

INTER-MIX 90

Hybrid Panel Bonding Adhesive

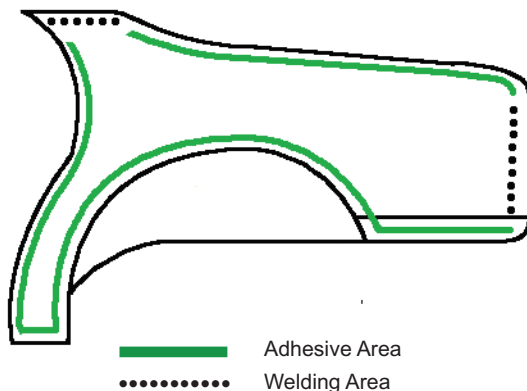
Products # 8422, #8423

Weld-Bonding

Directions

1. Wash all surfaces with soap or IES Super Foam (#4535) and rinse with water. Next, use IES Super Clean (#1700) or IES Specialty Adhesive Remover (#1780) to remove any grease, wax or other contaminants. Allow to dry completely.
2. Remove all paint, primer, corrosion and rust from surfaces to be bonded using a 36 grit abrasive Trim-Kut® Disc (#7060).
3. Straighten all metal and clamp replacement panel for proper alignment and fit.
4. Remove replacement panel from vehicle.
5. Clean all areas to be bonded with IES Super Clean (#1700) or IES Specialty Adhesive Remover (#1780) to remove any grease, wax or any other contaminants. Other cleaners may leave an oil film and prevent proper bonding.
6. Apply IES Weld-Thru Primer (#4525, #4526 or #4527) to the weld areas to ensure there will be no bare metal areas between the weld areas and the adhesive bond area.
7. Place adhesive cartridge in the applicator gun.
8. Remove end plugs from the nose of the cartridge. Tilting the gun back, pump the gun until both parts (A & B) are equally flowing from the cartridge. (See separate INTER-MIX™ gun loading instructions).
9. Attach the static mixer nozzle to the cartridge and tighten. Prior to applying adhesive, dispense a bead of adhesive approximately 1/2 of the length of the mixer or longer to ensure a proper uniform mix.
10. Apply IES Hybrid Panel Bonding Adhesive (#8422 or #8423) to all areas to be bonded (all bare metal surfaces). This means the replacement panel as well as the vehicle. Using a plastic spreader, tool out the adhesive to provide a base coat for an additional adhesive bead, ensuring all bare metal surfaces are coated.
11. Apply a bead of IES Hybrid Panel Bonding Adhesive (#8422 or #8423) approximately 1/4" from the inside edge of the replacement panel.
12. Clamp the panel into its proper position. When repositioning, slide the panel. Never lift the panel when repositioning. Apply clamps at 12" intervals or closer if necessary. In areas where clamps can not be applied, use sheet metal screws to hold the panel in place.
13. Tool any adhesive "squeeze out" to seal the outside seam along the bonded edge of the panel.
14. Weld appropriate areas (see diagram for specific panel replacement details). **CAUTION: Adhesive is combustible. Keep any MIG welding to a minimum of two inches from the adhesive. KEEP APPROPRIATE FIRE EXTINGUISHING EQUIPMENT WITHIN REACH AND BE AWARE TO ANY SMOKE OR FLAME THAT MAY BE PRESENT.** Resistant spot welding through uncured adhesive is permissible.
15. Spray the inside of the quarter at the bonded seams with IES INTER-GUARD Rust Proofing Wax "Honey Coat" (#4557) or INTER WAX Rustproofing, Clear Coating (#1695).
16. Clamps may be removed in approx. 6 to 8 hours. Panel may need to remain clamped if temperature is below 73°F or if there is any tension on the panel. Cure time is 24 hours. De-clamping time and cure time can be accelerated by applying heat with a heat gun or heat lamps. Be careful not to overheat. Do not exceed 180° F.

Working Time:	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.
Cure Time:	24 Hours



Quarter Panels

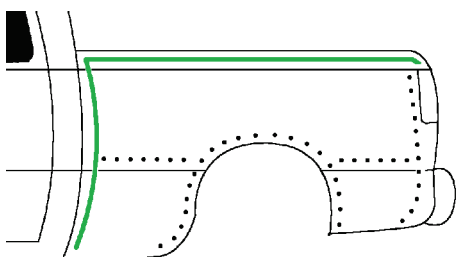
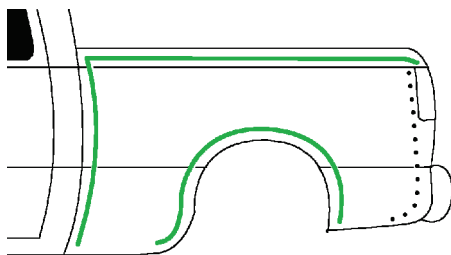
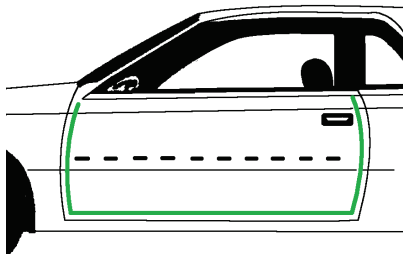
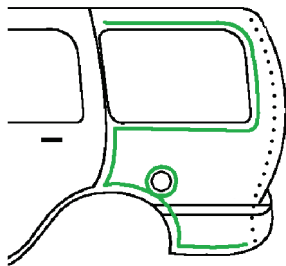
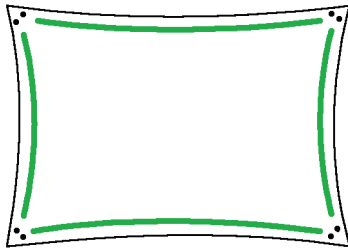
Cut or prepare the service panel for sectioning or replacement as per vehicle manufacturer's service replacement procedures. The rear portion where the quarter attaches to the rear body should be welded.




Sectioning at the sail panel should be welded. Follow vehicle manufacturer's procedures for proper welding.

Adhesive may be used in all other areas, lower panel, wheel opening, door jam, trunk drip rail if applicable. Follow IES Metal Panel Bonding Adhesive directions for surface preparation and applying adhesive.

INTER-MIX 90 Hybrid Panel Bonding Adhesive

Products # 8422, #8423



-  Adhesive Area
-  Welding Area
-  INTER-FOAM 5 Area

Roof Panels

Cut or prepare the service panel for replacement as per vehicle manufacturer's service replacement procedures.

Leave a space of two to four inches at each of the four corners to allow for two plug welds or a two inch lap weld.

Adhesive may be used around entire perimeter of the roof and on the roof bows if applicable.

Follow IES Hybrid Panel Bonding Adhesive directions for surface preparation and applying adhesive.

NOTE: On extended length van roof panels, it is recommended to put one plug weld in the center of each side of the roof panel.

Utility Vehicles and Van Side Quarters

Cut or prepare the service panel for replacement as per vehicle manufacturer's service replacement procedures.

The rear vertical portion should be welded and any joint/spliced/ section of the sail panel should be welded as per vehicle manufacturer's replacement procedures.

Adhesive may be used on the lowers, the wheel opening, door jam area, along the windows and where the panel meets the roof if applicable.

Follow IES Hybrid Panel Bonding Adhesive directions for surface preparation and applying adhesive.

Door Skins

Prepare the service panel for replacement and the door frame as per vehicle manufacturer's service replacement procedures.

Adhesive may be used on the entire part. Use IES INTER-FOAM 5 (#8451) Reinforcing Foam in-between the intrusion beam and door skin.

Follow IES Hybrid Panel Bonding Adhesive directions for surface preparation and applying adhesive.

Pickup Truck Box Sides (Outer Panel)

Prepare the service panel for replacement as per vehicle manufacturer's service replacement procedures.

The rear vertical portion should be welded.

Adhesive may be used on the top horizontal surface, where the outer panel hangs over the inner panel and the front edge of the box side.

Follow IES Hybrid Panel Bonding Adhesive directions for surface preparation and applying adhesive.

Pickup Truck Box Sides (Inner Panel)

Prepare the service panel for replacement as per vehicle manufacturer's service replacement procedures.

The rear vertical portion should be welded as well as the bottom of the panel where it attaches to the box floor, as well as the wheel opening.

Adhesive may be used on the horizontal surface, where the inner panel slides under the outer panel and the front edge of the box side.

Note: If the inner and outer panels are already pre-assembled, the adhesive will only be used at the wheel opening and the front edge of the box side.

Follow IES Hybrid Panel Bonding Adhesive directions for surface preparation and applying adhesive.

CAUTION: Although IES Hybrid Panel Bonding Adhesives (#8422, #8423) are classified as structural adhesives, it SHOULD NOT be used to bond structural components such as rails, core supports, pillars and rocker panels.