



INTER-MIX™ • INTER-WELD™ • INTER-FOAM™ & HAND MIX APPLICATION GUIDE

International Epoxies & Sealers™

	PRODUCT	NUMBERS	DESCRIPTION	APPLICATIONS/USES	TIMES
SEALERS	INTER-MIX 5 Adhesive/Sealer 5 Minute	8412 10 oz. cartridge	A non-sagging, semi-flexible adhesive / sealant.	A firm yet flexible seam sealer with excellent adhesion to: SMC, fiberglass, metal, aluminum and most plastics. Used for sealing vertical & horizontal seams and joints.	Working 5 to 10 min. Handling 10 to 20 min. Sandable 20 to 30 min. Paintable 20 to 30 min. Full Cure 6 to 8 hours
	INTER-MIX 15 Adhesive/Sealer 15 Minute	8411 10 oz. cartridge	A non-sagging, semi-flexible adhesive / sealant.	A firm yet flexible seam sealer with excellent adhesion to: SMC, fiberglass, metal, aluminum and most plastics. Used for sealing vertical & horizontal seams and joints.	Working 15 to 20 min. Handling 20 to 30 min. Sandable 45 min. Paintable 45 min. Full Cure 6 to 8 hours
	INTER-MIX 15 Adhesive/Sealer 15 Minute	8413 10 oz. cartridge	A non-sagging, extremely flexible adhesive / sealant.	A firm very flexible seam sealer with excellent adhesion to: SMC, fiberglass, metal, aluminum and most plastics. Used for sealing vertical & horizontal seams and joints.	Working 15 to 20 min. Handling 20 to 30 min. Sandable 45 min. Paintable 45 min. Full Cure 6 to 8 hours
	INTER-MIX 30 Flowable Seam Sealer 30 Minute	8410 10 oz. cartridge	A flowable, self leveling semi-flexible seam sealer with no tooling required.	Designed for sealing roof seams, drip rails and other horizontal seams. Ford Explorer, Bronco, Escort & Aerostar roof panels and various other horizontal applications.	Working 20 to 30 min. Handling 30 to 45 min. Sandable 60 min. Paintable 60 min. Full Cure 6 to 8 hours
BONDING ADHESIVES	INTER-MIX 45 Door Skin Adhesive 45 Minute	8415 10 oz. cartridge	A high strength two part epoxy adhesive.	Designed for bonding and sealing primed metal and SMC plastic type door skins and panels with flanges. <i>Note: Not for Camaro or Firebird late model door skins.</i>	Working 40 to 60 min. Handling 60 min. Sandable 60 min. Paintable 60 min. Full Cure 6 to 8 hours
	INTER-MIX 60 Metal Panel Bond 60 Minute	8420 10 oz. cartridge	A heavy body high strength epoxy adhesive. For Non-Structural Use Only.	Designed for bonding and sealing all automotive type steels and aluminum. Used in the replacement of quarter panels, roof panels, door skins, truck box sides & other outer body sheet metal.	Working 50 to 60 min. Handling 4 to 6 hours Full Cure 24 hours
	INTER-Weld 60 MSA Adhesive 60 Minute	8560 10 oz. cartridge	INTER-WELD 60 MSA is a 1:1 methacrylate structural adhesive featuring an extended open time.	Formulated for outstanding adhesion to a wide variety of materials, including metal, fiberglass, composites, vinyl esters, gelcoats and thermoplastics.	Working 55 to 60 min. Handling 90 to 130 min. Full Cure 24 hours approx.
	INTER-Weld 15 MSA Adhesive 15 Minute	8515 10 oz. cartridge	INTER-WELD 15 MSA is a 1:1 methacrylate structural adhesive.	Formulated to bond engineered thermoplastics, thermosets, composites and metal structural elements together in any combination. It forms tough, high strength, high impact, resistant bonds in all gaps.	Working 10 to 15 min. Handling 25 to 30 min. Full Cure 24 hours approx.
FOAMS	INTER-FOAM 5 Flexible Foam 5 Seconds	8451 10 oz. cartridge	A two-part flexible urethane foam formulated to expand 10 times its original volume. Will not bow out body panels.	Stops wind noise, water leaks & flutter in pillar posts, quarter panels, wheel housings & weather strips. Adds reinforcement to panels such as door skin brace, roof & hood panels.	Working 3 to 5 seconds Handling 2 to 3 min. Sandable not applicable Paintable 10 to 15 min. Full Cure 10 to 15 min.
	INTER-FOAM 10 Rigid Foam 10 Seconds	8455 10 oz. cartridge	A two-part rigid urethane foam formulated to expand 10 times its original volume.	Fills & reinforces pillar posts & box sections. Also stops wind, water & dust leaks. Eliminates panel flutter on cross members & provides sound deadening & compressive strength.	Working 10 to 25 seconds Handling 3 to 4 min. Sandable not applicable Paintable 10 to 15 min. Full Cure 30 to 45 min.
PLASTIC REPAIRS	INTER-MIX 5 Epoxyflex 5 Minute	8417 10 oz. cartridge 8010 10 oz. tube kit (Hand Mix)	A two-part high strength flexible epoxy adhesive, filler and surfacer.	Bonding, repairing or surfacing urethane and TPO bumpers, filler panels and most flexible plastic parts.	Working 5 to 10 min. Handling 10 to 15 min. Sandable 10 to 20 min. Paintable 10 to 20 min. Full Cure 6 to 8 hours
	INTER-MIX 40sec Flexible/Semi-Flexible 40 Seconds	8409 10 oz. cartridge	An extra-fast setting two part high strength epoxy adhesive, filler and surfacer.	Designed for bonding flexible/semi-flexible substrates such as polyurethane, rubber and other automotive parts.	Working 40 to 50 seconds Handling 5 to 10 min. Sandable 15 to 20 min. Paintable 20 to 30 min. Full Cure 6 to 8 hours
	INTER-MIX 5 Hi-Stress Epoxy 5 Minute	8416 10 oz. cartridge 8001 10 oz. tube kit (Hand Mix)	A two part high strength semi-rigid to rigid epoxy adhesive, filler and surfacer.	Bonding, repairing or surfacing SMC, TPO, rigid plastics, fiberglass, steel, aluminum, glass, and other rigid/semi-rigid type materials.	Working 5 to 10 min. Handling 10 to 15 min. Sandable 10 to 20 min. Paintable 10 to 20 min. Full Cure 6 to 8 hours
	INTER-MIX 40sec Rigid/Semi-Rigid 40 Seconds	8408 10 oz. cartridge	A two part high strength semi-rigid to rigid epoxy adhesive, filler and surfacer.	Bonding, repairing or surfacing SMC, TPO, rigid plastics, fiberglass, steel, aluminum, glass, and other rigid/semi-rigid type materials.	Working 40 to 50 seconds Handling 5 to 10 min. Sandable 15 to 20 min. Paintable 20 to 30 min. Full Cure 6 to 8 hours
	EASY-SAND Rigid/Flexible 5 Minute	8080 10 oz. tube kit (Hand Mix)	An easy sanding two-part epoxy adhesive, filler and surfacer designed for repairing most plastics.	EASY-SAND was designed for use on rigid and flexible parts, as an adhesive, filler and surfacer, in thin film amounts (skim coat). Use of EASY-SAND in thick layers will result in less flexibility.	Working 5 min. approx. Handling 10 to 15 min. Sandable 15 to 30 min. Paintable 10 to 20 min. Full Cure 6 to 8 hours
GENERAL	INTER-MIX 5 Epoxy Clear Quick Setting Adhesive 5 Minute	8460 5 oz. cartridge 8485 50 ml. cartridge 8030 30 ml. syringe (Hand Mix)	A two part rigid / semi-rigid high strength adhesive, filler, laminator and surfacer.	Bonding, repairing or surfacing SMC, fiberglass, most plastics, steel, aluminum, glass, wood and concrete.	Working 5 min. Handling 10 to 15 min. Sandable 15 to 30 min. Paintable 15 to 30 min. Full Cure 6 to 8 hours

Notes: All times stated are approximate depending on temperature and humidity. All times are based on 70° to 75° at 50% relative humidity.

Please refer to Product Technical Instructions for applications and directions

All 10 oz. Inter-Mix and Inter-Weld Kits Contain either 3 Static Mixing Tips Or 2 Static Mixing Tips Plus 2 Zip Tips. Inter-Foam Kits Contain 2 Static Mixing Tips.

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