

8460

INTER-MIX 5

Epoxy - Clear
Quick Setting Adhesive

INTER-MIX 15 Epoxy Clear Quick Setting Adhesive is a fast setting high strength adhesive, laminator and re-surfacer designed for bonding metals, plastics, fiberglass, SMC, FRP, glass, wood & concrete. Used to reattach emblems & decorative trim, repairs tail lamps & lens housings. Can be used with fiberglass cloth or mat to reinforce repairs.

100% Solids, No VOC's!

**Semi-rigid, some flexibility
after cured**

DIRECTIONS

1. Clean the area to be bonded with IES #1700 or IES #4700 Super Cleaning Solvent or IES #1780 Specialty Adhesive Remover.
2. Scuff the area to be bonded with 80-grit sandpaper.
3. If parts to be bonded are TPO or Polypropelene types of plastic, use IES #4182 INTER-BOND Adhesion Promoter.
4. Apply Epoxy Clear Adhesive to the part to be bonded and quickly mate the parts. Clamp or tape the parts together into position until handling strength is achieved.
5. If Epoxy Clear is to be painted, scuff or sand prior to painting. Prime and paint per manufacturer's specifications.

CAUTION:

Before using this or any IES product, refer to the Material Safety Data Sheet (MSDS) and label for safe use and handling instructions.

TECHNICAL INFO

Work Time:	5 Minutes
Handling Time:	10 to 15 Minutes
Paintable/Sandable:	15 to 30 Minutes
Full Cure Strength:	6 to 8 Hours

Application Temp: 70 - 90°F (21-32°C)

*Storage Temp: Below 75°F (24°C)
Dry conditions*

FOR PROFESSIONAL USE ONLY.

PROPERTIES:

Color:	Clear to Amber
Hardness Shore D Cured @ 75°F for one day:	79
Tensile Lap Shear Strength psi 75°F For 4 Hours:	1200
Exotherm:	149°C
Service Temp:	-40°F to 200°F
Viscosity Mixed A&B:	15,000 Cps

Product # 8460
10 fl. oz. kit (300mL)
Packaged 4 per case

Directions for using 200mL / 300mL 2008 Dual-Mix Cartridge products

www.internationalepoxies.com

Press release lever and pull plunger rods all the way back. (Fig. A)



Figure A

Place back end of the twin cartridge onto the plungers first. (Fig. B)



Figure B

Bring down the front of the cartridge and seat into the gun. (Fig. C)



Figure C

To remove cap, insert flat head of screw-driver into slot and pry upward. (Fig. D)



Figure D

Remove cap completely from cartridge. (Fig. E)
Cap can be re-inserted to seal a partially used cartridge. To avoid cross contamination, match up the circles and squares on the cap and top of the cartridge body.



Figure E

Tilting the gun back, pump the gun until the product flows equally from both chambers. This procedure equalizes the chambers to insure an equal mix. This is a very important step. (Fig. F)

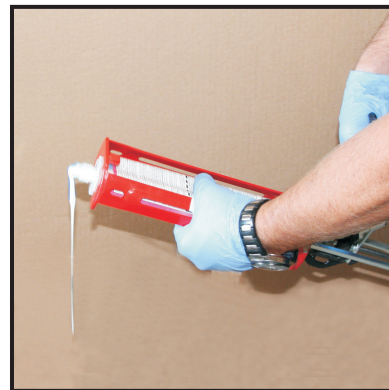


Figure F

Install the static mixer nozzle on the end of the nosepiece and tighten in a clockwise direction until securely fastened. (Fig. G)



Figure G

Pump material through the mixer nozzle. Discard the first 3 inches of product, then proceed with application. (Fig. H) To retain unused product, remove the mixer nozzle and install the cap into the appropriate sides of the cartridge after use.



Figure H