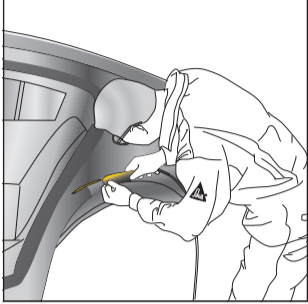
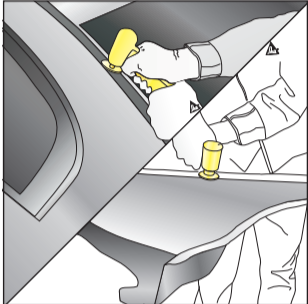
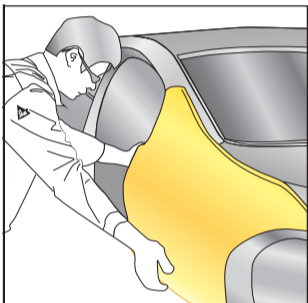
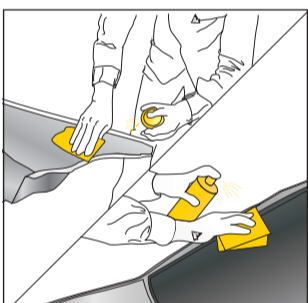
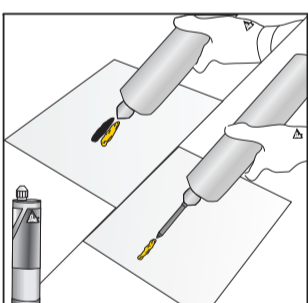
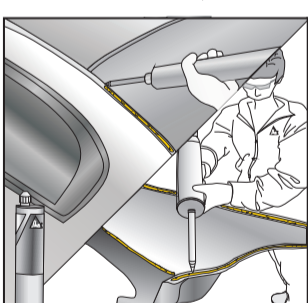
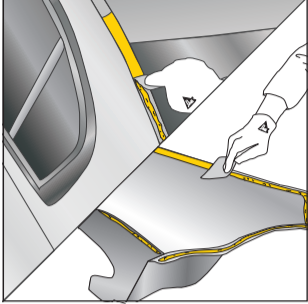
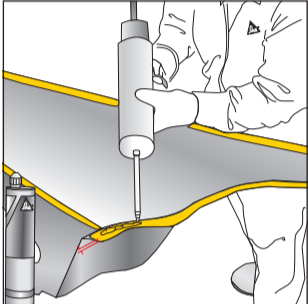
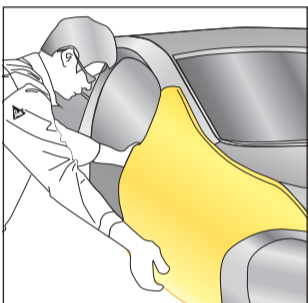
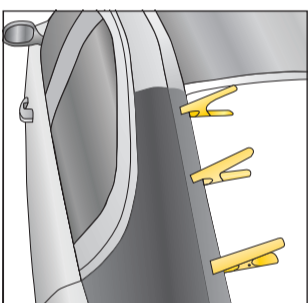
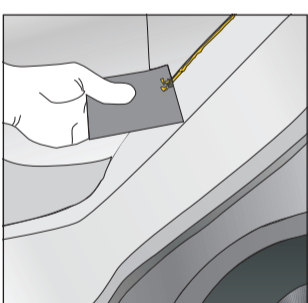
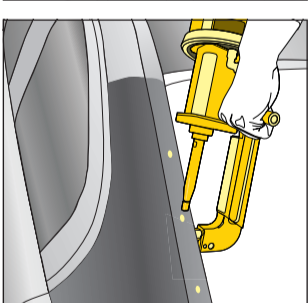


# SikaPower®-4720

## PANEL REPLACEMENT GUIDE

- 
  - Cut and remove damaged panel in accordance with OEM recommendations
- 
  - Clean the target bonding areas with Sika® Remover-208 or another suitable residue-free solvent
  - 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 Sika® Remover-208 or another 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 areas 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

<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. Curing speed may be accelerated by applying heat up to 80°C for max. 5 minutes using infrared lamps, heating blankets or ovens. Consult curing information on product label or contact Sika Technical Service.



### PROCESS TIMES

Substrate 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.s.	30 min	1 h	1 h

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

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