

## INTER-MIX 90

### Hybrid Panel Bonding Adhesive



A heavy-bodied two-part high strength epoxy/urethane adhesive that will bond to a wide variety of metal and plastic substrates. When used according to specific directions IES Hybrid Panel Bonding Adhesive may be used in the replacement of: Quarter Panels, Door Skins, Roof Panels, Truck Box Sides and other Outer Body Sheet Metal.

Do not use on structural components such as Rails, Rocker Panels, Core Supports, Pillars, etc.

- 2:1 Cartridge
- High Strength Bond
- Reduces Welding Time
- Reduces Fire Risks
- Provides Corrosion Protection
- Contains Glass Beads to Maintain A Constant Bondline Thickness.
- Bonds & Seals Simultaneously
- Weld-Through When Using Squeeze-Type Resistance Spot Welding
- Reduces Warpage
- Lifetime Limited Warranty when used as per directions.

#### TYPICAL PROPERTIES

	Temperature	
*Working Time:	70°F - 80°F	60-90 Minutes
*De-Clamping Time:	70°F - 80°F	6-8 Hours
	100° F	3 Hours
	140° F	60 Min.
	180° F	30 Min.
Total Cure Time:		24 Hours

\* Working /De-Clamping time may be accelerated when used in conjunction with heat. Please refer to the "Weld Bonding Procedures or SMC Bonding Procedures" for more information.

Lap Shear Strength Test                      ASTM-D-1002 Average  
Substrates:

Cold Rolled Steel                              3500 psi\*\*  
Aluminum                                        3500 psi\*\*

\*\* Substrates were cleaned with IES Super Clean and abraded with IES 7060 36 grit Trim-Kut Disc.

Please refer to the SDS and product label before using this or any IES product. Additional information and Repair Procedures can be found online at [www.useies.com](http://www.useies.com)

#### 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

8422	6.6 fl. oz. (200ml) kit Each kit includes two #8265 static mixers & one 1/2" and one 1" Ribbon Zip-Tip	4/box
8423	7.6 fl. oz. (225ml) kit Each kit includes two #8265 static mixers & one 1/2" and one 1" Ribbon Zip-Tip	4/box



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