

PRODUCT DATA SHEET

SikaForce®-303

Purform® based ultrafast-curing plastic repair adhesive

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Properties	SikaForce®-303 (A)	SikaForce®-303 (B)
Chemical base	Polyol	Isocyanate
Color (CQP001-1)	Black	White
	mixed	Black
Density	1.24 kg/l	1.29 kg/l
	mixed	1.26 kg/l
Mixing ratio	by volume	1 : 1
Non-sag properties	Good	
Application temperature	15 – 30 °C	
Working time	30 seconds ^A	
Mixer open time	15 seconds ^A	
Sanding time	5 minutes ^A	
Shore D hardness (ASTM D2240)	73	
Tensile strength (ISO 527)	26 MPa	
Elongation at break (ISO 527)	58 %	
Shelf life (CQP016-1)	24 months	

CQP = Corporate Quality Procedure

^A) 23 °C / 50 % r. h.

DESCRIPTION

SikaForce®-303 (Purform®) is based on Purform®, an industry-leading polyurethane with less than 0.1 % monomeric diisocyanate for better health protection and occupational safety.

SikaForce®-303 (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 5 minutes
- Over paintable
- No sagging or dripping
- No shrinkage

AREAS OF APPLICATION

SikaForce®-303 (Purform®) is used in the automotive workshop for minor plastic repair work such as bonding of plastic parts, broken brackets, or filling of 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

SikaForce®-303 (Purform®) cures by chemical reaction of the two components at ambient temperature. The generated exothermic heat of the reaction can speed up the cure, reducing working and handling times. After the open time is reached, the cure reaction proceeds very fast and the viscosity will increase significantly within seconds.

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®-303 (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 applied on the bonding surfaces.

Dispense SikaForce®-303 (Purform®) with adequate piston guns. In order to achieve proper mixing, Mixer Tips for SikaForce®-303 (part of the packaging and sold separately) are required.

Excess material should be removed immediately after application. Due to the high reactivity of the adhesive, exothermic heat may be generated during curing. Avoid excessive application of the adhesive to reduce possible thermal effects on the substrates.

After dispensing, leave the mixer on the cartridge till 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®-303 (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®-303 (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®-303 (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

For information and advice regarding transportation, handling, storage and disposal of chemical products, users shall refer to the actual Safety Data Sheets containing physical, ecological, toxicological and other safety-related data.

DISCLAIMER

Any information or suggestions for use concerning Sika’s products, which we either in writing or orally have given buyers or end-users of the product, have been given in good faith based on our own experiences and based on approved praxis and the technological and scientific knowledge on the time of giving such suggestions and information, which are given without any type of guarantees, and which do not lead to any further responsibility from Sika Danmark A/S, besides what is stated in the sales agreement in question. The buyer or end-user should themselves investigate or otherwise make sure, that our products are suitable for the use in question and further make sure that the products are kept and used correct and in agreement with the published rules and considering the actual conditions in order to avoid damages or less satisfactory results. Any order is accepted and any deliverance is affected according to the general terms of sales and delivery from Sika Danmark A/S, which are considered known and accepted, and which could be handed out when asked for. Our catalogues are not up-dated automatically. The present product data sheet is only for use in Denmark. Values stated in the present product data sheet should be seen as recommended, unless stated otherwise.

PRODUCT DATA SHEET

SikaForce®-303
Version 02.01 (10 - 2026), en_DK
012104533033001000

