



DUAL COMPONENT APPLICATION GUIDE

NOTE: 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 Data Sheets for applications and directions.
© International Epoxies & Sealers • P.O. Box 185 • San Antonio, FL 33576 • 1.800.451.7206 • www.useies.com

	PRODUCT	NUMBERS	DESCRIPTION	APPLICATION / USES	TIMES
SEALERS	INTER-MIX 15 min Limited Flow Semi-Flexible	8411 10 oz./300 ml 8611 6.76 oz./200 ml	A non-sagging, semi-flexible adhesive / seam sealer.	A firm yet semi-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: Immediately Full Cure: 6 to 8 hours
	INTER-MIX 5 min Limited Flow Semi-Flexible	8412 10 oz./300 ml 8612 6.76 oz./200 ml	A non-sagging, semi-flexible adhesive / seam sealer.	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: Immediately Full Cure: 6 to 8 hours
	INTER-MIX 10 min Bare Metal "Thick Set" Semi-Flexible	8405 10 oz./300 ml (gray) 8603 7.4 oz./220 ml (white) 8604 7.4 oz./220 ml (beige) 8605 6.76 oz./200 ml (gray) 8606 7.4 oz./220 ml (black)	A thick-set, non-sagging, firm, semi-flexible bare metal adhesive / seam sealer. Will hold brush marks.	Designed for sealing vertical and horizontal seams and joints on automobiles and truck applications. May be applied to bare metal and primed sheet metal joints. Excellent adhesion to: bare metal, primed metal, SMC, FRP, fiberglass, aluminum and most plastics. <i>Passes 1500 hour salt fog test!</i>	Working: 10 to 15 min. Handling: 30 to 45 min. Sandable: 45 min. Paintable: Immediately Full Cure: 6 to 8 hours
	INTER-MIX 15 min Adhesive/Sealer Extremely Flexible	8413 10 oz./300 ml 8613 6.76 oz./200 ml	A thick-set, non-sagging, extremely flexible adhesive / seam sealer. Will hold brush marks.	A firm yet extremely flexible seam sealer with excellent adhesion to: SMC, fiberglass, metal, aluminum and most plastics. Used for sealing vertical & horizontal seams and joints where flexing occurs.	Working: 15 to 20 min. Handling: 20 to 30 min. Sandable: 45 min. Paintable: Immediately Full Cure: 6 to 8 hours
	INTER-MIX 30 min Control Flow Semi-Flexible	8410 10 oz./300 ml 8610 6.76 oz./200 ml	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 90 min Hybrid Panel Bond	8422 6.76 oz./200 ml <i>Glass beads ensure consistent bond-line thickness.</i>	A heavy bodied, two part high strength hybrid epoxy/urethane adhesive.	A urethane/epoxy hybrid designed to bond with a wide variety of metal, aluminum and plastic substrates. <i>Working/de-clamping times may be accelerated with heat.</i>	Working: 60 to 90 min. Handling: 6 to 8 hrs. Full Cure: 24 hrs approx.
	INTER-MIX 45 min Door Skin Adhesive	8415 10 oz./300 ml 8615 6.76 oz./200 ml	A high-strength, two-part epoxy adhesive featuring an extended working time of 45 minutes.	Designed for bonding and sealing primed metal and SMC plastic type door skins and panels with flanges. NOTE: Not for Camaro or Firebird late model door skins.	Working: 45 to 60 min. Handling: 120 min. Sandable: 60 min. Paintable: 60 min. Full Cure: 6 to 8 hours
	INTER-MIX 60 min SMC Panel Adhesive	8414 10 oz./300 ml <i>Glass beads ensure consistent bond-line thickness.</i>	A non-sag, high-strength, two-part epoxy adhesive. For use in truck, automotive & marine applications.	Designed to provide tough, durable bonds to SMC panels, metal space frames and fiberglass. This product is ideal for splicing as well as panel replacement.	Working: 50 to 60 min. Handling: 4 to 6 hours Full Cure: 24 hours
	INTER-MIX 20 min Panel Bonding Adhesive	8430 6.76 oz./200 ml <i>Glass beads ensure consistent bond-line thickness.</i>	A methacrylate structural adhesive formulated to bond engineered thermoplastics, thermosets, composites and metal structural elements.	Designed for bonding all automotive type steels, aluminum, SMC, engineered thermoplastics, thermosets and composites together in any combination. Used in the replacement of quarter panels, roof panels, door skins, truck box sides and other outer body sheet metal.	Working: 20 to 25 min. Fixturing Time: 45 to 60 min. Full Cure: 24 hours
FOAMS / SOUND DEADENERS	INTER-FOAM 5 Flexible Foam 5 Second	8451 10 oz./300 ml 8651 6.76 oz./200 ml 8449 1.76 oz./50 ml	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 in pillar posts, quarter panels, wheel housings and weather strips. Adds reinforcement to panels such as door skin brace, roof and hood panels. Eliminates panel flutter.	Working: 3 to 5 sec. 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 Second	8455 10 oz./300 ml 8655 6.76 oz./200 ml	A two-part rigid urethane foam formulated to expand 10 times its original volume.	Fills and reinforces pillar posts and box sections. Stops wind water and dust leaks. Provides sound deadening and compressive strength.	Working: 10 to 25 sec. Handling: 3 to 4 min. Sandable: not applicable Paintable: 10 to 15 min. Full Cure: 30 to 45 min.
	NVH 60 Noise, Vibration Dampening Material	8445 10 oz./300 ml 8645 6.76 oz./200 ml	An two part urethane elastomer with excellent acoustical properties.	Eliminates panel resonance and panel flutter. Absorbs shock and vibration. Reduces noise. Remains flexible with excellent adhesion, even to existing foam. Non sagging, will not shrink.	Working: 60 min. Cure Times: 24 hours @ 77°F 1 hour @ 160°F 30 min @ 210°F
	BEAD-IT Sound Deadener & Seam Sealer	8406 10 oz./300 ml	A black, thick-set, firm but semi-flexible sound deadener/seam sealer that can be applied to various surfaces.	Designed to duplicate the sound deadener beads that are applied from the manufacturer. Can be applied to various surfaces such as: bare metal, primed or painted surfaces to help deaden sound and seal seams.	Working: 10 to 15 min. Handling: 30 to 45 min. Sandable: 45 min. Paintable: 45 min. Full Cure: 6 to 8 hours
GENERAL REPAIR: METAL, PLASTIC, FIBERGLASS, ALUMINUM, ETC.	INTER-MIX 40 sec Flexible / Semi-Flexible	8409 10 oz./300 ml	An extra-fast setting two part high strength flexible / semi-flexible epoxy adhesive, filler & surfacer.	Designed for bonding flexible / semi-flexible substrates such as polyurethane, rubber, most flexible plastic parts and other automotive parts. Great as a reinforcement on the back side of a two-sided repair.	Working: 40 to 50 sec. Handling: 5 to 10 min. Sandable: 15 to 20 min. Paintable: 20 to 30 min. Full Cure: 6 to 8 hours
	INTER-MIX 5 min Hi-Stress Epoxy Rigid / Semi-Rigid	8416 10 oz./300 ml 8616 6.76 oz./200 ml 8001 10 oz./300 ml (tube kit, hand-mix)	A two part high strength semi-rigid to rigid epoxy adhesive, filler & surfacer.	Bonding, repairing or surfacing SMC, TPO, rigid plastic bumpers, 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 5 min Epoxyflex Flexible / Semi-Flexible	8417 10 oz./300 ml 8617 6.76 oz./200 ml 8010 10 oz./300 ml (tube kit, hand-mix)	A two-part high-strength flexible epoxy adhesive, filler & 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
	EASY-SAND Rigid / Flexible 5 Minute	8480 10 oz./300 ml 8680 7.4 oz./220 ml 8080 10 oz./300 ml (tube kit, hand-mix)	A very easy sanding two-part epoxy adhesive, filler & 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
	QUICKIE-FIX 40 sec Repairs Plastic & Metal Parts	8440 1.76 oz./50 ml	An extremely fast set, two-part high strength adhesive, filler & surfacer.	A fast set epoxy repair compound used for bonding, filling and finishing. Used on plastics, FRP, SMC, fiberglass and metal parts. Great for bumper tab replacement.	Working: 40 to 50 sec. Handling: 5 to 10 min. Sandable: 15 to 30 min. Paintable: 20 to 30 min. Full Cure: 6 to 8 hours
	QUICKIE-FIX 1.5 Plastic Bonding Adhesive	8642 1.76 oz./50 ml 8643 6.76 oz./200 ml	A fast set plastic bonding adhesive.	Used for bonding & repairing small panels, bumper tabs, headlamp buckets, header panels, etc.	Working: 90 sec. Handling: 90 sec. Sandable: 30 min. Paintable: 30 min. Full Cure: 24 hours
	INTER-MIX 5 min Epoxy Clear Quick Setting Adhesive	8460 10 oz./300 ml 8485 1.76 oz./50 ml 8030 1.01 oz./30 ml (syringe kit, hand-mix)	A two part high strength semi-rigid to rigid epoxy adhesive, filler & 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