

**INTER-WELD 60 MSA
Methacrylate Structural Adhesive
Product No. 8560 (300mL Cartridge Kit)**

1:1 Mix ratio

PRODUCT DESCRIPTION

INTER-WELD 60 is a methacrylate structural adhesive that features an extended open time for bonding large components or for prolonged assembly operations.

INTER-WELD 60 offers outstanding adhesion to a wide variety of materials, including metal, fiberglass, composites, vinyl esters, gelcoats, and thermoplastics.

INTER-WELD 60 exhibits high strength and superior toughness over a wide temperature range including subzero temperatures. The formulation has special materials to curtail odor after application and during the long open time. This product has a unique benefit to end users concerned with read-through, it has a low exotherm in large masses to prevent sensitive parts from seeing distortion.

Working Time: 60 minutes approx.

De-clamping Time: 90 to 130 minutes

Full Cure Time: 24 hours approx.

INSTRUCTIONS FOR USE

1. Remove all paint, primer, corrosion and rust from surfaces to be bonded.
2. Clean areas to be bonded with IES Super Clean Product # 1700 or #4700. Other cleaners may leave an oily film and prevent bonding.
3. When bonding to aluminum substrates use IES #1840 Rust Raider Metal Etch. Follow directions on container to prepare bonding surfaces.
4. Load cartridge into gun IES #96211 or IES #96214 pneumatic gun and follow enclosed instructions. Prior to applying adhesive, dispense a bead of adhesive approximately the length of the mixer to ensure a proper mix.
5. Apply adhesive to both mating surfaces. Then using a spreader tool out the adhesive to ensure all bare metal surfaces are coated.
6. Secure the panel using clamps. The adhesive contains glass beads to prevent over clamping and to provide a consistent bond line. Use screws or rivets in hard to clamp areas. If repositioning is needed, slide the panels rather than remove and reapply. Tool any adhesive squeeze out to seal the bonded edge.
7. Allow adhesive to cure 1-1/2 to 2-1/2 hours before de-clamping.

UNCURED PROPERTIES

Part A Part B

Viscosity, cps (#7, 2.5 rpm)	305000	220,000
Viscosity, cps (#7, 20 rpm)	76,000	50,000
Color	natural	amber
Mix Ratio (wt & volume)	1: 1	

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Technical Data Sheet

Product 8560

CURING PROPERTIES*

Gel Time 55 – 65 minutes
Fixture Time (De-clamping time) 1-1/2 hrs to 2-1/2 hrs
Exotherm Time 85 – 95 minutes
Exotherm temp (Max) 90C (50 gram mall)*

Curing properties are highly dependent on the specific application and the materials being bonded. The ranges used here are based on representative examples of typical applications. Above values with 10 gram mass mixed in an open cover in a controlled lab test unless otherwise stated.

CURED PROPERTIES

Hardness Shore D 60-65
Elongation 20 – 30 %
Operating Temp -40F° - 250° F

BOND PERFORMANCE

Steel/Steel > 3000 psi Aluminum/Aluminum (acid etched) > 1500 psi
E-Coat/E-Coat Stock Failure Fiberglass/Fiberglass Stock Failure
GelCoat/GelCoat Stock Failure SMC Stock Failure
ABS Stock failure
Peel Strength, Steel/Steel (ASTM D1876) 20 pli
Impact Strength FG/FG, Auto Side Impact >3.78 J

CHEMICAL RESISTANCE

INTER-WELD 60 exhibits excellent resistance to commonly encountered service environments and chemicals. Depending on the materials being bonded, **INTER-WELD 60** will retain bond strength in boiling water, salt water, salt fog, kerosene, gasoline, diesel fuel, antifreeze, hydraulic fluids, and cutting oils. **Resistance to specific chemicals and environments must be tested.**

NOT RECOMMENDED FOR CONTINUOUS EXPOSURE TO: Crude oil, toluene, MEK, Acetone, 100% low molecular weight aromatics, aldehydes, and ketones.

Note: MMA's (Methyl-methacrylate Adhesives) are not compatible with Polyester resin / styrene repair compounds and fiber-glass gelcoats.

PACKAGING & SHELF LIFE

INTER-WELD 60 is available in 300 mL cartridges, pails, and drums. This material can be used with conventional meter/mix dispense equipment. All materials should be stored in a cool place when not used for an extended period of time. Shelf life of this product is (6) months. Shelf life may be extended with refrigeration. Do not freeze.

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