



# Adhesion Promoter 86A

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## Product Data Sheet

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Updated : October 2001  
Supersedes : March 1998

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### Product Description

Adhesion Promoter 86A is a liquid "primer" designed to be used with 3M Polyurethane Protective Tape to enhance initial adhesion in demanding situations.

Adhesion Promoter 86A is designed to promote faster adhesion of Polyurethane Protective Tapes with acrylic adhesives to certain types of surfaces, such as polyurethane paint, epoxy

primers, or epoxy composites. It is not intended for use where the acrylic adhesive would be in direct contact with aluminium, stainless steel, carbon steel, or glass.

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### Physical Properties & Performance

#### Characteristics

Not for specification purposes

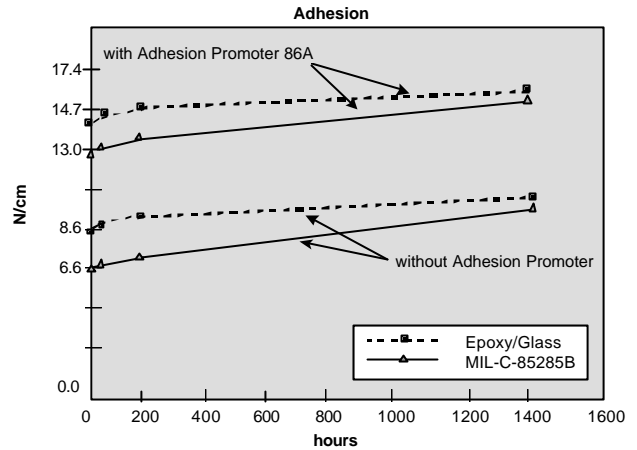
<b>Active Ingredient</b>	Polyamide Resin	
<b>Solvent</b>	Isopropyl Alcohol, N-Propyl Alcohol	
<b>Solids</b>	6.5%	
<b>Colour</b>	Transparent, Colourless	
<b>Viscosity</b>	Approximately 100 cps	
<b>Flashpoint</b>	53°F (12°C) Flammable Liquid	
<b>Package Size</b>	0.47 Litre / 1 (US) Pint	
<b>Net Weight</b>	0.75 kg/litre 0.95 lbs./pint	
<b>Storage</b>	Store at 16-27°C (60-80°F). Lower temperature storage will not affect product performance if the promoter is warmed up to 16-27°C (60-80°F) before application.	
<b>Shelf Life</b>	12 months from date of manufacture.	
<b>Initial Peel Adhesion</b> (8681HS w/86A) ASTM D-1000 (1 hr dwell, 180° Peel)	Epoxy / Glass    14.5 N/10mm Mil-C-85285B    12.8 N/10mm	132.4 oz./in. 117.0 oz./in.

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**Typical Performance Characteristics**

Adhesion Promoter 86A promotes faster initial adhesion build rate of 3M Polyurethane Protective Tapes with acrylic adhesives to certain surfaces.

**Note:** Adhesion Promoter 86A is a toluene-free replacement for Adhesion Promoter 86. For most substrates, Adhesion promoters 86A and 86 adhesion performance will be similar.



**Bonding Information**

**Surface Preparation:**

The bonding surface must be smooth, clean, dry and free of foreign matter. If necessary, the surface should be sanded to the smoothness attainable with 320 grit sandpaper. Clean the surface with isopropyl alcohol and allow the surface to dry prior to the application of Adhesion Promoter 86A.

**Note:** Towels or cloths used in the cleaning process should be untreated and lint free.

**Apply Adhesion Promoter**

Wipe surface with lint free cloth wetted with Adhesion Promoter 86A, using the minimum amount that will coat desired surface. Allow to dry for 10 minutes or until the coated surface is not glossy. For best results, apply Polyurethane Protective Tape with acrylic adhesive within 2 hours to the promoted surface.

**Note:** In many applications only the outer most edges of the application may require use of Adhesion promoter.

**Note:** Tape applications over Adhesion Promoter 86A will be more difficult to remove.

**Note:** If desired, Adhesion Promoter 86A may be sprayed on the surface, using most conventional spray equipment. If dilution is required, it may be done with isopropyl alcohol.\*

**\*Note : When using solvents, be sure to follow the manufacturer's precautions and directions for use.**

**Health & Safety Information**

**Warning:**

Vapour harmful.  
May cause skin and eye irritation.  
Harmful if swallowed.  
Contains isopropanol.

**Precautions:**

Avoid breathing vapours.  
Avoid contact with eyes and prolonged skin contact.

**First Aid:**

**If inhaled:**  
Remove person to fresh air.

**In case of eye contact:**

Flush eyes with large amounts of water for at least 15 minutes and call a physician.

**In case of Skin Contact:**

Wash affected areas with soap and water.

**If Swallowed:**

Do not induce vomiting. Call a physician.

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Values presented have been determined by standard test methods and are average values not to be used for specification purposes. Our recommendations on the use of our products are based on tests believed to be reliable but we would ask that you conduct your own tests to determine their suitability for your applications. This is because 3M cannot accept any responsibility or liability direct or consequential for loss or damage caused as a result of our recommendations.



**Tapes & Adhesives**

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