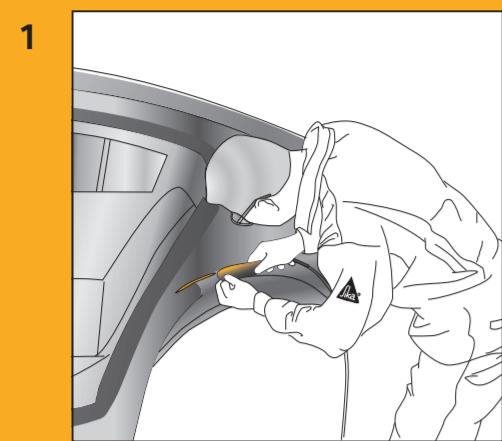


SikaPower®-4720

PANEL REPLACEMENT GUIDE



- Cut and remove damaged panel in accordance with OEM recommendations



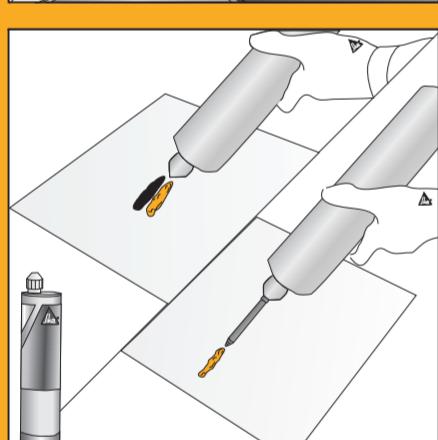
- Grind bonding areas on both car body and new panel to bare metal



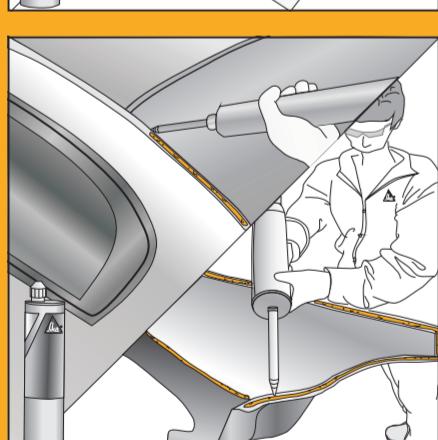
- Straighten all metal and align parts
- Dry fit panel



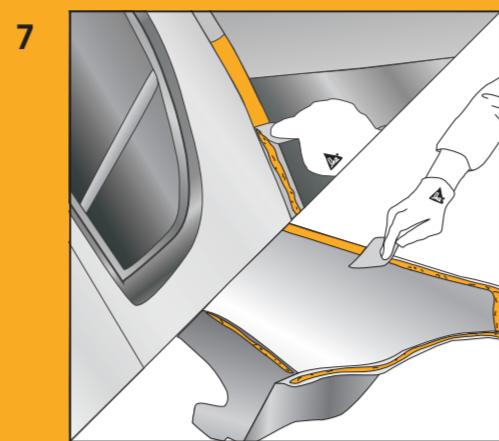
- Clean target bonding areas with a suitable residue-free solvent



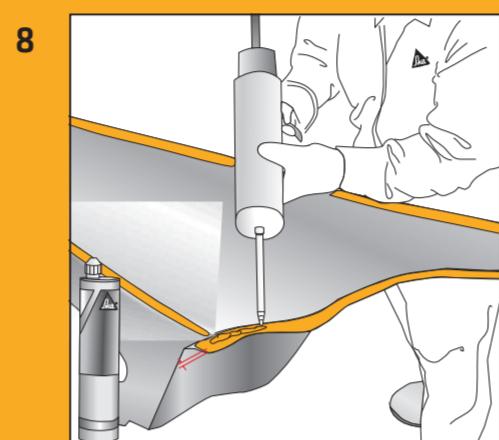
- Before attaching mixer, extrude some material until both Parts A and B flow evenly
- Attach static mixer and dispense a small amount of adhesive



- Apply an adhesive bead to all bare metal areas of both pieces to be bonded



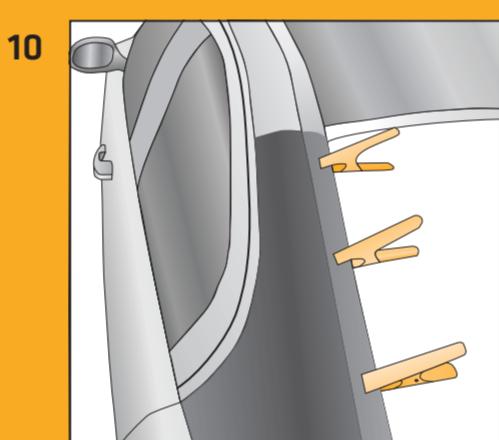
- Spread the adhesive to cover all bare metal areas with a plastic spatula



- 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



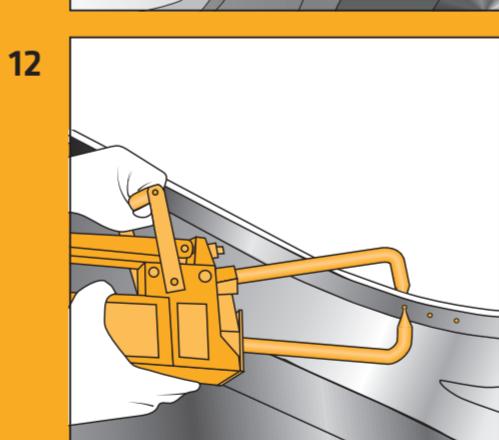
- Align new part to car body within 60 minutes¹⁾ after start of adhesive application



- 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 hours¹⁾)



- 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

¹⁾ 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.