance

AREAS OF APPLICATION

SikaFast®-306 is a fast curing, flexibilized structural adhesive designed to substitute welding, riveting and other mechanical fastening. SikaFast®-306 is suitable for high strength fastening of joints on different types of substrates including top coats, metals, and plastics with no or limited surface preparation.

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

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CURE MECHANISM

SikaFast®-306 cures according to radical chain polymerization.

For an ideal curing process, it is required to homogeneously mix both components with the defined ratio. Open and cure time are influenced by mixing ratio deviations as well as temperature. The higher the temperature the shorter the open and cure time and vice versa. Despite the quick strength build-up, exposure to premature stresses must be avoided since this may result in a reduction of mechanical properties and loss of adhesion.

CHEMICAL RESISTANCE

In the view of potential chemical or thermal exposure, it is required to conduct project related testing.

METHOD OF APPLICATION

Surface Preparation

Surfaces must be clean, dry and free from grease, oil and dust. Remove all loose particles or residues by cleaning it thoroughly.

Due to the diversity of materials, preliminary tests with original substrates are necessary.

Application

SikaFast®-306 is applied with a mixing ratio of 10:1 by volume from cartridges. If applied in large masses, heat is generated by the exothermic reaction. To avoid excessive temperature increase, bond thickness is limited to 5 mm, but must measure at least 0.5 mm.

Optimum temperature for the bonding process is between 15 °C and 25 °C. The approved temperature range for substrates and adhesive is between 10 °C and 35 °C. The influence of the reactivity by temperature changes must be respected.

The parts must always be joined within the open time.

SikaFast®-306 shall be processed with pneumatic or electric driven piston guns.

Removal

Uncured excess of SikaFast®-306 can be removed easily before curing with a dry wipe, with Sika® Remover-208 or another suitable solvent. Once the adhesive is cured it 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.

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

PACKAGING INFORMATION

Dual cartridge	490 ml
Mixer: Sulzer MixPac™ MFHX 10-18	

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

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