

REPAIR PROCEDURES



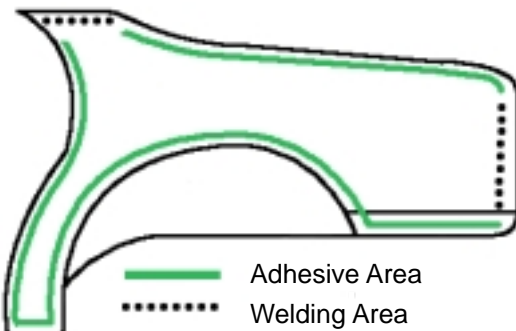
INTER-WELD™ 60 MSA Metal Panel Bonding Adhesive

Product # 8560

Weld-Bonding

1. Remove all paint, primer, corrosion and rust from surfaces to be bonded using IES #7060 36 grit Abrasive Trim-Kut Disc. When preparing aluminum surfaces use 80 grit abrasive disc.
2. Straighten all metal and clamp replacement panel for proper alignment and fit. There should be no tension on the replacement panels.
3. Remove replacement panel from vehicle.
4. Clean areas to be bonded with IES #1700 Super Clean or IES #4700 Super Clean to remove any grease, wax or any other contaminates. Other cleaners may leave an oil film and prevent proper bonding.
5. When bonding aluminum parts, apply IES #1840 RUST-RAIDER / Surface Prep to the bonding surfaces of the replacement panel and the vehicle. Allow 20 minutes etching time. Rinse with water or wipe off with a wet cloth, then wipe dry with a clean, dry cloth.
6. Apply IES #4525 or #4526 Weld-Thru Primer 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 the mixer nut and end plugs from the cartridge. Tilting the gun back, pump the gun until both parts (A & B) are equally flowing from the cartridge. (See separate INTER-MIX and INTER-WELD gun loading instructions).
9. Attach the static mixer nozzle to the cartridge and slide on the mixer nut and then tighten. Prior to applying adhesive, dispense a bead of adhesive approximately the length of the mixer or longer to ensure a proper uniform mix.
10. Apply IES #8560 INTER-WELD 60 MSA Adhesive to all areas to be bonded (cover 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 IES #8560 INTER-WELD 60 Adhesive approximately 1/4" from the inside edge of the replacement panel. We recommend attaching IES #8261 1/2" Zip-Tip or IES #8262 1" Zip-Tip to the mixer to keep from applying too much adhesive.
12. Clamp the panel into its proper position within 60 minutes. 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. **CAUTION: ADHESIVE IS FLAMMABLE when in a liquid state.** Allow adhesive to set before welding (approximately 1-1/2 to 2-1/2 hours).
Weld appropriate areas (see diagram for specific panel replacement details). Keep any welding to a minimum of two inches from the adhesive. Adhesive is combustible when cured and will burn. Refer to Material Safety Data Sheet.
15. Spray the inside of the quarter at the bonded seams with IES #4557 Honeycoat Corrosion fighter.
16. Clamps may be removed after welding or after adhesive has set, allow 1-1/2 to 2-1/2 hours. Panel may need to remain clamped for a longer time if temperature is below 75° F. Cure time is approximately 24 hours.

Note: Set times, de-clamping times, cure times etc. are based on 75 degrees F. Cooler temperatures may extend the time as warmer temperatures may lessen the time.

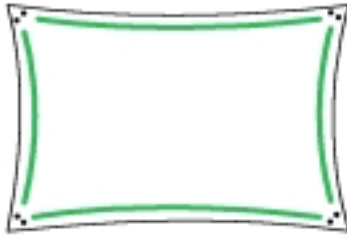


Quarter Panels

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 must 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 INTER-WELD 60 MSA directions for surface preparation and applying adhesive.



Roof Panels

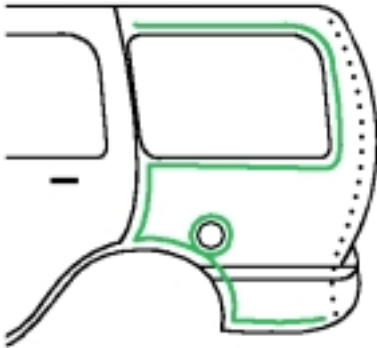
Cut or prepare the service panel for replacement as per vehicle manufacturer's service replacement procedures.

Leave a space of two 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 INTER-WELD 60 MSA directions for surface preparation and applying adhesive.

NOTE: On extended length van roof panels, it is recommended to put 2-3 evenly spaced plug welds in each side of the roof panel.



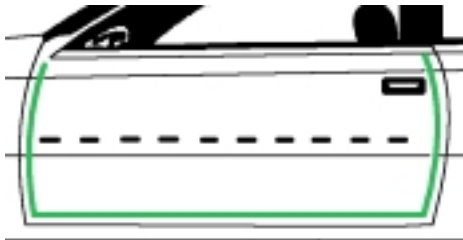
Utility Vehicles and Van Side Quarters

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

The rear vertical portion must be welded and any joint/spliced/ section of the sail panel must 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 INTER-WELD 60 MSA directions for surface preparation and applying adhesive.

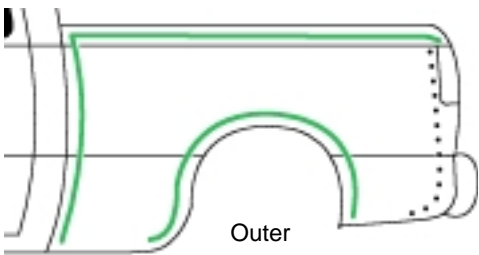


Door Skins

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 #8451 Inter-Foam 5 reinforcing foam in-between the intrusion beam and door skin.

Follow IES INTER-WELD 60 MSA directions for surface preparation and applying adhesive.



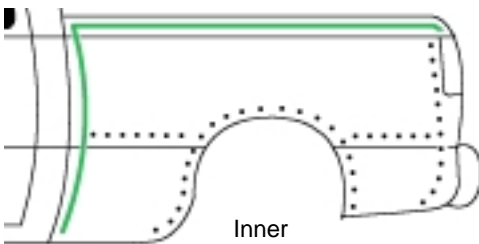
Pickup Truck Box Sides (Outer Panel)

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

The rear vertical portion must 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 INTER-WELD 60 MSA 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 front edge of the box side.

Follow IES INTER-WELD 60 MSA directions for surface preparation and applying adhesive.

CAUTION: Although IES #8560 INTER-WELD 60 ADHESIVE is classified as a structural adhesive, it **SHOULD NOT** be used to bond structural components such as rails, core supports, pillars and rocker panels.

-  Adhesive Area
-  Welding Area
-  Inter-Foam 5 Area