

## INTER-MIX 15 THICK SET FLEXIBLE SEAM SEALER

INTER-MIX 15 Flexible Adhesive/Seam Sealer is a non-sagging, extremely flexible adhesive/sealant designed for sealing vertical and horizontal seams and joints on automobiles and truck applications. Excellent adhesion to: bare metal, primed metal, SMC, FRP, fiberglass, aluminum and most plastics\*. Can be sprayed with our 2K Spray System.

\* For TPO and Polypropylene plastics, use IES #4182 INTER-BOND Adhesion Promoter.

### DIRECTIONS

1. Surface must be clean and free of dirt, grease, oil, rust, old seam sealer and any other contaminants. Use IES Super Cleaning Solvent or IES Specialty Adhesive Remover to clean the surface.
2. If applying sealer directly to bare metal, surfaces should be sanded with P80 grit sandpaper. If applying the sealer to a primed surface is desired, use a 2K epoxy or 2K urethane primer. Allow to dry and sand primed surfaces with 400 grit sandpaper or scuff pad. Blow off and wipe clean using IES-1700/4700/1780 film free solvent. Do not use an acid etch or self-etching 1K primer.
3. Follow the IES dual cartridge set up instructions for loading cartridge into the dispensing gun.
4. Dispense IES 8413/8613 Seam Sealer into the joint or seam. Smooth out if desired with tool or finger and feather edge.
5. IES 8413/8613 will set up in approximately 15 minutes.
6. Scuff or sand sealer with 320 grit sandpaper prior to priming or painting.
7. Prime and paint per manufacturer's specifications.

### STORAGE/HANDLING

The average shelf life of IES Epoxy Adhesives and Sealants is 24 months at 77°F (25°C). For best results, store in original, tightly closed containers. Storage in cool, clean, and dry areas is recommended. Usable shelf life may vary depending on method of application and storage conditions. Certain resins are prone to crystallization due to temperature changes and humidity. If crystallization does occur, warm the contents of the container to 150°F (65°C) until all crystals have dissolved. The time needed depends on the size of the container, amount of product and the state of crystallization. It may take only a few minutes to reconstitute a small kit with a small number of crystals. Allow contents to cool to room temperature before continuing. The epoxy adhesive or sealant will function properly as if the crystals never occurred.

NOTICE TO PURCHASER: The following warranty is in lieu of all other expressed or implied warranties, specifically all goods are manufactured of first class materials and by competent professionals. We have no control over the use and application of our products. Our liability shall not exceed the purchase price.



Thick-Set  
Flexible Adhesive/Seam Sealer

### TECHNICAL INFO

Mixed Color	Gray
Mix Ratio	1:1
Work time	15-20 Minutes
Handling Time	20-30 Minutes
Part Paintability	45 Minutes
Sealer Sandability	45 Minutes
Full Cure Strength	6-8 Hours
Service Temperature	-20°F to 190°F

All times stated are approximate depending on temperature and humidity. All times are based on 70°F to 75°F at 50% relative humidity.

### CAUTION

For professional use only. Before using this or any IES product, refer to the Safety Data Sheet (SDS) and label for safe use and handling instructions.

### PRODUCT AVAILABLE

8413	10 fl. oz. kit (300mL) Each kit includes three static mixers	4 per case
8613	6.76 fl. oz. (200 mL) Each kit includes two static mixers	6 per case