

**HiPUR** *Polyurethane* **FORMER**™  
**ADVANCED BONDING SYSTEM**



**UL** US LISTED

**ADHESIVE APPLICATOR TOOL**

Patent Pending

## TECHNICAL SPECIFICATIONS

**Voltage:** 120v AC

**Output:** 12 watts in standby phase, 200 watts while heating

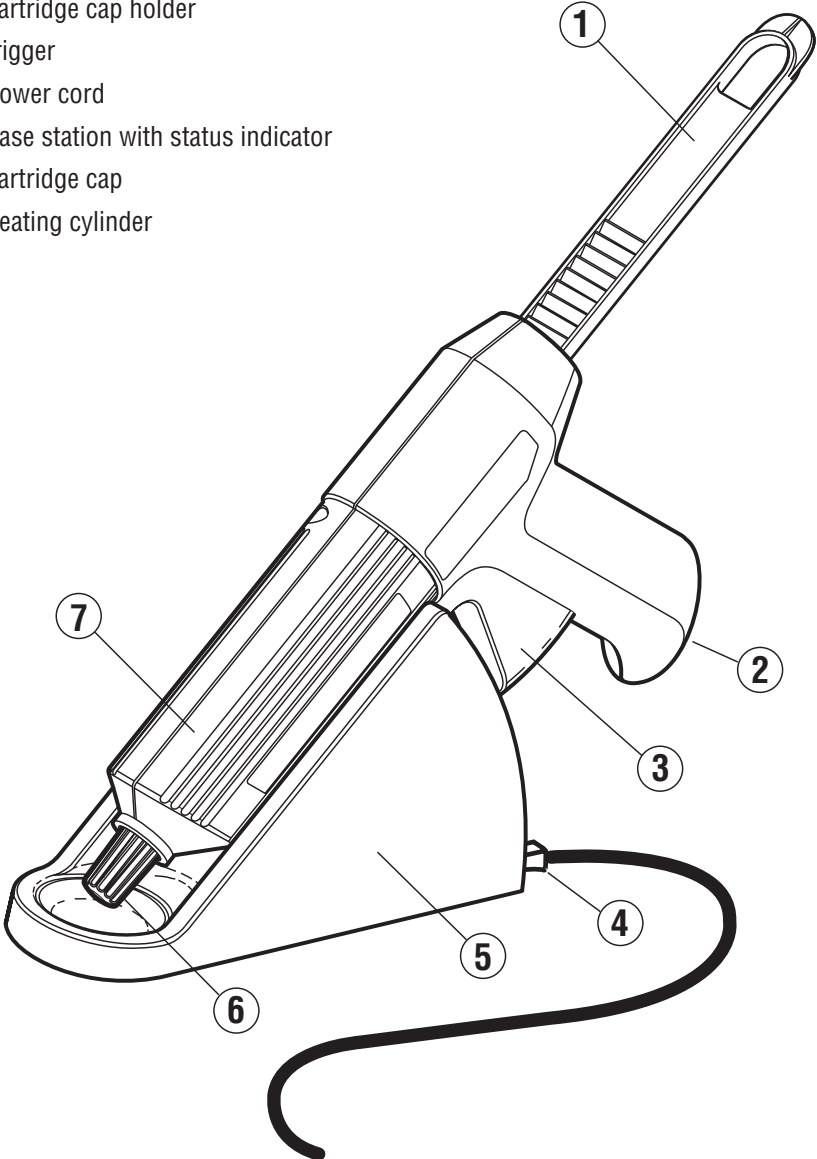
**Heat-up Time:** 10-13 minutes

**Working Temperature:** 212-284°F

**Maximum Working Time:** Approximately 20 minutes away from base unit

**Cartridge:** Works with all HiPURformer™ 50 gram cartridges

- 1 feed rod
- 2 cartridge cap holder
- 3 trigger
- 4 power cord
- 5 base station with status indicator
- 6 cartridge cap
- 7 heating cylinder



## OPERATING INSTRUCTIONS

Congratulations on your purchase of a **HiPURformer™** polyurethane reactive hot melt adhesive applicator. You have chosen a high quality product that has been manufactured, tested and packed with the greatest care.

Please read these operating instructions carefully before using your adhesive applicator and retain them for future reference. With proper care and use, the **HiPURformer™** adhesive applicator will provide you with years of satisfaction.

**UL WARNING.** Read this instruction booklet before using. To reduce risk of fire or shock, do not expose to rain or moisture. Store indoors. When servicing, use only identical replacement parts. When using electric tools, basic safety precautions should always be followed to reduce the risk of fire, electric shock and personal injury.



**DOUBLE INSULATED TOOLS**, such as the **HiPURformer™** adhesive applicator, are equipped with a two-prong plug. These tools have a special insulation system that complies with both UL and CSA requirements. They do not require grounding.

## IMPORTANT SAFETY INSTRUCTIONS

**Read operating instructions thoroughly before using adhesive applicator.**

**⚠️ WARNING: Eye and Skin Irritant. Potential Skin and Respiratory Sensitizer. Caution: Contact with heated product may cause thermal burns. Always wear gloves.** Contains isocyanates. Avoid contact with skin and eyes. Avoid prolonged or repeated contact with vapors. Do not swallow. May be harmful if swallowed. **First Aid:** If swallowed, do not induce vomiting. Call physician immediately. If eye contact occurs, flush eyes with water for 15 minutes and call physician. In case of skin contact, wash skin with soap and water. Seek medical attention if sensitization or rash occurs. If inhaled, move to fresh air and contact physician. For additional safety information, refer to Material Safety Data Sheet or call 1-800-347-4583. **KEEP OUT OF THE REACH OF CHILDREN.**

When using a hot air gun to remove adhesive, remain in a well-ventilated area. Do not over-heat flammable materials or substrates susceptible to thermal damage.

The **HiPURformer™** adhesive applicator is designed for use with **HiPURformer™** polyurethane reactive hot melt adhesives only. Operation and performance are NOT guaranteed with any other hot melt products.

## ABOUT HiPURformer™ POLYURETHANE REACTIVE HOT MELT ADHESIVES

The **HiPURformer™** Adhesive Applicator has been specially designed for use with **HiPURformer™** polyurethane reactive hot melt adhesive cartridges. **HiPURformer™** adhesives are extremely versatile and offer many advantages over traditional hot melts.

- High-strength, permanent bonds
- Fast set times: range from 30 seconds–5 minutes\*
- Bonds a wide variety of materials: wood, ceramic, metal, leather, textiles, marble, PVC, plastic and many other substrates
- Interior/Exterior use: resists temperatures from -20°F to +275°F
- Waterproof and weatherproof
- UV indicator for easy clean-up
- Solvent free and nonflammable
- Greatly reduces the need for mechanical fasteners
- Adhesive is removable by heating to 280°F. with a hot air gun. Bond will soften at approximately 280°F., but adhesive will not flow or become liquid. **DO NOT USE HEAT GUNS WITH FLAMMABLE OBJECTS OR SUBSTRATES.**
- Features and performance vary depending on the **HiPURformer™** adhesive formula selected. Please refer to the instructions accompanying the specific adhesive cartridge purchased.

\*Set times may vary with application temperature, ambient temperature, thermal conductivity and temperature of the substrates.

### LIMITATIONS:

- Not for continuous submersion or use below the waterline.
- Not for use on copper or metal alloys containing a high percentage of copper.



Wood to Wood  
30-Second Set Time



Wood to Wood  
60-Second Set Time

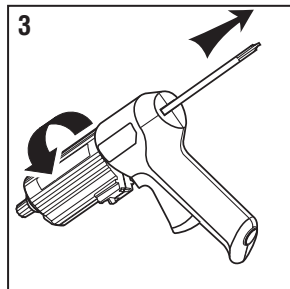
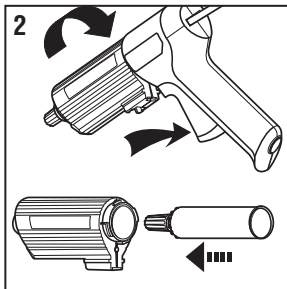
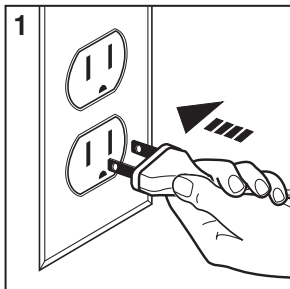


Multi-Purpose  
75-Second Set Time

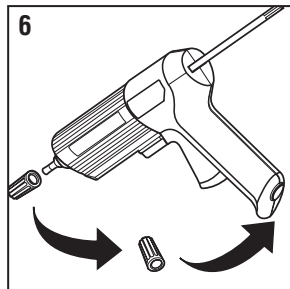
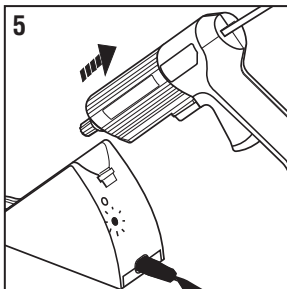
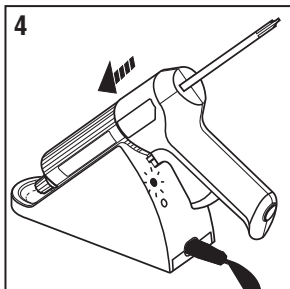


Multi-Purpose  
5-Minute Set Time

## GETTING STARTED



1. Plug base station into power source. Green diode will light up.
2. Depress trigger and turn heating cylinder counterclockwise to separate the two applicator components. Remove adhesive cartridge from foil pouch and insert into heating cylinder.
3. Reassemble the applicator by retracting the feed rod and twisting the cylinder until it locks into place.

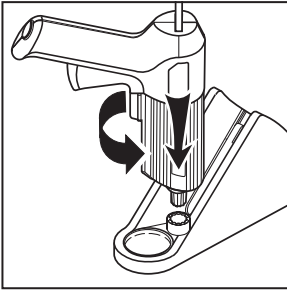


4. Insert tool into contact slots on base station to heat adhesive. Status indicator remains RED during heat-up (approx. 10-13 minutes). When the status indicator turns GREEN, the adhesive has reached bonding temperature and is ready to use.
5. Always wear gloves. Remove tool from base station.
6. Unscrew cap (store in handle). Depress trigger to extrude adhesive. Feed rod will advance and press against cartridge plunger.
7. Apply the adhesive sparingly in either a spot or continuous bead. Do not spread.
8. Join the surfaces to be bonded together, ensure proper alignment of pieces and hold firmly in place until the adhesive sets (working times vary).
9. Substrates may be machined or planed after 1 hour, however, do not subject the bond to stress for 24-48 hours.

## MOUNTING BASE STATION

If desired, the base station may be mounted on a firm surface. Use 2.9mm (1/9") diameter screws to secure, using the holes provided on the bottom of the unit.

## IMPORTANT INFORMATION ABOUT ADHESIVE CARTRIDGES



- Always seal cartridge tightly during heating and after use.
  - Removing Cartridge Cap: Always wear gloves. Make sure the cartridge is hot before attempting to remove the cap. If the cap becomes stuck, it may be loosened by using the similarly shaped receptacle in the base station (see diagram).
  - Allow heating cylinder to cool for approximately five minutes down before inserting a new cartridge.
- If cartridge and heating cylinder accidentally become stuck together, simply heat-up unit to release. Once separated, wipe adhesive residue off unit to prevent future problems.

## FOR BEST RESULTS

- Use only **HiPURformer™** polyurethane reactive hot melt adhesives and **Steinel** replacement parts.
- Make sure the surfaces to be bonded are perfectly clean. Prefinished surfaces should be sanded or "roughed up" before applying adhesive.
- Make sure the adhesive is fresh. Shelf life is one year from the date of manufacture.
- The objects to be adhered should be at room temperature. If necessary, warm them (with a hot air gun, for instance). Cold surfaces will cause the adhesive to set more quickly and will shorten the working time.
- Heavy objects should be fixed in position (using tape, a vise etc.) until fully cured.
- Optimum bond strength is achieved by joining the two contact surfaces immediately after applying adhesive.
- Hardened, excess adhesive can easily be removed with a scraper or putty knife soon after it sets (the adhesive will change from clear to opaque).
- The adhesive bond may be softened and the glued surfaces separated by heating them to 280°F with a hot air gun. **DO NOT USE HEAT GUNS WITH FLAMMABLE OBJECTS OR SUBSTRATES.**
- During prolonged work breaks (over 60 minutes), replace the cartridge cap securely while the adhesive is hot and unplug the unit.
- When finished using the **HiPURformer™ Advanced Bonding System**, extrude about one inch of adhesive from the cartridge nozzle, then immediately replace the cartridge cap tightly while the adhesive is hot.
- Tightly sealing the cartridge after use will prolong the life of the adhesive. For best results, use product within four weeks after opening.
- The load-bearing capacity of the bond depends largely on the strength of the substrate (e.g. do not glue heavy objects onto weak materials such as paint, wallpaper or drywall).

## LIMITED WARRANTY

This quality **STEINEL** product has been manufactured, tested and packed with the greatest care. It complies with all applicable North American safety standards and regulations.

**STEINEL** warrants this product against defects in material and workmanship as follows:

- Normal household environment – 36 months from date of original purchase.
- Commercial or industrial use – 12 months from date of original purchase.

During this warranty period, **STEINEL** agrees to repair or replace, at **STEINEL's** discretion, any defective product without charge.

This warranty does not cover parts subject to wear or damage caused by accident, misuse, abuse, alteration or lack of reasonable care. Consequential damage to external items is also excluded from this warranty.

Use only **HiPURformer™** polyurethane reactive hot melt adhesives and **STEINEL** replacement parts. Use of other adhesives or parts will unconditionally and permanently void this warranty.

To obtain warranty service, call **STEINEL's** Customer Service Department in the USA at 1-800-852-4343 or in Canada at 1-604-299-3506. A Customer Service Representative will attempt to diagnose the problem and correct it over the telephone. If the problem cannot be solved over the telephone, you will be given a Returned Goods Authorization Number and will be instructed to return the defective product to the appropriate service center, freight prepaid. All returned products must be fully assembled, well packed, and accompanied by the original invoice showing date of purchase.

**Repair Service:** Units returned for repair outside the terms of the Limited Warranty Statement are subject to standard repair charges.

## SPARE PARTS (refer to diagram on page 2)

Spare parts may be ordered by calling **STEINEL** at **1-800-852-4343** or visit our website at **www.steinell.net**. Please have your Visa or Mastercard ready.

Part #	Description
05011	Feed Rod
05012	Trigger Handle
05013	Heating Cylinder
05014	Base Station (does not include cord)
05015	Power Cord

## BOND STRENGTH OF HiPURformer™ ADHESIVES

Strength Development				
Maple to Maple	WW30	WW60	MP75	MP300
10 minutes	650 psi	600 psi	270 psi	118 psi
1 hour	1090 psi	1130 psi	600 psi	478 psi
24 hours	1360 psi	1480 psi	900 psi	1016 psi

Recommended Applications				
SUBSTRATE	WW30	WW60	MP75	MP300
Wood	E	E	G	G
Steel	NR	NR	E	E
Ceramics	NR	NR	E	E
Aluminum	NR	NR	E	E
ABS	NR	NR	E	E
Concrete/Brick	NR	NR	E	E
Vinyl	NR	NR	E	E
Glass/Marble	NR	NR	E	E
Melamine	NR	NR	E	E
PVC	NR	NR	E	E
Lexan	NR	NR	E	E
FRP	NR	NR	E	E

**E** = Excellent adhesion **G** = Good adhesion **NR** = Not recommended

## TROUBLESHOOTING

Problem	Cause	Solution
Unit not warming up	<ul style="list-style-type: none"> <li>• Not plugged in</li> <li>• No electrical contact between heating cylinder and base station</li> <li>• Electrical contacts on heating cylinder dirty or soiled with adhesive</li> </ul>	<ul style="list-style-type: none"> <li>• Check power cord</li> <li>• Insert heating cylinder into contact slot on base</li> <li>• Clean electrical contacts on heating cylinder</li> </ul>
Adhesive has stopped extruding	<ul style="list-style-type: none"> <li>• Adhesive temperature too low</li> <li>• Adhesive past shelf life</li> <li>• Cured adhesive in cartridge tip</li> </ul>	<ul style="list-style-type: none"> <li>• Tightly seal cartridge and re-heat in base unit</li> <li>• Allow gun to cool, then install a new cartridge</li> <li>• Attempt to clear cartridge tip</li> </ul>
Green indicator light appears immediately after changing cartridge	<ul style="list-style-type: none"> <li>• Heating cylinder still hot from previous use</li> </ul>	<ul style="list-style-type: none"> <li>• Ensure that “cold” cartridge is heated for at least 12 minutes</li> </ul>





**STEINEL®**

[www.steinell.net](http://www.steinell.net)

**STEINEL America, Inc.**

9051 Lyndale Avenue South, Bloomington, MN 55420

800-852-4343 • 952-888-5950

[email-sales@steinell.net](mailto:email-sales@steinell.net) [www.steinell.net](http://www.steinell.net)