

INTER-MIX 90

Hybrid Panel Bonding Adhesive

A heavy-bodied high strength epoxy/urethane adhesive that will bond to a wide variety of metal and plastic substrates. When used according to specific directions IES Hybrid Panel Bonding Adhesive may be used in the replacement of: Quarter Panels, Door Skins, Roof Panels, Truck Box Sides and other Outer Body Sheet Metal.

NOTE: Do not use on structural components such as Rails, Rocker Panels, Core Supports, Pillars, etc.

IES 8422 Inter-Mix 90 Panel Bonding Adhesive is chemically engineered to be one of the best panel bonders on the market today.

Epoxy Resin and Polyamid Hardner System provides lap shear strengths of greater than 3,000 psi. on steel and aluminum substrates.

90 Minute Work Time provides ample time for application, panel alignment and clamping.

Heat Cure Activator built into the formula provides Heat Induced Curing for faster fixture times if desired.

Adhesion Promoter built into the formula provides stronger bonding to steel, aluminum, SMC and FRP.

Urethane and ATBN Copolymer Resins built into the formula, provides Impact and Fracture Resistance, even at lower temperatures.

High Performance Fillers provide easier pumping and non-sag performance, even when heat induce curing is needed.

Solid Glass Beads are added in to prevent adhesive squeeze out when clamping and provide a consistent bond line thickness.

- **2:1 Cartridge**
- **High Strength Bond**
- **Reduces Welding Time**
- **Reduces Fire Risks**
- **Provides Corrosion Protection**
- **Contains Glass Beads to Maintain A Constant Bondline Thickness.**
- **Bonds & Seals Simultaneously**
- **Reduces Warpage**
- **Lifetime Limited Warranty when used as per directions.**



TYPICAL PROPERTIES

	Temperature	
*Working Time	70° - 80°F	60-90 Minutes
*De-Clamping Time	70° - 80°F	6-8 Hours
	100°F	3 Hours
	140°F	60 Minutes
	180°F	30 Minutes

Total Cure Time: 24 Hours

* Working /De-Clamping time may be accelerated when used in conjunction with heat. Please refer to the "Weld Bonding Procedures or SMC Bonding Procedures" for more information.

Lap Shear Strength Test	ASTM-D-1002 Average
Substrates:	
Cold Rolled Steel	3500 psi**
Aluminum	3500 psi**

** Substrates were cleaned with IES Super Clean and abraided with IES 7060 36 grit Trim-Kut Disc.

STORAGE

Product should be stored in a cool, dry location in unopened containers at a temperature between 50°F to 85°F (10°C to 30°C) unless otherwise labeled. Protect package from direct sunlight and heat. Do not handle or store near open flame or other sources.

Please refer to the SDS and product label before using this or any IES product. Additional information and Repair Procedures can be found online at www.useies.com

PRODUCT AVAILABLE

8422 6.76 fl. oz (200ml kit) 4/case

Each kit includes two #8265 static mixers & one 1/2" and one 1" Ribbon Zip-Tip

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 if the specific instructions are not followed or if product is used for something other than its intended use.