

INTER-MIX 45 DOOR SKIN ADHESIVE

INTER-MIX 45 Door Skin Adhesive is a high strength adhesive designed for bonding and sealing flanged type door skins. Specially formulated to provide the proper degree of flexibility that is necessary to withstand the repeated shock caused by slamming doors.

DIRECTIONS

1. Remove the original door skin by grinding the outer edge of the skin.
2. Chisel and peel back the remainder of the door skin from the door flange.
3. Align and sand the door flange to prepare it for painting.
4. Clean areas to be bonded and primed with IES 1700/4700/1780 solvent.
5. Prime all bare metal with epoxy or urethane primer. Allow primer to cure according to manufacturer's recommendations. Scuff and wipe clean the bonding surfaces.
6. Follow the IES dual cartridge set up instructions for loading cartridge into the dispensing gun.
7. Lay the door skin flanged side up, on a carpeted table or rack and apply a 13mm or ½ inch bead of 8415/8615 adhesive on the flange. Lower the door frame onto the skin and align. Fold the door skin flange over the edge of the door frame. Then smooth out and remove excess adhesive.
8. IES 8415/8615 adhesive will set up in approximately 40 to 60 minutes. Allow 120 minutes before handling.
9. Scuff or sand sealer with 320 grit sandpaper prior to priming or painting.
10. Prime and paint per manufacturer's specifications

Note: Not for Camaro or Firebird late model door skins

CAUTION

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



Door Skin Adhesive
Gray

TECHNICAL INFO

| | |
|--------------------|---------------|
| Mixed Color | Gray |
| Mix Ratio | 1:1 |
| Work time | 40-60 Minutes |
| Handling Time | 120 Minutes |
| Part Paintability | 60 Minutes |
| Sealer Sandability | 60 Minutes |
| Full Cure Strength | 6-8 Hours |

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

STORAGE

Should be stored in a cool, dry location at a temperature between 50°F to 86°F (10°C to 30°C).

PRODUCT AVAILABLE

| | | |
|-------------|--|------------|
| 8415 | 10 fl. oz. kit (300mL) <i>Each kit includes three #8260 static mixers</i> | 4 per case |
| 8615 | 6.76 fl. oz. (200 mL) <i>Each kit includes two #8260 static mixers</i> | 6 per case |

NOTICE TO PURCHASER: The following warranty is in lieu of all other expressed or implied warranties, specifically all goods are manufactured of first class materials and by competent professionals. We have no control over the use and application of our products. Our liability shall not exceed the purchase price.