



# PRODUCT APPLICATION GUIDE

INTER-MIX™ • INTER-FOAM™ • INTER-WELD™ • Hand Mix

|  | PRODUCT   | NUMBERS   | DESCRIPTION   | APPLICATION / USES   | TIMES   |
|--|---|---|---|--|---|
| SEALERS  | <b>INTER-MIX 5 min</b><br>Adhesive / Sealer<br>Semi-Flexible        | 8412<br>(10 oz. cartridge)<br><br>Non-sag up to 1/4" bead                                   | A non-sagging, semi-flexible adhesive / seam sealer.  | A firm yet flexible seam sealer with excellent adhesion to: SMC, fiberglass, metal, aluminum and most plastics. Used for sealing vertical & horizontal seams and joints.   | Working: 5 to 10 min.<br>Handling: 10 to 20 min.<br>Sandable: 20 to 30 min.<br>Paintable: 20 to 30 min.<br>Full Cure: 6 to 8 hours  |
|  | <b>INTER-MIX 10 min</b><br>"Thick Set" Seam Sealer<br>Semi-Flexible | 8405<br>(10 oz. cartridge)<br><br>Non-sag up to 1/2" bead                                   | A thick-set, non-sagging, firm, semi-flexible <b>bare metal</b> adhesive / seam sealer.<br><br><i>Passes 1500 hour salt fog test!</i> | Designed for sealing vertical and horizontal seams and joints on automobiles and truck applications. May be applied to bare metal and primed sheet metal joints. Excellent adhesion to: bare metal, primed metal, SMC, FRP, fiberglass, aluminum and most plastics.      | Working: 10 to 15 min.<br>Handling: 30 to 45 min.<br>Sandable: 45 min.<br>Paintable: 45 min.<br>Full Cure: 6 to 8 hours             |
|  | <b>INTER-MIX 15 min</b><br>Adhesive/Sealer<br>Semi-Flexible         | 8411<br>(10 oz. cartridge)<br><br>Non-sag up to 1/4" bead                                   | A non-sagging, semi-flexible adhesive / seam sealer.  | A firm yet semi-flexible seam sealer with excellent adhesion to: SMC, fiberglass, metal, aluminum and most plastics. Used for sealing vertical & horizontal seams and joints.  | Working: 15 to 20 min.<br>Handling: 20 to 30 min.<br>Sandable: 45 min.<br>Paintable: 45 min.<br>Full Cure: 6 to 8 hours             |
|  | <b>INTER-MIX 15 min</b><br>Adhesive/Sealer<br>Extremely Flexible    | 8413<br>(10 oz. cartridge)<br><br>Non-sag up to 1/4" bead                                   | A non-sagging, extremely flexible adhesive / seam sealer.   | A firm yet extremely flexible seam sealer with excellent adhesion to: SMC, fiberglass, metal, aluminum and most plastics. Used for sealing vertical & horizontal seams and joints where flexing occurs.  | Working: 15 to 20 min.<br>Handling: 20 to 30 min.<br>Sandable: 45 min.<br>Paintable: 45 min.<br>Full Cure: 6 to 8 hours             |
|  | <b>INTER-MIX 30 min</b><br>Flowable Seam Sealer<br>Semi-Flexible    | 8410<br>(10 oz. cartridge)  | A flowable, self-leveling semi-flexible seam sealer with no tooling required.   | Designed for sealing roof seams, drip rails and other horizontal seams. Ford Explorer, Bronco, Escort & Aerostar roof panels and various other horizontal applications.  | Working: 20 to 30 min.<br>Handling: 30 to 45 min.<br>Sandable: 60 min.<br>Paintable: 60 min.<br>Full Cure: 6 to 8 hours             |
| BONDING ADHESIVES  | <b>INTER-WELD 15 min</b><br>MSA Adhesive<br>Panel Bonding           | 8515<br>(10 oz. Cartridge)<br><br><i>Glass beads ensure consistent bond-line thickness.</i> | An extreme, high-strength methacrylate structural adhesive featuring a faster working time of 15min.                                  | Formulated for bonding metal structural elements, SMC, engineered thermoplastics, thermosets and composites, together in any combination. Forms a tough, high-strength, high-impact, resistant bond.   | Working: 10 to 15 min.<br>Handling: 25 to 30 min.<br>Full Cure: 24 hrs approx.  |
|  | <b>INTER-MIX 45 min</b><br>Door Skin Adhesive                       | 8415<br>(10 oz. cartridge)  | A high-strength, two-part epoxy adhesive featuring an extended working time of 45 minutes.  | Designed for bonding and sealing primed metal and SMC plastic type door skins and panels with flanges.<br><b>NOTE: Not for Camaro or Firebird late model door skins.</b>   | Working: 40 to 60 min.<br>Handling: 60 min.<br>Sandable: 60 min.<br>Paintable: 60 min.<br>Full Cure: 6 to 8 hours                   |
|  | <b>INTER-MIX 60 min</b><br>SMC Panel Adhesive                       | 8414<br>(10 oz. Cartridge)<br><br><i>Glass beads ensure consistent bond-line thickness.</i> | A non-sag, high-strength, two-part epoxy adhesive. For use in truck, automotive & marine applications.                                | Designed to provide tough, durable bonds to SMC panels, metal space frames and fiberglass. This product is ideal for splicing as well as panel replacement.  | Working: 50 to 60 min.<br>Handling: 4 to 6 hours<br>Full Cure: 24 hours   |
|  | <b>INTER-MIX 60 min</b><br>Metal Panel Bond                         | 8420<br>(10 oz. cartridge)<br><br><i>Glass beads ensure consistent bond-line thickness.</i> | A heavy body, high-strength structural epoxy adhesive featuring an extended working time of 60minutes.                                | Designed for bonding all automotive type steels, aluminum, SMC, engineered thermoplastics, thermosets and composites, together in any combination. Used in the replacement of quarter panels, roof panels, door skins, truck box sides and other outer body sheet metal. | Working: 50 to 60 min.<br>Handling: 4 to 6 hours<br>Full Cure: 24 hours   |
|  | <b>INTER-WELD 60 min</b><br>MSA Adhesive<br>Panel Bonding           | 8560<br>(10 oz. cartridge)<br><br><i>Glass beads ensure consistent bond-line thickness.</i> | A high-strength methacrylate structural adhesive featuring an extended working time of 60 minutes.                                    | Designed for bonding all automotive type steels, aluminum, SMC, engineered thermoplastics, thermosets and composites, together in any combination. Used in the replacement of quarter panels, roof panels, door skins, truck box sides and other outer body sheet metal. | Working: 55 to 60 min.<br>Handling: 90 to 130 min.<br>Full Cure: 24 hrs approx.   |
| FOAMS  | <b>INTER-FOAM 5</b><br>Flexible Foam<br>5 Second                    | 8451<br>(10 oz. cartridge)<br>8449<br>(50 ml. cartridge)                                    | A two-part flexible urethane foam formulated to expand 10 times its original volume. Will not bow out body panels.                    | Stops wind noise, water leaks in pillar posts, quarter panels, wheel housings and weather strips. Adds reinforcement to panels such as door skin brace, roof and hood panels. Eliminates panel flutter.  | Working: 3 to 5 sec.<br>Handling: 2 to 3 min.<br>Sandable: not applicable<br>Paintable: 10 to 15 min.<br>Full Cure: 10 to 15 min.   |
|  | <b>INTER-FOAM 10</b><br>Rigid Foam<br>10 Second                     | 8455<br>(10 oz. cartridge)  | A two-part rigid urethane foam formulated to expand 10 times its original volume.   | Fills and reinforces pillar posts and box sections. Stops wind water and dust leaks. Provides sound deadening and compressive strength.  | Working: 10 to 25 sec.<br>Handling: 3 to 4 min.<br>Sandable: not applicable<br>Paintable: 10 to 15 min.<br>Full Cure: 30 to 45 min. |
| GENERAL REPAIR: METAL, PLASTIC, FIBERGLASS, ALUMINUM, ETC. | <b>INTER-MIX 40 sec</b><br>Rigid / Semi-Rigid                       | 8408<br>(10 oz. cartridge)  | An extra-fast setting two part high strength rigid / semi-rigid epoxy adhesive, filler & surfacer.                                    | Bonding, repairing or surfacing SMC, TPO, rigid plastics, fiberglass, steel, aluminum, glass and other rigid/semi-rigid type materials.  | Working: 40 to 50 sec.<br>Handling: 5 to 10 min.<br>Sandable: 15 to 20 min.<br>Paintable: 20 to 30 min.<br>Full Cure: 6 to 8 hours  |
|  | <b>INTER-MIX 40 sec</b><br>Flexible / Semi-Flexible                 | 8409<br>(10 oz. cartridge)  | An extra-fast setting two part high strength flexible / semi-flexible epoxy adhesive, filler & surfacer.                              | Designed for bonding flexible / semi-flexible substrates such as polyurethane, rubber, most flexible plastic parts and other automotive parts. Great as a reinforcement on the back side of a two-sided repair.  | Working: 40 to 50 sec.<br>Handling: 5 to 10 min.<br>Sandable: 15 to 20 min.<br>Paintable: 20 to 30 min.<br>Full Cure: 6 to 8 hours  |
|  | <b>INTER-MIX 5 min</b><br>Hi-Stress Epoxy<br>Rigid / Semi-Rigid     | 8416<br>(10 oz. cartridge)<br>8001<br>(10 oz. tube kit - Hand Mix)                          | A two part high strength semi-rigid to rigid epoxy adhesive, filler & surfacer.   | Bonding, repairing or surfacing SMC, TPO, rigid plastic bumpers, fiberglass, steel, aluminum, glass and other rigid/semi-rigid typematerials.  | Working: 5 to 10 min.<br>Handling: 10 to 15 min.<br>Sandable: 10 to 20 min.<br>Paintable: 10 to 20 min.<br>Full Cure: 6 to 8 hours  |
|  | <b>INTER-MIX 5 min</b><br>Epoxyflex<br>Flexible / Semi-Flexible     | 8417<br>(10 oz. cartridge)<br>8010<br>(10 oz. tube kit - Hand Mix)                          | A two-part high-strength flexible epoxy adhesive, filler & surfacer.  | Bonding, repairing or surfacing urethane and TPO bumpers, filler panels and most flexible plastic parts.   | Working: 5 to 10 min.<br>Handling: 10 to 15 min.<br>Sandable: 10 to 20 min.<br>Paintable: 10 to 20 min.<br>Full Cure: 6 to 8 hours  |
|  | <b>EASY-SAND</b><br>Rigid / Flexible<br>5 Minute                    | 8080<br>(10 oz. tube kit - Hand Mix)  | A very easy sanding two-part epoxy adhesive, filler & surfacer designed for repairing most plastics.                                  | EASY-SAND was designed for use on rigid and flexible parts, as an adhesive, filler and surfacer, in thin film amounts (skim coat). Use of EASY-SAND in thick layers will result in less flexibility.   | Working: 5 min approx.<br>Handling: 10 to 15 min.<br>Sandable: 15 to 30 min.<br>Paintable: 10 to 20 min.<br>Full Cure: 6 to 8 hours |
|  | <b>QUICKIE-FIX 40 sec</b><br>Repairs Plastic & Metal Parts          | 8440 (50 ml. cart.)   | An extremely fast set, two-part high strength adhesive, filler & surfacer.  | A fast set epoxy repair compound used for bonding, filling and finishing. Used on plastics, FRP, SMC, fiberglass and metal parts. Great for bumper tab replacement.  | Working: 40 to 50 sec.<br>Handling: 5 to 10 min.<br>Sandable: 15 to 30 min.<br>Paintable: 20 to 30 min.<br>Full Cure: 6 to 8 hours  |
|  | <b>INTER-MIX 5 min</b><br>Epoxy Clear<br>Quick Setting Adhesive     | 8460 (10 oz. cart.)<br>8485 (50 ml. cart.)<br>8030 (30 ml. syringe - Hand Mix)              | A two part high strength semi-rigid to rigid epoxy adhesive, filler & surfacer.   | Bonding, repairing or surfacing SMC, fiberglass, most plastics, steel, aluminum, glass, wood and concrete.   | Working: 5 min.<br>Handling: 10 to 15 min.<br>Sandable: 15 to 30 min.<br>Paintable: 15 to 30 min.<br>Full Cure: 6 to 8 hours        |

NOTE: All times stated are approximate depending on temperature and humidity. All times are based on 70° to 75° at 50% relative humidity.  
All 10 oz. Inter-Mix and Inter-Weld Kits contain either 3 static mixing tips or 2 static mixing tip plus 2 Zip-Tips. Inter-Foam kits contain 2 static mixing tips.  
Please refer to Product Technical Data Sheets for applications and directions. © International Epoxies & Sealers • P.O. Box 185 • San Antonio, FL 33576 • 1.800.451.7206