

PRODUCT DATA SHEET

SikaFast®-312

Structural assembly adhesive

TYPICAL PRODUCT DATA (FURTHER VALUES SEE SAFETY DATA SHEET)

Properties	SikaFast®-312 (A)	SikaFast®-312 (B)
Chemical base	Monomeric methacrylate	
Color (CQP001-1)	Off white	Light blue
mixed	Light blue	
Cure mechanism	Polymerization	
Density	0.90 kg/l	0.90 kg/l
mixed	0.90 kg/l	
Mixing ratio	by volume 1 : 1	
	by weight 1 : 1	
Viscosity	Brookfield 92/10	160 000 mPa·s
		180 000 mPa·s
Application temperature	10 – 35 °C	
Open time (CQP526-2)	35 minutes ^A	
Fixing time	(bondline thickness 0.3 mm, lap-shear strength reach 3 MPa) 120 minutes ^A	
Shore D hardness (CQP023-1 / ISO 48-4)	60	
Tensile strength (CQP036-1 / ISO 527)	20 MPa	
Elongation at break (CQP036-1 / ISO 527)	20 %	
Tensile lap-shear strength (CQP046-6 / ISO 4587)	10 MPa	
Shelf life	9 months ^B	

CQP = Corporate Quality Procedure

^A) 23 °C / 50 % r. h.^B) stored at 10 – 25 °C

DESCRIPTION

SikaFast®-312 is a 2-component adhesive system based on acrylate polymer technology. It bonds well on various of substrates with limited pre-treatment.

PRODUCT BENEFITS

- High strength
- Long open time
- Room temperature curing
- Good non sag performance
- Good thixotropic performance

AREAS OF APPLICATION

SikaFast®-312 is a flexible structural fast curing adhesive designed to substitute welding, riveting and other mechanical fastening.

SikaFast®-312 is suitable for high strength fastening of joints on different types of substrates including cold-rolled steel, stainless steel, and aluminium, ABS, PC, FRP and composite materials, etc., without 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.

CURE MECHANISM

SikaFast®-312 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®-312 can be dispensed from dual cartridges with adequate pneumatic guns. Extrude adhesive without mixer to equalize the filling levels. Attach the mixer and dispose of the first few cm of the bead before the application.

To ensure good mixing quality with cartridges the defined static mixer must be used. Other static mixers may be suitable but those must be thoroughly tested beforehand.

If applied in large masses, heat is generated by the exothermic reaction.

Optimum temperature for the bonding process is between 15 °C and 25 °C. The influence of the reactivity by temperature changes must be respected.

The parts must always be joined within the open time.

Removal

Uncured excess of SikaFast®-312 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

SikaFast®-312 (A+B)

Dual cartridge	400 ml
Mixer: CH 10-18T	

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

The information, and in particular, the recommendations relating to the application and enduse 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 written recommendations, or from any other advice offered. The user of the product must test the product's suitability for the intended application and purpose. Sika reserves the right to change the properties of its products. 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.

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SikaFast®-312
Version 01.01 (07 - 2026), en_IN
012805303120001000

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