

IES™ 8417 FLEXIBLE PLASTIC REPAIR PROCEDURES

Proper preparation of the substrate is 95% of the success of the plastic repair. At IES™, we have simplified the repair process.

The technician no longer needs to learn all of the different kinds of plastics by symbols, such as, TPO, SMC, TPUR, etc. There are over 2,000 different plastics used in the automotive marketplace, new, used and manufactured. Some have identification symbols and some do not have any at all.

Using the simplified IES™ Repair procedures, the technician needs to know only if the substrate is **flexible** or if the substrate is **rigid /semi-rigid**. If the substrate is rigid/semi-rigid, the only other identification that is needed is whether the substrate becomes 'greasy' when sanded or not.

THE ABOVE IS THE ONLY I.D. NEEDED!

FLEXIBLE PLASTIC REPAIR PROCEDURES

1. Clean off the painted surface with soap and water using a scuff pad. Rinse thoroughly with water and air dry.
2. With a clean cloth, use IES SUPER CLEAN™ (1700 quarts or 4700 aerosol) to clean all contaminants off of the painted surface, such as waxes and silicones.
3. Using a 120 grit D.A. sander, sand all the paint off of the substrate to be repaired - at least 3" to 4" past the area to be repaired.

NOTE: DO NOT ALLOW THE SUBSTRATE TO GET HOT!

(This releases plasticizers from the substrate and can be detrimental to the adhesion process.)

4. Now "dish" out the area to be repaired, sanding or grinding an area at least 1½" on both sides of the area to be repaired. Again, KEEP THE SUBSTRATE COOL while sanding.
5. If the repair is a tear, drill a 1/8" hole at both ends of the tear to help prevent further tearing.
6. If the tear or hole goes all the way through the plastic part, prepare the back side as the front side has been prepared, using steps 1 through 5.
7. Using a scuff pad, use soap and water to thoroughly scrub the bare substrate. Rinse thoroughly and let air dry completely.

NOTE: NEVER USE ANY SOLVENT ON BARE SANDED PLASTIC, THIS MAY CAUSE SWELLING AND/OR DISTORTION TO THE SUBSTRATE. DO NOT DRY USING AN AIR HOSE, AS THIS MAY CONTAMINATE THE SUBSTRATE.

8. If reinforcement is needed on the backside of the repair, use IES reinforcement fiberglass mesh tape or IES aluminum reinforcement tape. Apply the reinforcement tape across the repair area with one piece and then "X" apply a second piece across the first piece. (This adds about 4 times the strength to the repair.)
9. Use IES EPOXYFLEX™, in any dispensing form; squeeze tube 8010, cartridge 8011, quarts 8013, gallons 8015. Also, 8417 INTER-MIX 5™ or 8409 INTER-MIX 40sec FSF.

10. When using a hand-mix repair compound, mix equal amounts (1 to 1), of side A and side B together until the color is uniform with no streaks. For INTER-MIX self-mixing repair compounds, follow cartridge setup instructions. Apply repair compound on top of the reinforcement tape on the back side first with at least an 1/8" build. Be sure that the damaged area is lined up correctly. Allow repair compound to set.
11. After about 10 minutes, repeat step 10 on the front side without the reinforcement tape.

NOTE: When applying to the front side, ensure not to apply any of the repair compound on top of any painted surface, as this can lead to peel back and may not feather edge.

NOTE: EVEN THOUGH IES EPOXY CAN BE SANDED AND FINISHED AFTER APPROXIMATELY 10-15 MINUTES, FULL CURE ON ALL OF OUR EPOXIES TAKE 6 TO 8 HOURS AT 75°F.

12. After set-up of the repair compound, you can sand in approximately 10-15 minutes. Use 120 grit on a D.A. to sand down. **NOTE: KEEP THE SURFACE COOL.** IES recommends using the D.A. in an "on-off" process, feeling the surface frequently, to ensure the surface remains cool. After sanding and low spots are noted, scuff the low spots, mix additional repair compound and fill the low spots. Let set as before and hand sand to finish. Hand sand using 120 grit, then 320 grit, then 400 grit paper. **Optional:** IES 8080 Easy-Sand Filler/Surfacer may be used to fill in the low spots before the final sanding.
13. Use IES 4185 FLEXIBLE PRIMER SURFACER for any remaining light scratches. After IES 4185 dries hand sand using 400 grit paper, wet or dry.
14. Paint as per paint company's directions.

NOTE: ONLY ONE REPAIR PRODUCT IS NEEDED FOR THE COMPLETE REPAIR. BACKSIDE, MIDDLE, FRONTSIDE AND FINISH.



CAUTION: Wear gloves and eye protection when using products. Avoid contact with eyes, skin & clothing. Wash thoroughly after using. Do not breathe vapor. Use only in well ventilated areas. Do not take internally. In case of eye or skin contact, flush immediately with plenty of water.

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 workpersons. We have no control over the use and application of the contents herein. Our liability shall not exceed the purchase price.