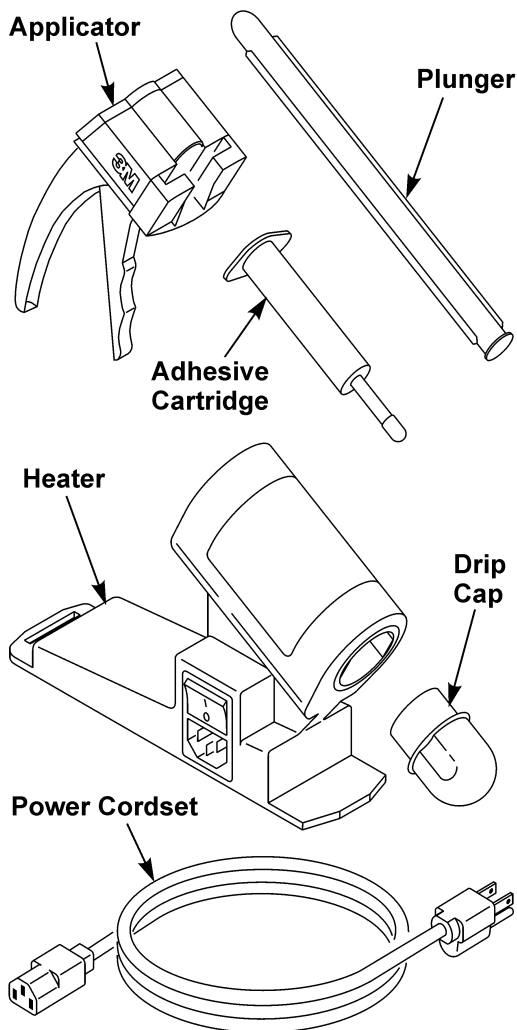


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Scotch® Mini-Weld Adhesive System User's Manual

The Scotch Mini-Weld Adhesive System Includes
The items shown below:



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Ordering Information

Should your Scotch Mini-Weld Adhesive System require replacement parts, they can be ordered from your local authorized distributor. Use the part numbers shown below:

Mini-Weld Replacement Parts List

<u>Part Number</u>	<u>Description</u>	<u>Contents</u>
62-9895-9939-4	Heater Power cordset	1 cord
62-9886-0003-7	Heater Drip Cap...	2 / bag
62-9886-9930-2	Applicator	1 applicator 1 plunger
62-9886-0002-9	Plungers	3 / bag
62-9886-0001-1	Heater	1 heater
	NOTE: Includes heater, drip cap, and power cordset	
62-9886-9935-1	Starter Kit	See NOTE
	NOTE: Includes heater, drip cap, applicator, power cordset, three adhesive cartridges, and one plunger	

Important Safety Information

Intended Use

The Scotch® Mini-Weld Adhesive Heater is specially designed to heat Scotch Mini-Weld Adhesive cartridges prior to bonding applications in an industrial environment. Using this heater for any other adhesive or any other purpose is not recommended and could cause hazardous conditions.

WARNING

To reduce the risk of electrical shock or injury while using the heater, exercise the following precautions:

- For indoor use only. Do not operate in wet locations or in the presence of liquids.
- Do not use a heater that has been left outdoors or has become wet.
- Use only the power cordset provided for this heater and connect to a properly grounded outlet.
- Do not modify the plug or connector and do not use an adaptor in an ungrounded outlet. If the plug does not fit your outlet, have a qualified electrician or service person install a proper outlet.
- If an extension power cord is needed, use only a three conductor, grounded cord that complies with NEC requirements and state and local electrical codes.
- When connecting and disconnecting the power cordset, grasp the molded plug or connector on the ends. Pulling on the cord portion could result in damage.

To Obtain More Information:

Read the safety information on the Scotch Mini-Weld Adhesive package and cartridge. The Material Safety Data Sheet (MSDS) for each adhesive contains safety, health, handling and disposal information. The MSDS can be obtained by calling 1-800-364-3577 or 651-737-6501.

WARNING

To reduce the risk of fire, lower the potential for hazardous exposure, and reduce the risk of other hazardous conditions, exercise the following precautions:

- Scotch Mini-Weld adhesives must only be heated in the Scotch Mini-Weld Adhesive Heater. Never use ovens or other heating devices.
- Do not heat or expose Scotch Mini-Weld adhesives to temperatures above 275° F (135° C). Vapors from heated material may be irritating to eyes and respiratory tract and may cause asthma-like symptoms in persons previously sensitized to isocyanates.
- Do not clean or remove Scotch Mini-Weld adhesives with heat, flame or solvent.

CAUTION

- To reduce risk of electrical shock, do not attempt to disassemble the heater. There are no user serviceable parts inside. If the heater is not operating properly, see the warranty section in this manual or contact your nearest 3M Sales Branch.
- To prevent injury, avoid contact with hot interior surfaces of the heater or melted adhesive. For maximum protection, wear heat resistant gloves when using.
- Use only with Scotch Mini-Weld Adhesive. Using any other materials MAY CAUSE HAZARDOUS CONDITIONS.
- FOR INDUSTRIAL USE ONLY.
- Keep out of reach of children.

Important Safety Information

(Continued)

Grounding Instructions:

The Scotch[®] Mini-Weld Adhesive Heater must be grounded. If the heater malfunctions or breaks down, grounding provides a path of least resistance for electric current to flow thus reducing the risk of electrical shock.

This heater is equipped with a power cord that contains an equipment-grounding conductor and a grounding plug. The plug must be used with an appropriate outlet that is properly installed and grounded in accordance with all state and local codes and requirements.

The Scotch Mini-Weld Adhesive Heater is intended for use on a nominal 120-Volt circuit with a grounding plug as shown in the figure to the left. Make sure the heater is connected to an outlet with the same configuration as the plug. **Do not use an adapter!**

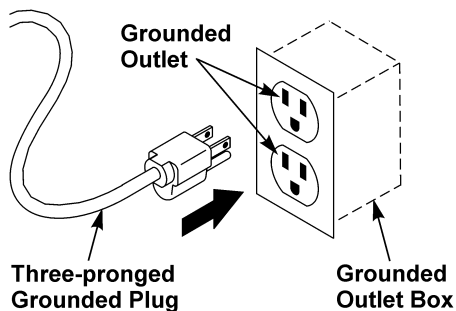
Scotch[®] Mini-Weld Adhesive Heater

120 VAC 50/60Hz .33 A 40 W



WARNING

Do not modify the plug or connector and do not use an adaptor in an ungrounded outlet. If the plug does not fit your outlet, have a qualified electrician or service person install a proper outlet.



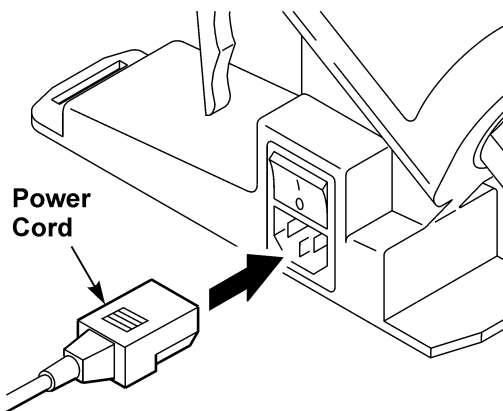
Setup and Installation

1. Remove the heater from its shipping container and inspect for any obvious damage. If damaged, do not use and immediately contact your local 3M Engineered Adhesives Division representative, or call 1-800-362-3550.

WARNING

Do not modify the plug or connector and do not use an adaptor in an ungrounded outlet. If the plug does not fit your outlet, have a qualified electrician or service person install a proper outlet.

2. Connect the power cord set to the Scotch® Mini-Weld Adhesive Heater as shown.



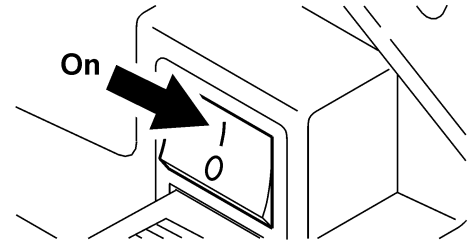
WARNING

Use only the power cordset provided for this heater and connect to a properly grounded outlet.

WARNING

If an extension power cord is needed, use only a three conductor, grounded cord that complies with NEC requirements and state and local electrical codes.

3. Plug the heater power cord into a grounded 120 VAC receptacle.
4. Push the **On/Off** switch to the **On** position as shown.



WARNING

To reduce the risk of electrical shock, or injury while using the heater, exercise the following precautions:

- For indoor use only. Do not operate in wet locations or in the presence of liquids.
- Do not use a heater that has been left outdoors or has become wet.
- When connecting and disconnecting the power cordset, grasp the molded plug or connector on the ends. Pulling on the cord portion could result in damage.

CAUTION

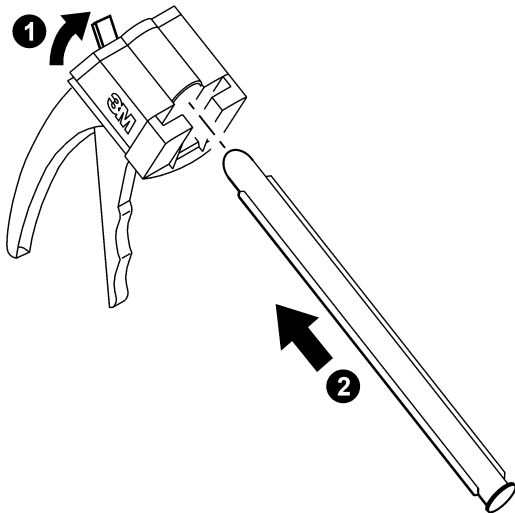
To reduce risk of electrical shock, do not attempt to disassemble the heater. There are no user serviceable parts inside. If the heater is not operating properly, see the warranty section in this manual or contact your nearest 3M Sales Branch.

Loading Applicator

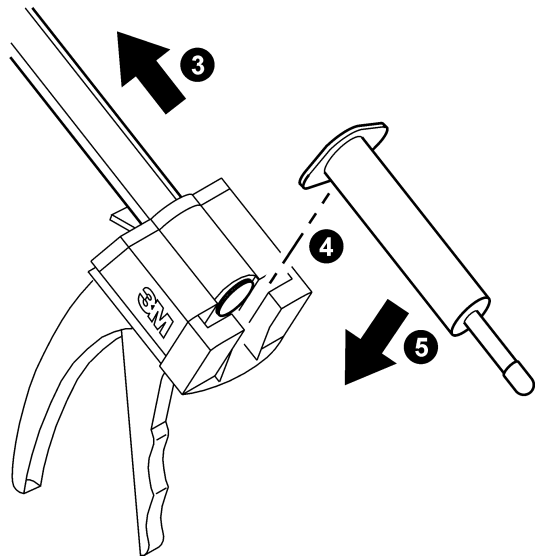
 **CAUTION**

Use only with Scotch® Mini-Weld Adhesive.
Using any other materials MAY CAUSE
HAZARDOUS CONDITIONS.

5. Select Scotch Mini-Weld Adhesive cartridge and insert it into the Scotch Mini-Weld Applicator as follows:
- Assemble applicator by pushing up and holding the release lever at the rear of the applicator body (see ❶) and sliding the flat end of the plunger into the applicator (see ❷), making sure that the side with ratchet teeth face down toward the applicator handle.

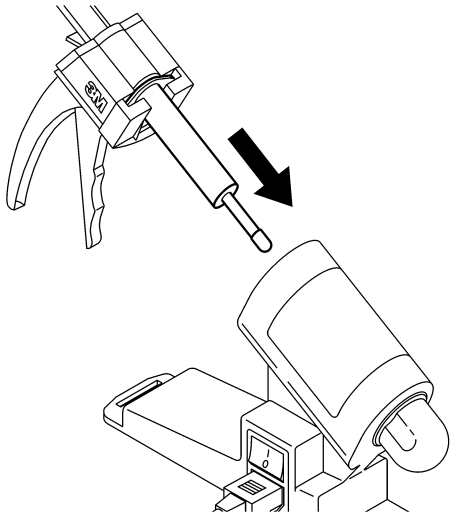


- Slide the plunger all the way back until it is flush with the cartridge entry slot on the Scotch Mini-Weld Applicator (see ❸).
- Load the selected Scotch Mini-Weld cartridge into the applicator by aligning the two rear tabs of the cartridge with the entry slots at the top of the applicator (see ❹).
- Push the cartridge down into the entry slots until it rests on the bottom of the slot (see ❺).



Heating and Dispensing

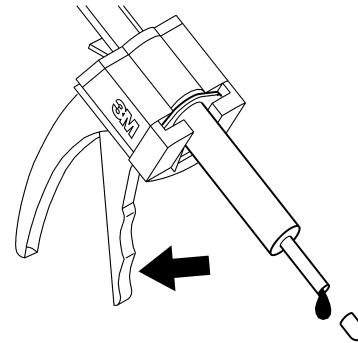
1. If heater is not already **On**, push the **On/Off** switch to the **On** position.
2. Place the Scotch® Mini-Weld Cartridge, into the heater and allow the adhesive to heat for a minimum of 20 minutes before attempting to use it.



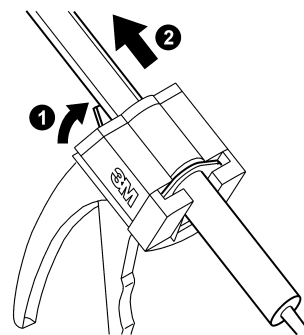
WARNING

Scotch Mini-Weld adhesives must only be heated in the Scotch Mini-Weld Adhesive Heater. Never use ovens or other heating devices.

3. When the cartridge has been sufficiently heated, and before attempting to extrude adhesive, remove the cap on the tip of the cartridge and set it aside for reuse later.
4. Advance the plunger of the applicator by actuating the trigger until adhesive begins to flow from the tip of the cartridge.



5. Apply the desired amount of adhesive to the area to be bonded.
6. After adhesive has been applied, lift and hold the release lever at the rear of the applicator (see ①).
7. Pull the plunger back slightly (see ②) to relieve pressure on the cartridge plunger.



8. Wipe away any remaining adhesive from the cartridge tip. Use a paper or cloth towel to wipe away any remaining adhesive.

Note

Do not allow the Scotch Mini-Weld Cartridge to remain outside the heater more than three minutes. Doing so will cause the adhesive to cool and solidify in the tip preventing the extrusion of adhesive. If the applicator is being used periodically, the "out" time may be longer but it should never exceed five minutes.

9. Replace the cap onto the cartridge nozzle and place the applicator back into the heater, until used again, to maintain heat.

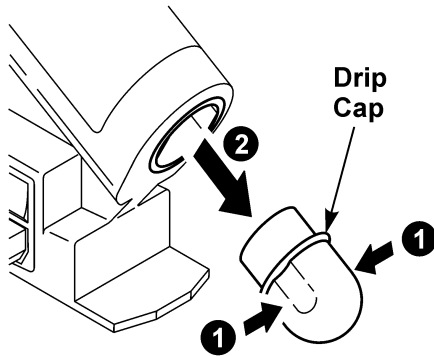
Drip Cap Cleaning and Replacement

The Scotch® Mini-Weld Adhesive Heater is equipped with a drip cap that collects any adhesive that may drip from the tip of the cartridge while inside the heater. If the cap becomes filled with adhesive, follow these simple steps to clean or replace the drip cap.

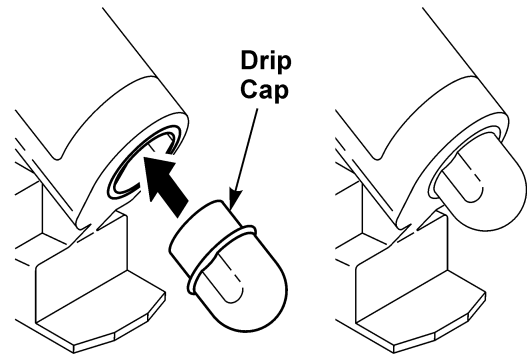
 **CAUTION**

To prevent injury, avoid contact with hot interior surfaces of the heater or melted adhesive. For maximum protection, wear heat resistant gloves when using.

1. While holding the heater firmly with one hand, squeeze the drip cap slightly at the finger depressions (see ❶), and then pull the cap off the heater (see ❷).



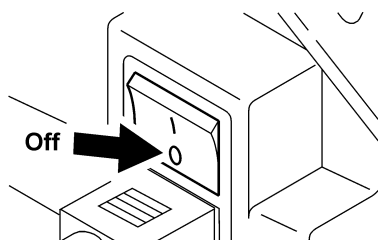
2. Once the drip cap has been removed from the heater, allow sufficient time for any adhesive to cool and solidify.
3. Remove all solid adhesive by gently squeezing the drip cap. This will release the adhesive from the non-stick surface within the drip cap allowing it to be removed.
4. To replace the heater drip cap, hold the heater firmly and push the drip cap into the front opening of the heater. Push the cap until it is seated (as indicated when it snaps in place).
5. Align the finger depressions as shown in the illustration.



6. Continue using the Scotch Mini-Weld Adhesive System as described in the preceding sections of this manual.

Shutdown

1. Push the **On/Off** switch on the heater to the **Off** position.
3. Adhesive is sufficiently heated when it appears molten or clear.



2. The unused adhesive may be left in the heater for up to three days without curing significantly to prevent re-use. Partial cartridges that require storage for longer periods of time must be sealed tightly (with a heat seal or rolled over and clipped) in its original metalized envelope. A Scotch® Mini-Weld Adhesive Cartridge may be stored for up to three weeks in this envelope.

If a partially used adhesive cartridge has not been used for longer than three days or stored in the original metalized envelope for longer than three weeks, exposure to moisture may have cured the adhesive. Replace a partially used adhesive cartridge that has cured with a new cartridge. If the Mini-Weld cartridge has been heated for a minimum of 20 minutes and the adhesive cannot easily be extruded by applying moderate pressure to the applicator trigger, the adhesive is partially cured and should be discarded.

Warranty

Contact your nearest 3M sales branch or authorized Scotch® Mini-Weld Adhesive System distributor.

Important Notice: User is responsible for determining whether the Scotch® Mini-Weld Adhesive System is fit for a particular purpose and suitable for user's method of application.

Warranty: 3M warrants for 6 months from the date of purchase or use, whichever occurs first, that the Scotch Mini-Weld Adhesive Heater will be free of defects in material and manufacture. 3M MAKES NO OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY IMPLIED WARRANTY ARISING OUT OF A COURSE OF DEALING, CUSTOM, OR USAGE OF TRADE. This warranty does not cover routine maintenance, normal wear and tear, or damage resulting from accident, misuse, alteration, corrosion, lack of reasonable care, service performed by an unauthorized repair service, use of unauthorized replacement parts or accessories, or installation, use, operation, or maintenance not in accordance with 3M recommended procedures, or use of adhesive cartridges not manufactured by 3M or not subject to 3M quality standards.

Limitation of Remedies: If the Scotch Mini-Weld Adhesive Heater is proven to be defective within the warranty period stated above, THE EXCLUSIVE REMEDY, AT 3M'S OPTION, SHALL BE TO REFUND THE PURCHASE PRICE OF OR TO REPAIR OR REPLACE THE DEFECTIVE 3M HEATER, provided that the defective heater is, at 3M's choice, returned immediately to 3M or an authorized service representative designated by 3M, or made available at user's premises in a location suitable for servicing.

Limitation of Liability: 3M shall not otherwise be liable for any losses or damages, whether direct, indirect, special, incidental, or consequential, regardless of the legal or equitable theory asserted, including, but not limited to, contract, negligence, warranty, or strict liability.

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