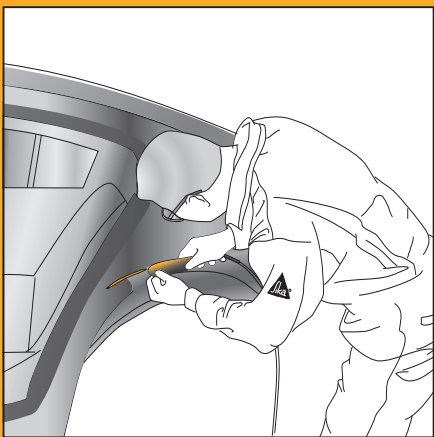
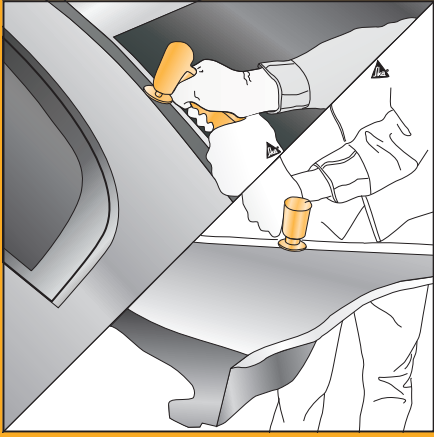


# SikaPower®-4720


## PANEL REPLACEMENT GUIDE

- 


1

  - Cut and remove damaged panel in accordance with OEM recommendations
- 

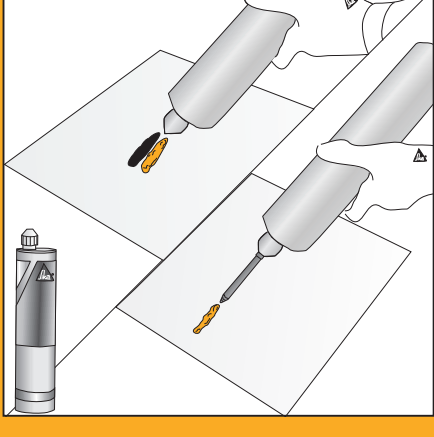
2

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

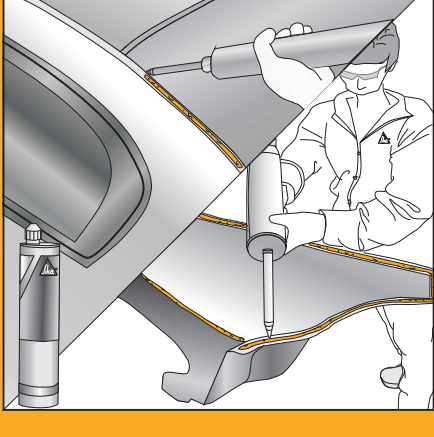
3

  - Straighten all metal and align parts
  - Dry fit panel
- 

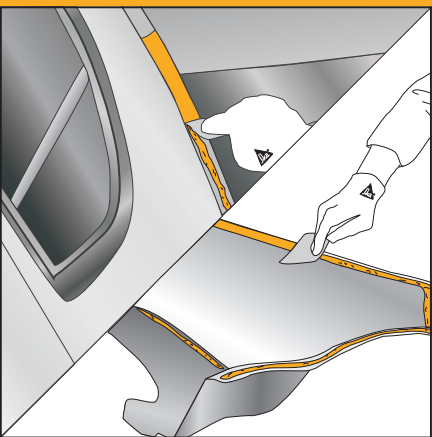
4

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

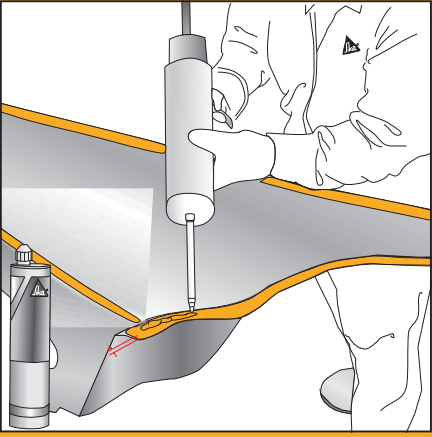
5

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


6

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

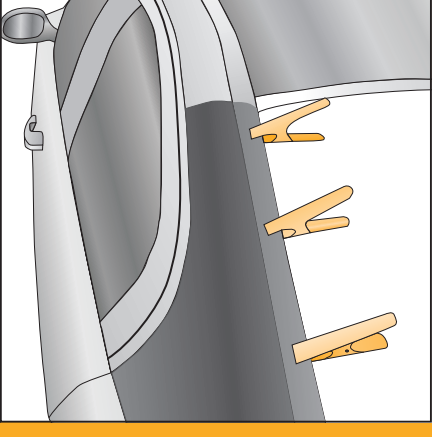
7

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

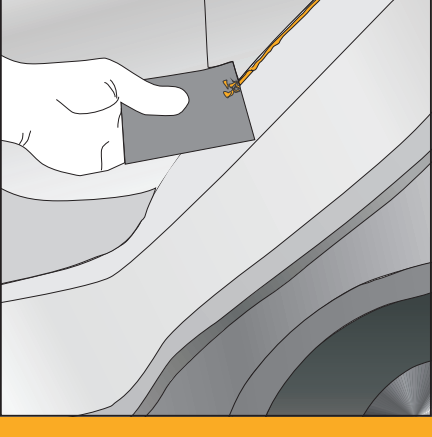
8

  - 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
- 

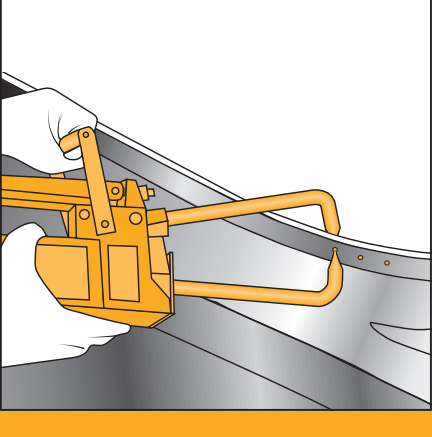
9

  - Align new part to car body within 60 minutes<sup>1)</sup> after start of adhesive application
- 

10

  - 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>)
- 


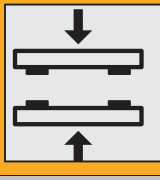

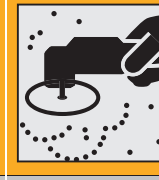
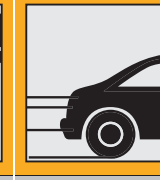
11

  - Tool any adhesive squeeze-out to seam along the bonded edge
- 

12

  - 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.

