

INTER-CLAD DOUBLE-DUTY 1K ADHESION PRIMER & SEALER

IES INTER-CLAD DOUBLE-DUTY 1K Adhesion Primer & Sealer is a 2 in 1 elastomeric coating that facilitates adhesion to TPO, TEO and PP substrates. IES INTER-CLAD has a built in adhesion promoter that saves you time and money. Topcoat can be applied without the need of sanding or scuffing as soon as it is dry. Ideal for easy refinishing of new, unprimed OEM replacement bumpers.



PRODUCT SPECIFICATIONS

Color:	Light Gray
Cure Time (70°F):	50-60 minutes
Cure Time (130°F):	15-20 minutes
Recommended Coats:	2
Flash Time Between Coats:	5 minutes
VOC Content:	22-24%
Viscosity (#2 Zahn):	19-21 Seconds
Gun Nozzle:	.8 - 1.4mm

DIRECTIONS

1. Wash all areas to be painted with soap and water then wipe down with *Super Clean 2 Plastic Cleaner*. Any dirt, oils, grease or other contaminants must be removed. If the part has previously been painted or primed, scuff the surface with a coarse scuff pad and then clean & wipe with *Super Clean 2 Plastic Cleaner*.
2. Hand stir the contents thoroughly until it is evenly mixed. Use a paint shaker if desired. *IES Double Duty* is ready to be sprayed, but may be thinned with acetone (up to 5% by volume).
3. Apply with a 0.8-1.4mm base-coat gun for fine atomization. Spray the surface evenly with a light coat. After 3 to 5 minutes, apply a heavier coat to completely cover the surface. (If a heavier build up is desired, an additional coat may be applied).
4. After application allow the surface to dry for at least 1 hour at standard room temperature or bake for 15 minutes at 130°F before applying topcoat. Scuffing or sanding is not required prior to applying topcoat and can be top coated at any time after it has dried completely. There is no close on the window for top coating.

***Provides superior adhesion to
TPO, TEO & PP plastics.***

Works on flexible or rigid substrates

No sanding or scuffing is required.

Outstanding flexibility

***Ideal for easy refinishing of new, unprimed
OEM replacement bumpers.***

***1K Formulation = No Waste
(Pour the contents directly back into the can)***

Low VOC - 50 State Compliant!

STORAGE

Product should be stored in a cool, dry location in unopened containers at a temperature between 50°F to 85°F (10°C to 30°C) unless otherwise labeled. Protect package from direct sunlight and heat. Do not handle or store near open flame or other sources.

PRODUCT AVAILABLE

1815	Quart Can (0.95 L)	4/box
1816	Gallon Can (3.79 L)	1/box

These suggestions and data are based on information we believe to be reliable and accurate, but no guarantee of their accuracy is made. International Epoxies & Sealers shall not be liable for any damage, loss or injury, direct or consequential arising out of the use or the inability to use the product. In every case, we urge and recommend that purchasers, before using any product in full scale production, make their own tests to determine whether the product is of satisfactory quality and suitability for their operations, and the user assumes all risk and liability whatsoever, in connection therewith.

Cost & Time Analysis Of Using INTER-CLAD vs. "Traditional Method"

DIRECTIONS OF APPLICATION

Here are the standard directions that we have for the application of this product.
As mentioned, no scuffing, sanding or adhesion promoter is needed.

1. Clean the bumper. Use either Wax & Grease Remover or some type of plastic cleaner. Spray on a wet coat and then wipe with a clean cloth in one direction. For superior adhesion, you can wash the bumper with a scuffing compound. No adhesion promoter is necessary.
2. Spray the INTER-CLAD Primer & Sealer. An HVLP gun is recommended with a spray pressure of 25-35 psi. This primer is ready to spray but you can reduce it down with paint thinner up to 5% by volume. Make sure the primer is well mixed before application.
3. Allow the bumper to dry. For us to comfortably warrant the adhesion, we recommend waiting 60 minutes for the bumper to dry at room temperature or about 15 minutes at 130°F. There is no closing window so it can be topcoated once the primer is dry.

Cost	Time	Traditional	Using INTER-CLAD	Cost	Time
\$0.78	5 min	Soaping	Soaping	\$0.78	5min
\$0.31	5 min	W&G Remover	W&G Remover	\$0.31	5 min
\$6.00	15 min	Adhesion Promoter	N/A	\$0.00	N/A
\$12.00	2 hr 10 min	2K Primer	INTER-CLAD	\$12.13	1 hr
\$1.00	30 min	Sanding	N/A	\$0.00	N/a
\$20.09	3 hr 5 min	Total to Basecoat	Total to Basecoat	\$13.22	1 hr 10 min

How these numbers were obtained:

- Soaping - Assuming 5oz. of a scuffing agent is used at \$20/gal: $5/128 * \$20.00/\text{gal} = \0.78
- W&G Remover - Assuming 3 oz. of W&G Remover is used at \$65/5 gal: $3/640 \text{ oz} * 65/5 \text{ gal} = \0.31
- Adhesion Promoter - The most popular "Bulldog Adhesion Promoter" using 6 oz. of a 20 oz. aerosol can at \$20/can = \$6.00
- 2K Primer - Assuming a \$120 2K kit is used using 1 gal/1 qt. and 8 oz. of the 160 oz. mixture is used for the spot repair: $16/160 * \$120 = \12.00
- INTER-CLAD - 8 oz. of INTER-CLAD is needed for 16 oz. required of an ordinary 2K Sanding Primer. At \$194/gal: $8/128 * \$194 = \12.13
- Sanding - Cost of sandpaper was assumed at \$1.00 for all use.

Additional Factors To Consider:

- 1K Formulation = No Waste. Pour the contents directly back into the can. Once the 2K Primer is mixed, any amount not used cannot be reused.
- No closing window on INTER-CLAD.
- Can be used for smooth and textured coatings.

As shown above, the cost of using INTER-CLAD comes out to about 2/3 the price of the conventional method, using the above price assumptions. Additionally, the time application is cut by about 2 hours. When considering cost of labor and cost of materials, INTER-CLAD provides a more cost-effective bumper repair solution for body shops.

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