

MINIPUR 15

PRODUCT DESCRIPTION

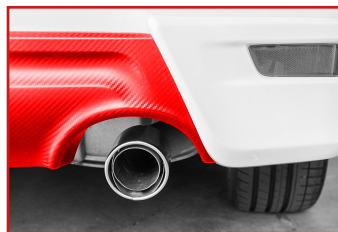
MINIPUR 15 is a structural 2-part polyurethane adhesive.

PRODUCT CHARACTERISTICS

MINIPUR 15 is fast curing, resistant to elevated temperature, moisture, fuel, many solvents and chemicals. MINIPUR 15 shows early sanding and painting capability. It shows good sag resistance properties, allowing vertical application and offers excellent gap filling properties.

TYPICAL APPLICATIONS (professional use)

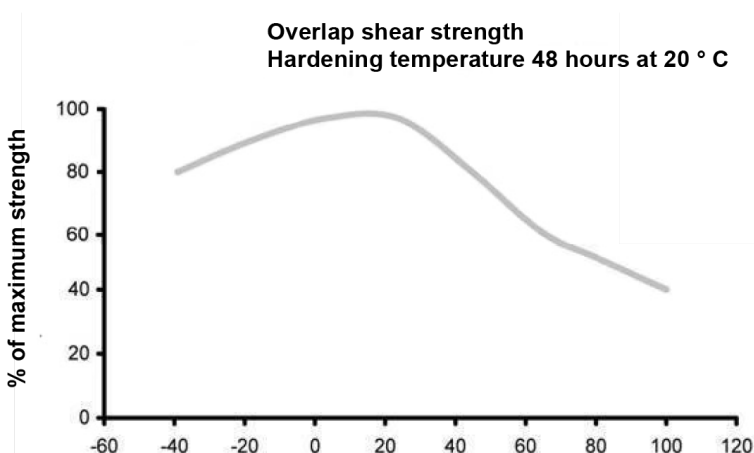
- Small, quick, durable bonding and repair jobs.
- In combination with a reinforcing mesh broken or missing bumper tabs can be rebuilt.



TECHNICAL DATA

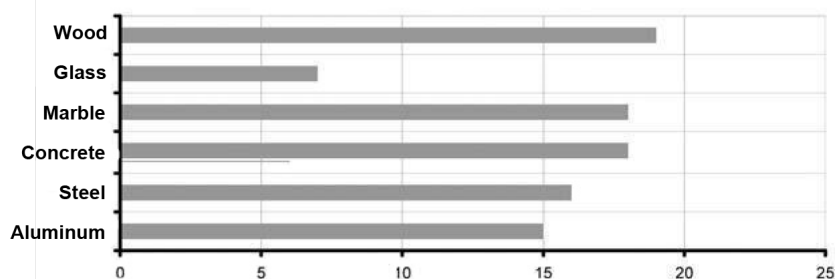
Composition:	reactive isocyanate prepolymer
Consistency:	paste
Specific gravity:	1,28 g/cm ³ approx.
Viscosity:	60.000 mPas approx.
Tooling time (+23°C):	3 minuti approx.
Sanding time (+23°C):	10 minuti approx.
Processing time (+23°C):	5 minuti approx.
Shore D hardness (EN ISO 858, +23°C):	63
Tensile strength (EN ISO 527, +23°C):	23 mPa
Young's modulus (EN ISO 527, +23°C):	420 mPa
Elongation at break (EN ISO 527, +23°C):	55%
Glass transition temperature (EN ISO 11357)	+65°C
Resistivity:	1,2x10 ¹⁵
Service temperature:	-3°C / +90°C. Up to +120°C for short cycles of 30 minutes max.

The values in this table must not be considered as specifications.



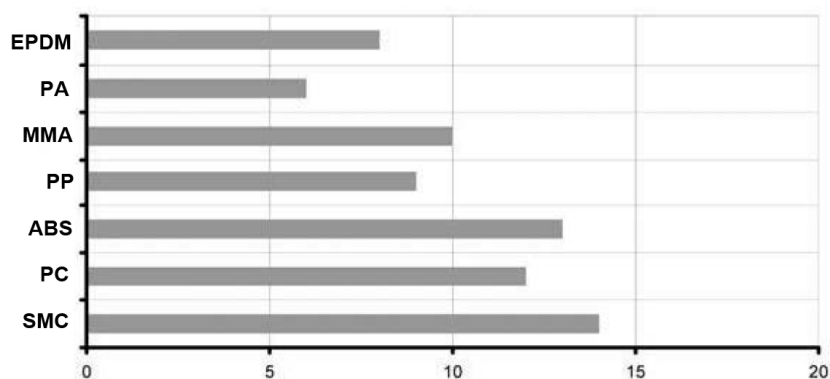
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CUT RESISTANCE OF DIFFERENT MATERIALS (N/mm²)



Tests conducted at a temperature of +20°C on metal-to-metal joints after 48 h curing at +20°C. Pretreatment carried out by sandblasting and degreasing with acetone.

MEDIUM CUT RESISTANCE OF PLASTIC MATERIALS (N/mm²)



Tests conducted at a temperature of +20°C on metal-to-metal joints after 48 h curing at +20°C. Pretreatment carried out by sandblasting and degreasing with isopropanol.

REACTION MECHANISM

The speed of the curing reaction is mainly influenced by the temperature and thickness of the application. As an exothermic reaction, the speed decreases with decreasing thickness and application temperature.

To a lesser extent, the substrate also affects the reaction rate.

Materials with a high coefficient of thermal conductivity will tend to slow it down.

The maximum reaction temperature is reached in applications of consistent thickness (5 mm) and is always below + 60°C.

METHOD OF USE

Surface preparation: surfaces must be clean, dry and free from dust and grease.

Application: to assure an on ratio dispense we recommend levelling the pistons by placing the opened cartridge in the dispenser and purge till material starts to flow from both cartridge chambers prior to attaching the static mixer.

After attaching the static mixer (we recommend to use only the static mixers included in the package; additional static mixers can be ordered from Fratelli Zucchini) and loading the cartridge into the dispense tool, pull the trigger at a constant and steady rate to force both prepolymer and curative through the static mixer.

It is recommended to discard the first 25 to 50 mm of dispensed material as it may be off-ratio. Sufficiently mixed on-ratio adhesive has a uniform black colour. It is creamy, smooth and glossy.

In case of short interruptions of work, it is possible to use the same static mixer.

The material in the mixer will become very difficult or impossible to dispense at about one-half of the open time

In case of longer interruptions, replace the static mixer.

After having finished dispensing, leave the mixer in place.

If stored properly, the remaining adhesive will have a shelf life of several weeks.

To start using **MINIPUR 15** again, remove the static mixer and dispose of properly.

Carefully clean the cartridge nozzle, the products in the two chambers must be cleanly separated.

If there is any black-tan mixing on either side dispense some product out of the openings with no mixer attached, until only single component product resides in each chamber.

Finally attach a new mixer and start dispensing.

Solvent wiping: traces of uncured product can be cleaned using solvente **ST 512**.

Cured product can be removed mechanically.



MINIPUR 15

Paintability: compatible with many painting systems.
Bonded parts can be painted only after the adhesive is completely cured.
A preliminary test is always recommended.

SAFETY AND HEALTH

See Safety Data Sheet.

STORAGE STABILITY

18 months from the date of manufacture if stored in the original unopened packaging, in a dry place at a temperature between +15°C and +25°C.
Shelf life is reduced in case of exposition to temperatures above +30°C and below +10°C.

PACKAGING

Article	Code	Colour	Packaging	pcs./box
MINIPUR 15	1004274	black	50 ml. cartridge	12
L/MINI GUN	1003950	-	-	-
MINIPUR MIXER	1004281	-	-	12



Fratelli Zucchini S.p.A.

Via C. Colombo, 6 Tel. +39 0532 782711 info@zucchini.it
44124 Ferrara - Italy Fax +39 0532 732121 www.zucchini.it

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