TECHNICAL DATA

www.useies.com

#8422, #8423
INTER-MIX 90
Hybrid Panel Bonding Adhesive

A heavy-bodied two-part high strength epoxy/urethane adhesive that will bond to: Cold Rolled Steel, E-Coated Steel, Epoxy Primed Steel, Galvanized Steel, Aluminum, SMC, FRP (traditional fiberglass) and a wide variety of other plastics and metals. 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.

#8422 - (200ml) **#8423** - (225ml)

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

- **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°F - 80°F	60-90 Minutes
***De-Clamping Time:**	70°F - 80°F	6-8 Hours
	100° F	3 Hours
	140° F	60 Min.
	180° F	30 Min.
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 Substrates:	ASTM-D-1002 Average
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.*

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

FOR PROFESSIONAL USE ONLY.

Product Available

8422	6.76 fl. oz. (200ml) kit	4 per case
8423	7.6 fl. oz. (225ml) kit	4 per case