



MINI-MAX™ GENERAL PURPOSE ADHESIVE

TECHNICAL DATA SHEET



Check local VOC regulations to ensure compliance of all products in your area.

DESCRIPTION

Mini-Max General Purpose Adhesive is a two-component epoxy based adhesive for fast bonds on most surfaces.

FEATURES

- Superior adhesion
- Ideal working time
- Bonds multiple substrates

SUITABLE SUBSTRATES

- SMC
- Fiberglass
- Steel
- Aluminum

TYPICAL PROPERTIES

Part:	Product Name:	Color:	Container:
68432	General Purpose Adhesive	Black	1 oz. Mini-Max Cartridge
Working time:	3 minutes @ 70°F (21°C)		
Set time:	7 minutes @ 70°F (21°C)		
Cure time:	60 minutes @ 70°F (21°C)		
Heat cure time:	15 minutes @ 120°-140°F (49°-60°C)		
Lap shear strength:	1800-2000 psi (ASTM D 1002)		

HANDLING AND APPLICATION

PREPARATION:

1. Clean with **Scuff & Clean** and rinse with water.
2. Clean with **Plastic & Leather Prep** or **XXX Universal Surface Cleaner**.

Note:

Take care to avoid saturating any exposed fibers.

MIXING:

Remove cap between pistons. Cut off cartridge tips at perforation. Dispense material and mix until uniform.

APPLICATION:



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FOR USE WITH PLASTIC REPAIR REINFORCING TAPE:

1. Clean surface as outlined in Preparation section.
2. Sand with 80 grit paper 2-3 inches around damaged area. “V” groove damaged area with a 24-36 grit disc. Blow off dust.
3. Lay **Plastic Repair Reinforcing Tape** on the back side of the repair.
4. Dispense **Mini-Max General Purpose Adhesive** over the **Plastic Repair Reinforcing Tape** and spread firmly 2-3 inches beyond repair.
5. Finish repair with appropriate filler.

GENERAL PURPOSE BONDING:

1. Clean surface as outlined in Preparation section.
2. Sand painted areas to be bonded with 180 grit paper and clean with **Plastic & Leather Prep** or **XXX Universal Surface Cleaner**.
3. For impact strips and side moldings, mask both sides of the surface where adhesive is to be applied.

IMPORTANT:

DO NOT ALLOW **Mini-Max General Purpose Adhesive** TO FLOW OVER MASKED AREA OR ONTO PAINTED SURFACE.

4. Apply **Mini-Max General Purpose Adhesive** to surface to be bonded.
5. Hold or clamp firmly. Repair piece will be securely bonded in 30 minutes. Allow another 30 minutes for full cure.

Note:

For larger repairs, **Non-Sag Fast Set Adhesive** in the 7 oz. **Dual-Mix** cartridge is also available.

STORAGE:

General Purpose Adhesive should be stored in a cool dry place with adequate ventilation away from heat, sparks and flames. The shelf life for **General Purpose Adhesive** is 1 year when stored under normal conditions.

RELATED PRODUCTS:

Part:	Product Name:	Size:
38351	Plastic & Leather Prep	Gallon
38353	Plastic & Leather Prep	16 oz. Aerosol
38354	Plastic & Leather Prep	Quart
38391	Scuff & Clean	Gallon
38398	Scuff & Clean	16 oz. Tube
39907	Non-Sag Fast Set Adhesive	7 oz. Cartridge
77771	XXX Universal Surface Cleaner	Gallon



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77774	XXX Universal Surface Cleaner	Quart
40542	Carbo-Fill+	Tube
70006	Plastic Repair Reinforcing Tape	36' Roll
