

# SikaFast® -3311

## Fast Curing, 10:1 Mix Ratio, Toughened Low/Medium Modulus Structural Methylmethacrylate Adhesive

### Typical Product Data

| Properties  | Component A<br>SikaFast®-3311            | Component B<br>SikaFast®-3311 |
|---|--|-------------------------------|
| Chemical base   | Toughened 2-component methylmethacrylate |                               |
| Color   | Milky-white                              | Blue/Black                    |
| Color mixed   | Light Blue/Gray                          |                               |
| Cure mechanism  | Free Radical Polymerization              |                               |
| Density (uncured)   | 8.0 lb/gal                               | 9.0 lb/gal                    |
| Density mixed   | 8.1 lb/gal                               |                               |
| Mixing ratio  | by volume<br>by weight                   |                               |
|   | 10:1<br>8.9:1                            |                               |
| Viscosity <sup>a</sup> (Individual Component), Brookfield Spindle #7 @ 20 RPM | 125,000 cps                              | 70,000 cps                    |
| Application temperature   | product 50°- 95°F (10°- 35°C)            |                               |
| Skin time <sup>b</sup> (CQP <sup>c</sup> 019)                                 | 6 minutes                                |                               |
| Peak Exotherm Time/Temperature; (Sika P.4.10.11)                              | 12 minutes / 95°C (203°F)                |                               |
| Shore D-hardness (ASTM D 2240)  | 73                                       |                               |
| Tensile strength <sup>b</sup> (ASTM D 638)                                    | 1,450psi (10 MPa)                        |                               |
| E-Modulus <sup>b</sup> @0.1-1% (ASTM D 638)                                   | 65,000 psi (450 MPa)                     |                               |
| Tensile lap-shear strength <sup>c</sup> (CQP 046-1)                           | 2200 psi (15 MPa)                        |                               |
| Service temperature range   | -40° to 250°F (-40°to 121°C)             |                               |
| Shelf life (storage below 77°F (25°C))  | 12 months                                | 9 months                      |

<sup>a)</sup> 77°F (25°C)

<sup>b)</sup> 73°F (23°C) / 50% r.h.

<sup>c)</sup> CQP = Corporation Quality Procedure

#### Description

SikaFast®-3311 is a fast curing, 10:1 ratio two-component adhesive system based on methyl-methacrylate (MMA) polymer technology. Uncured SikaFast®-3311 is a thixotropic, non-sagging paste which allows an easy and precise application.

#### Product Benefits

- Non-sagging and thixotropic formulation
- Little or no surface preparation
- Good impact, peel and shear resistance

#### Areas of Application

SikaFast®-3311 is a fast curing, flexible structural adhesive designed to substitute welding, riveting and other mechanical fastening. SikaFast®-3311 is suitable for high strength fastening of joints on different types of substrates including top coats, metals, and plastics, etc., with no or limited surface preparation. This product is suitable for professional experienced users only. Test with actual substrates and conditions have to be performed to ensure adhesion and material compatibility.

Industry



Prior to each use of any Sika product, the user must always read and follow the warnings and instructions on the product's most current Product Data Sheet, label and Safety Data Sheet which are available on request at [tsmh@us.sika.com](mailto:tsmh@us.sika.com). Nothing contained in any Sika materials relieves the user of the obligation to read and follow the warnings and instructions for each Sika product as set forth in the current Product Data Sheet, label and Safety Data Sheet prior to product use.

## Cure Mechanism

SikaFast®-3311 cures by free radical polymerization. For an ideal curing process it is required to homogeneously mix both components within the defined ratio. SikaFast®-3311 offers an extended working time followed by fast curing. This leads to an optimal relation between application time and fast strength development to allow handling of bonded parts. Despite the quick strength build-up, premature exposure to stresses must be avoided since this may result in a reduction of mechanical properties and loss of adhesion.

## Chemical Resistance

Cured SikaFast®-3311 has good resistance to dilute acids and bases, water, mineral oil and some aliphatic and aromatic hydrocarbon. **Actual chemical resistance of bonded components must be tested.** The above information is offered for general guidance only.

## Method of Application

### Surface preparation

All surfaces must be clean, dry, dust and grease free. Best result will be achieved with surfaces that have been lightly abraded immediately prior to bonding. Due to the diversity of substrates, preliminary tests are necessary.

### Application

If SikaFast®-3311 is applied in large amounts, excessive heat is generated by the exothermic reaction. To avoid such high temperatures the bond line thickness should not exceed 0.20 inches (5 mm). A bond line thickness of less than 0.01 inches (0.25 mm) is not recommended.

## Removal

Uncured excess material can best be removed before curing with a dry wipe. From tools and equipment SikaFast®-3311 may be removed with Sika® Remover-208 or a suitable solvent. Once the adhesive is cured it can only be removed mechanically. Hands and exposed skin should be cleaned immediately using a suitable industrial hand cleaner and water. Do not use solvents on skin!

## Further Information

To contact Sika Corporation's Technical Services Department please send an e-mail to [tsmh@us.sika.com](mailto:tsmh@us.sika.com). Copies of the Safety Data Sheet are available upon request.

## Packaging Information

|           |        |
|-----------|--------|
| Cartridge | 490 ml |
|-----------|--------|

## Basis of Product Data

All technical data stated in this Product Data Sheet are based on laboratory tests only. 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.

## Limited Material Warranty

Sika Corporation warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as

directed within shelf life. User determines suitability of product for intended use and assumes all risks. Buyer's sole remedy shall be limited to the purchase price or replacement of product exclusive of labor or cost of labor. **NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS.**

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