



Adhesion Promoter K520UV

Technical Data Sheet

October 2006

General Description 3M™ Adhesion Promoter K520UV is a liquid primer 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. A fluorescent dye has been added so that the primer coverage can be verified. Since formulations and surface energies vary for these materials, each application should be verified through testing. 3M adhesion promoter K520UV is specifically formulated to be used with 3M Acrylic Foam and Acrylic *Plus* Tapes for automotive applications.

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)

Safety Procedures Observe proper handling precautions as outlined in the Material Safety Data Sheet (MSDS), which is available on request. The website address for the 3M MSDSs is www.3M.com/msds. If necessary, the 3M 24-hour emergency response telephone number is 1-800-364-3577 or 651-737-6501.

Equipment 3M adhesion promoter K520UV can be applied by a gravity feed wipe, knurled roller, sprayer and felt-tipped applicator or other similar applicator types. Applicator heads should be cleaned or replaced regularly. A convenient application system is available through your 3M Automotive Division representative.

Shelf Life Shelf life is one year from the date of shipment when stored in the original container at 4°C – 38°C (40°F – 100°F), 0-95% relative humidity, and away from light sources. Storage at lower temperatures for short periods will not affect product performance if the primer is warmed to recommended temperatures before application.

Surface Preparation The bonding surface should be clean and dry. Contaminated surfaces should be cleaned with an untreated, lint-free cloth and an appropriate solvent (typically isopropyl alcohol).*

Application Shake well before using. Apply a thin, uniform coating to the bonding surface, using the minimum amount that will fully coat the surface. A wet coating thickness of 0.002 inch or less ensures a good application. Although drying times may vary due to temperature and/or humidity, a drying time of 30-90 seconds is indicative of this thickness. The primer should be dry before applying the tape. For best results, apply tape within one hour after primer application. Be sure the primer surface remains free from contaminants prior to laminating the tape.

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Clean-Up

3M™ Adhesion Promoter K520UV can be removed with acetone solvent.* Vigorous scrubbing may be required.

***Note:** When using solvents, extinguish all ignition sources and follow the manufacturer's precautions and directions for use.

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