



3M™ Stamark™ Surface Preparation Adhesive P-50

Instructions for use with 3M™ Stamark™ Pavement Marking Tapes

Information Folder 5.17

May 2014

Replaces IF 5.17 dated March 2010

Directions for Use 3M™ Stamark™ Surface Preparation Adhesive P-50 is extremely flammable; handling and storage precautions on the container must be observed. Containers must be opened away from the face slowly and carefully to vent any internal vapor pressure. Stamark surface preparation adhesive P-50 is applied by using the Adhesive Spray Applicator PS-14. Use P-50 within two years of receipt. See Storage Recommendations for proper methods of storage.

Coverage P-50 sprayable adhesive coverage is about 450 lineal ft/gal. (35 m/l) spraying a 6-inch (15 cm) wide pattern. The resulting wet thickness is approximately 6.0–7.0 mil. If tape wider than six inches (15 cm) is to be applied, make multiple passes with the adhesive spray applicator.

- Application Conditions — Stamark™ Durable Tapes**
1. Air temperature — Minimum 40°F (4°C) and rising in a season when nighttime lows are above 40°F (4°C). To determine if P-50 is required, refer to the 3M Climate Guide or product bulletin for tape to be applied.
 2. No rainfall for previous 24 hours. Other visible signs of moisture (dew or frost) should not be present.
 3. Asphalt surfaces must be at least three days old before applying the P-50 adhesive.
 4. Concrete surfaces open to traffic less than 90 days must have the curing compound removed before applying P-50. Curing compound can be removed by sandblasting or other methods such as shotblasting or hydroblasting. If hydroblasting is used the road must be allowed to dry completely before application of P-50 and Stamark tapes.
 5. The pavement surface must be clean, dry, and in good condition.
 6. Do not apply P-50 over old pavement markings such as paint, epoxy, thermoplastic, and preformed tapes including Stamark tapes. Old pavement markings must be removed using methods such as sandblasting, shotblasting, or grinding. Hydroblasting may also be used, but the road must be allowed to dry for a minimum of 24 hours before application of P-50 and Stamark tapes. At least 90 percent of the old pavement marking material must be completely removed down to the road surface prior to application of P-50.
 7. Traffic must be kept off of pavement surfaces coated with a surface preparation adhesive prior to tape application.

Application Conditions — Stamark™ Temporary Removable Tapes	For application of P-50 with Stamark Temporary Removable Tapes, refer to Information Folder 3.2. For additional information on the application of P-50 for Series 710 under marginal weather conditions or on a poor surface, contact 3M Pavement Markings Technical Service at 1-800-553-1380.
Application Procedures	<ol style="list-style-type: none"> 1. Completely clean and flush the spray equipment with Acetone or Methyl Ethyl Ketone before spraying P-50. 2. Clean the pavement surface thoroughly and mark the position where the pavement marking will be applied. 3. Apply one coat of P-50 sprayable adhesive. Spray the adhesive a minimum of one (1) inch (2.5cm) beyond where the edges of the tape will be applied. 4. Allow the P-50 to set. P-50 is set when it feels tacky but is no longer in liquid form and has a matte finish rather than a glossy wet appearance. P-50 dries quickly under most circumstances. Typical time for P-50 to set is two to three (2 – 3) minutes under optimal conditions of 70°F (21°C) and medium to low humidity levels. Use methods described Information Folder 5.7 to verify that P-50 is set. 5. After P-50 is set, apply the tape by using methods described in Information Folder 5.7. Do not allow P-50 to remain on the road without tape application for an extended time. A delay will result in dirt and dust forming a film on the P-50 surface reducing adhesion performance. 6. Tamp the tape thoroughly with the 3M™ Roller Tamper Cart (RTC-2) with a minimum 200 lb (90 kg) load or slowly drive over the tape making six passes over each part of the tape. The vehicle should be equipped with a pointing device to aid in keeping the vehicle on the tape. Tamping is very important! <p>RTC-2 Operating Instructions</p> <ul style="list-style-type: none"> • Do not twist or turn the tamping device on tape. • Make six passes over each part of the tape. • Make sure all edges are firmly adhered. • Open to traffic as soon as tamping is complete.
Clean-Up	<ol style="list-style-type: none"> 1. When finished applying surface preparation adhesive, pull the PS-14 applicator backwards eight to ten (8-10) feet to draw the adhesive back into the can, and remove the siphon tube from the adhesive. 2. Insert the siphon tube into a can of Acetone or Methyl Ethyl Ketone. Place a catch pan under the spray nozzle and rotate the front wheel until the solvent from the spray nozzle appears clear. 3. Rotate the pump backwards to draw the solvent back into the can. 4. Dispose of the cleaning solvent according to local regulations and guidelines.
Recommended Storage	Store away from heat in a cool, dry place and protect from freezing. Store out of direct sunlight. Keep container closed when not in use. Keep container in well ventilated area. Contents may be under pressure; open carefully.
Health and Safety Information	Read all health hazard, precautionary, and first aid statements found in the Material Safety Data Sheet (MSDS), and/or product label of chemicals prior to handling or use. Also refer to the MSDS for information about the volatile organic compound (VOC) content of chemical products. Consult local regulations and authorities for possible restrictions on product VOC content and/or VOC emissions.

**FOR INFORMATION OR ASSISTANCE
CALL: 1-800-553-1380**

**IN CANADA CALL:
1-800-265-1840**

**Internet:
www.3M.com/roadwaysafety**

3M and Stamark are trademarks of 3M. Used under license in Canada.

3M assumes no responsibility for any injury, loss or damage arising out of the use of a product that is not of our manufacture. Where reference is made in literature to a commercially available product, made by another manufacturer, it shall be the user's responsibility to ascertain the precautionary measures for its use outlined by the manufacturer.

Important Notice

All statements, technical information and recommendations contained herein are based on tests we believe to be reliable, but the accuracy or completeness thereof is not guaranteed, and the following is made in lieu of all warranties, or conditions express or implied. Seller's and manufacturer's only obligation shall be to replace such quantity of the product proved to be defective. Neither seller nor manufacturer shall be liable for any injury, loss or damage, direct, indirect, special or consequential, arising out of the use of or the inability to use the product. Before using, user shall determine the suitability of the product for his/her intended use, and user assumes all risk and liability whatsoever in connection therewith. Statements or recommendations not contained herein shall have no force or effect unless in an agreement signed by officers of seller and manufacturer.



Traffic Safety and Security Division
3M Center, Building 225-04-N-14
St. Paul, MN 55144-1000
1-800-553-1380
www.3M.com/roadwaysafety

3M Canada Company
P.O. Box 5757
London, Ontario N6A 4T1
1-800-3MHELPS

3M México, S.A. de C.V.
Av. Santa Fe No. 55
Col. Santa Fe, Del. Alvaro Obregón
México, D.F. 01210

Please Recycle
© 3M 2014. All rights reserved.
Electronic Only