

3M™ Adhesion Promoter K520UV

Technical Data Sheet



Description

3M™ Adhesion Promoter K520UV is a liquid adhesion promoter used to improve the adhesion of 3M™ Acrylic Foam and Acrylic *Plus* Tapes to Polyolefin-based substrates such as thermoplastic olefins (TPO), Polypropylene (PP), and EPDM rubber used in automotive applications. A fluorescent dye has been added so that the primer coverage can be verified. Because substrate formulations and surface energies may vary for these materials, each application should be tested for compatibility.

Physical Properties

Components	Toluene, Isopropyl Alcohol, Chlorinated Polyolefin, Polyamidoamine
Color	Straw
Viscosity	3.3 mPa·s
Flashpoint	5°C (41°F)
Drying Time	30-90 seconds
Coverage	62 m ² (800 ft ²) per Liter
Net Weight	860 g/l (7.2 lb/gal)

Equipment

3M adhesion promoter K520UV can be applied by a gravity feed wipe, knurled roller, and felt-tipped applicator or other similar type applicator. Applicator heads should be cleaned or replaced regularly.

Surface Preparation

The bonding surface should be clean and dry. Contaminated surfaces should be cleaned with an appropriate solvent* such as isopropyl alcohol. Observe precautions for solvent handling.

Application

Shake well before using. Apply a thin, uniform coating of the 3M™ Adhesion Promoter K520UV to the bonding surface, using the minimum amount that will fully coat the surface. A wet coating thickness of approximately 0.002 inch (0.05 mm) or less is recommended. Although drying times may vary due to temperature and/or humidity, a drying time of 30-90 seconds is typical of this thickness. The adhesion promoter should be dry before applying the tape. For best results, apply tape within one hour after applying adhesion promoter. Be sure the primer surface remains free from contaminants prior to laminating the tape.

Clean-Up

3M Adhesion Promoter K520UV can be cleaned up with acetone solvents*. Vigorous scrubbing may be required.

***Note:** When using solvents for cleanup, use the precautionary measures recommended in the SDS and/or label for the solvent.

Shelf Life

Shelf life is 2 years from date of manufacturing when stored in the original container at 4°C – 38°C (40°F – 100°F) and 0 – 95% relative humidity. Storage at lower temperatures for short periods will not affect product performance if the promoter is applied at recommended temperatures.

Regulatory Information

Observe proper handling precautions as outlined in the Safety Data Sheet (SDS), which is available on request. The website address for 3M SDSs is http://www.3m.com/3M/en_US/company-us/SDS-search/.

Contact Information

The information provided in this technical document is intended as a guide for this product.

For more information or help in selecting a 3M product for an application, please contact your 3M technical service representative or call 1-800-328-1684.

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