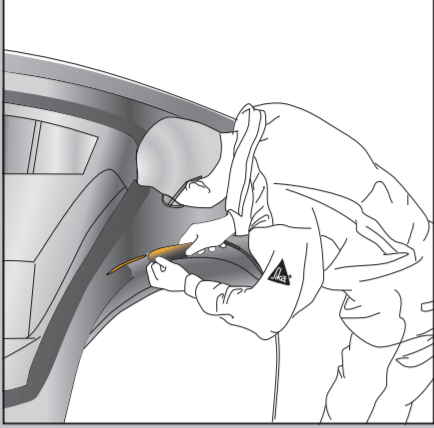
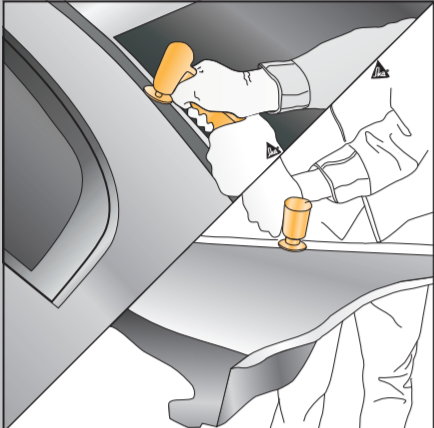
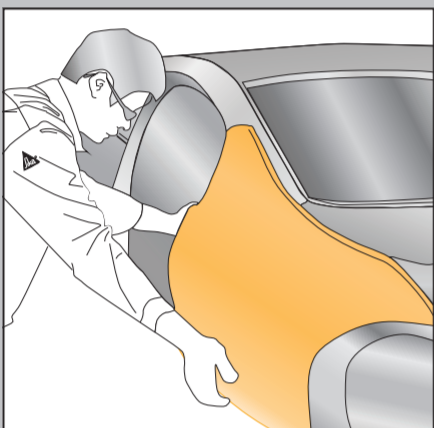

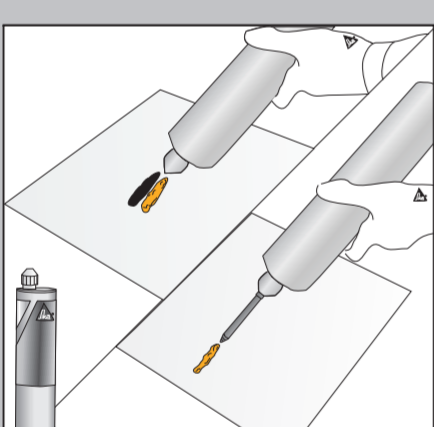
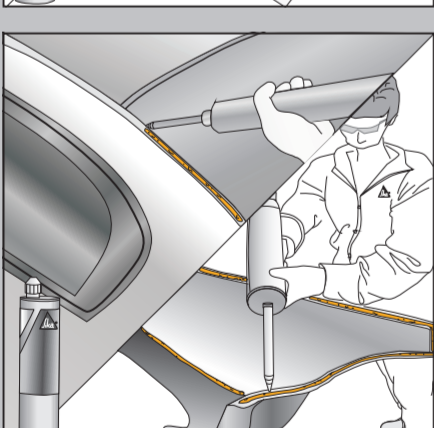
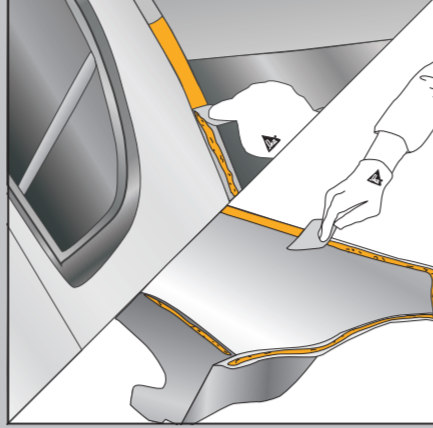
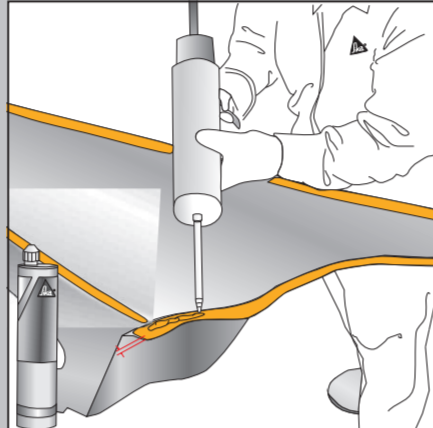
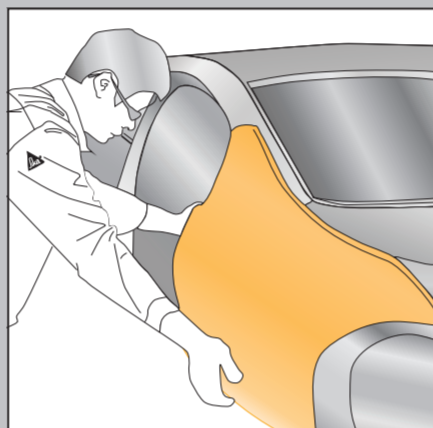
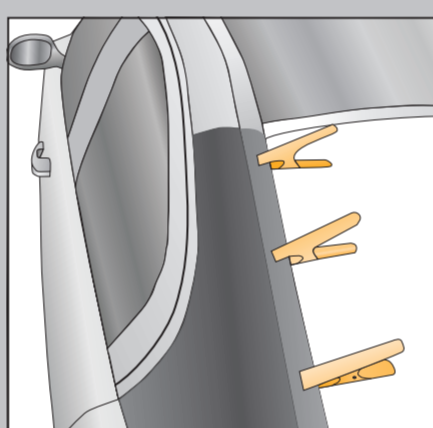
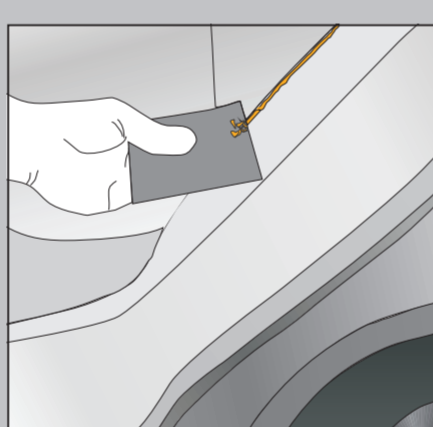
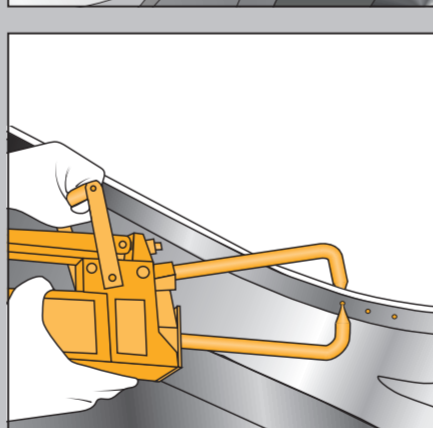


# SikaPower®-4720

## PANEL REPLACEMENT GUIDE

- 
  - Cut and remove damaged panel in accordance with OEM recommendations
- 
  - Grind bonding areas on both car body and new panel to bare metal
- 
  - Straighten all metal and align parts
  - Dry fit panel
- 
  - Clean target bonding areas with a suitable residue-free solvent
- 
  - Before attaching mixer, extrude some material until both Parts A and B flow evenly
  - Attach static mixer and dispense a small amount of adhesive
- 
  - Apply an adhesive bead to all bare metal areas of both pieces to be bonded
- 
  - Spread the adhesive to cover all bare metal areas with a plastic spatula
- 
  - Apply a second bead of adhesive on new panel approx. 5 mm from the edge of the panel
  - Do not apply a second bead at points that will be spot welded
- 
  - Align new part to car body within 60 minutes<sup>1)</sup> after start of adhesive application
- 
  - Clamp panel in its proper position, start in corners, panel end points and positions where tension is present in the fit (remove clamps after 4.5 hours<sup>1)</sup>)
- 
  - Tool any adhesive squeeze-out to seam along the bonded edge
- 
  - Proceed with welding or riveting where required and in accordance with OEM recommendations



Temperature	Open time	Clamp time	Grindable	Drive-away time
10 °C	90 min	16 h	48 h	48 h
23 °C	60 min	4.5 h	16 h	24 h
30 °C	30 min	2 h	6 h	8 h
60 °C	n.a.	30 min	1 h	1 h

<sup>1)</sup> All time indications are related to 23°C (ambient and substrate). Product curing behavior is temperature dependent and increases with higher temperature and vice versa. Cure time may be accelerated by applying heat up to 85°C using infrared lamps, heating blankets or ovens. Consult curing information on product label or contact Sika Technical Service.

Our most current General Sales Conditions shall apply.  
Please consult the most current local Product Data Sheet prior to any use.

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