



# 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.

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### 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.

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### 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 |

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### Technical Consultation Service

Our Technical Staff is ready to assist you with any questions. You are invited to take advantage of our extensive experience, laboratory services and trained field service representatives. Call (800) 831-1122 for answers to your questions. Hours of operation are Monday through Thursday 8:00 am until 5:00 pm EST and on Friday 8:00 am until 4:30 pm EST.

#### Disclaimer:

The information supplied in this document is for guidance only and should not be construed as a warranty. All implied warranties are expressly disclaimed. All users of the materials are responsible for assuring that it is suitable for their needs, environment and use. All data subject to change as SEM deems appropriate.

Users should review the Safety Data Sheet (SDS) and product label for the material to determine possible health hazards, appropriate engineering controls and precautions to be observed in using the material. Copies of the SDS and product label are available upon request.