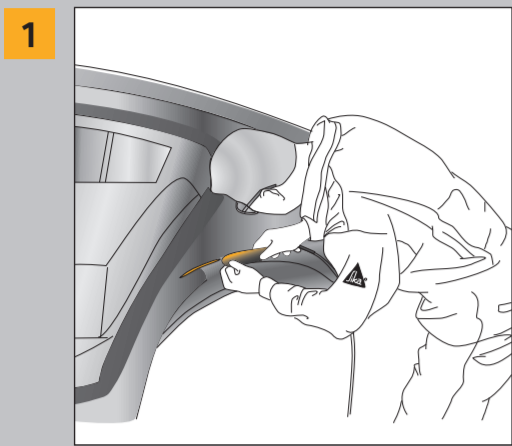
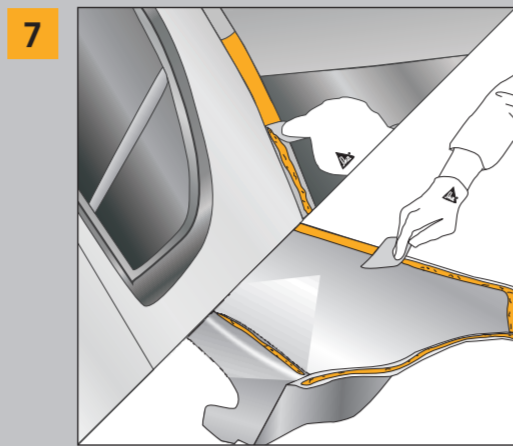


SikaPower®-4720

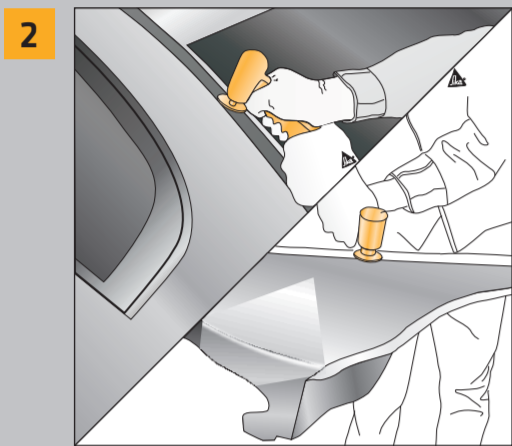
PANEL REPLACEMENT GUIDE



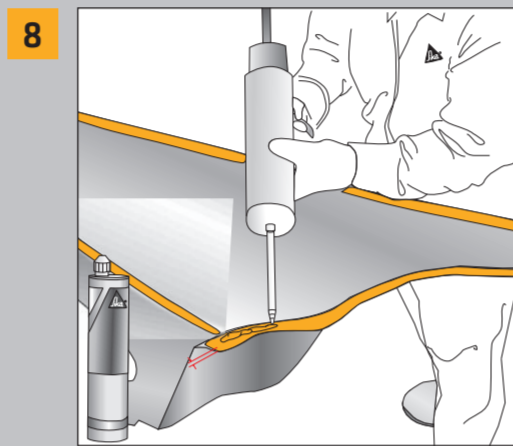
- 1**
- Cut and remove damaged panel in accordance with OEM recommendations



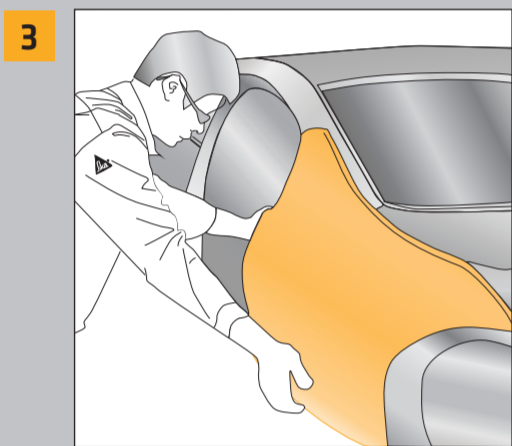
- 7**
- Spread the adhesive to cover all bare metal areas with a plastic spatula



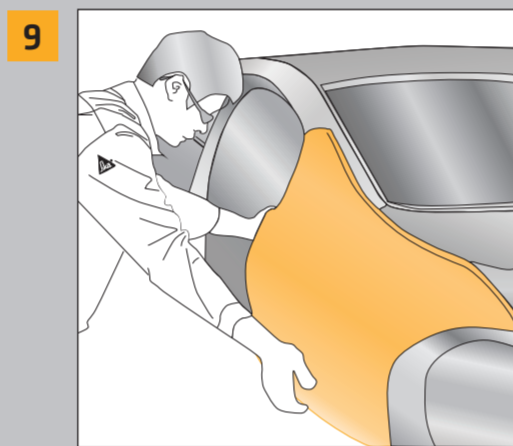
- 2**
- Grind bonding areas on both car body and new panel to bare metal



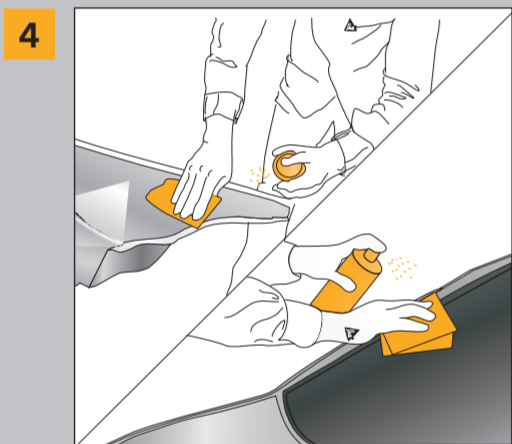
- 8**
- Apply a second bead of adhesive on new panel approx. 5mm from the edge of the panel
 - Do not apply a second bead at points that will be spot welded



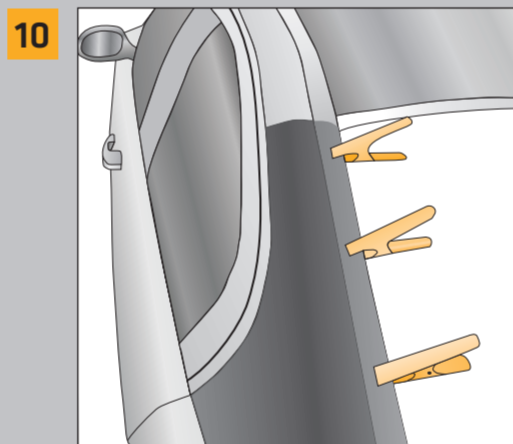
- 3**
- Straighten all metal and align parts
 - Dry fit panel



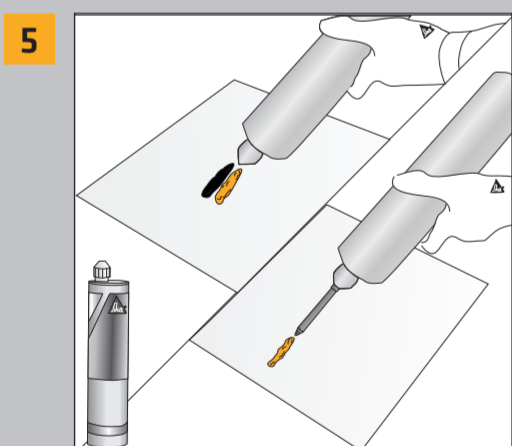
- 9**
- Align new part to car body within 60 minutes¹⁾ after start of adhesive application



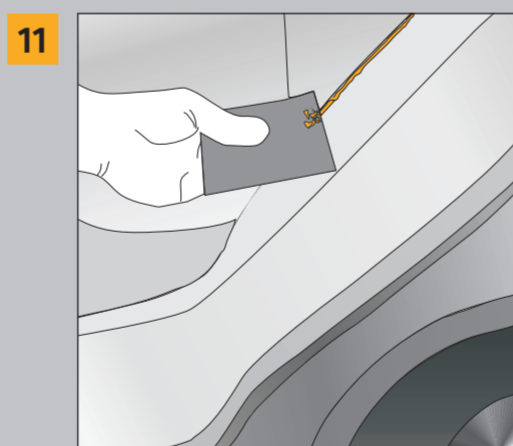
- 4**
- Clean target bonding areas with a suitable residue-free solvent



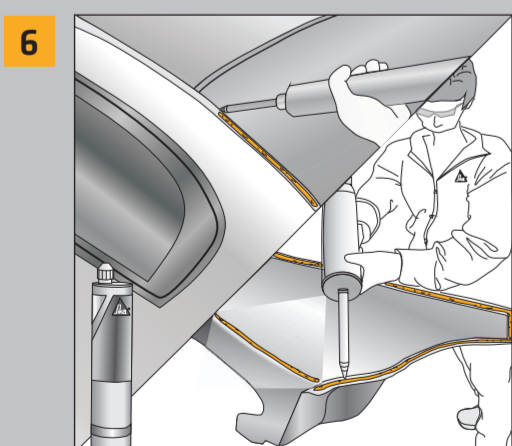
- 10**
- Clamp panel in its proper position, start in corners, panel end points and positions where tension is present in the fit (remove clamps after 4.5 hours¹⁾)



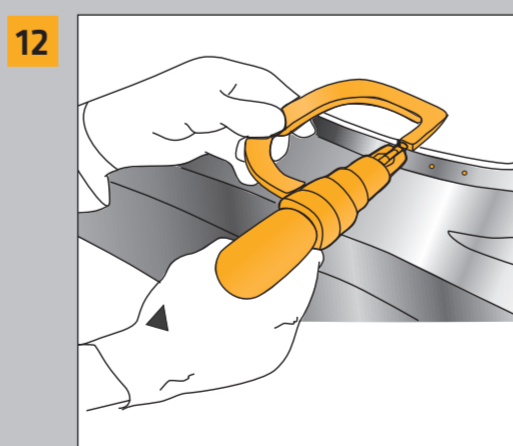
- 5**
- Before attaching mixer, extrude some material until both Parts A and B flow evenly
 - Attach static mixer and dispense a small amount of adhesive



- 11**
- Tool any adhesive squeeze-out to seam along the bonded edge



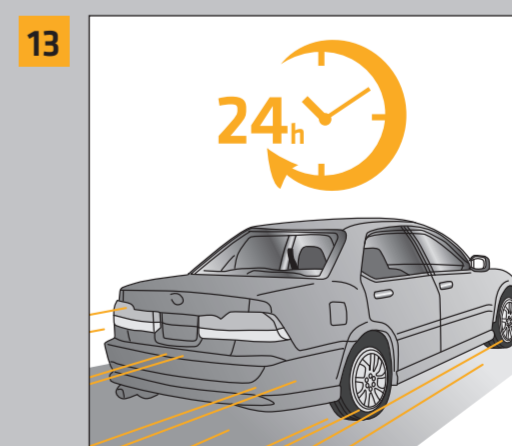
- 6**
- Apply an adhesive bead to all bare metal areas of both pieces to be bonded



- 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



- 13**
- Vehicle may be returned to service after 24 hours¹⁾

¹⁾ All time indications are related to 23°C (ambient and substrate). Product curing behavior is temperature dependent and increase 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.