



## Automotive Aftermarket Division

### 3M™ 58012 Single Step Low VOC Primer

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#### 1) Part Numbers

50812	:	30ml bottle
51011	:	250ml bottle

#### 2) Description and end uses

3M™ 58012/51011 is a single step low VOC primer designed to prime surface in order to improve the adhesion of polyurethane sealants onto glass that has been treated with a ceramic silk screen printing. The application is common in the automotive industry.

#### 3) Physical Properties

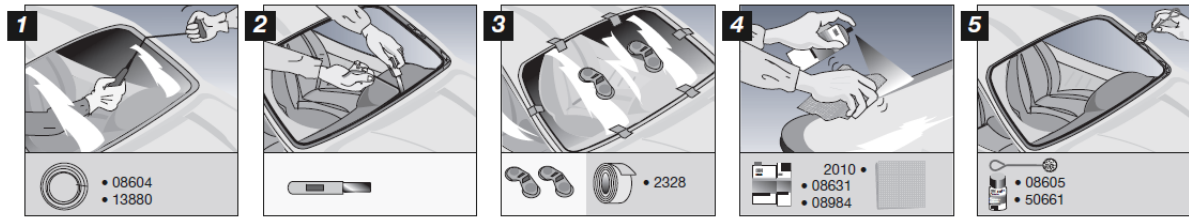
Colour	black liquid
Viscosity	100 ml DIN cup, Ø=4 mm: 12-15 sec
Density at 20°C	0.9 ± 0.05
Conventional solids content (EN 827)	28.5 ± 1.5%
Application temperature	5 to 25°C
Drying time	10 to 15 min



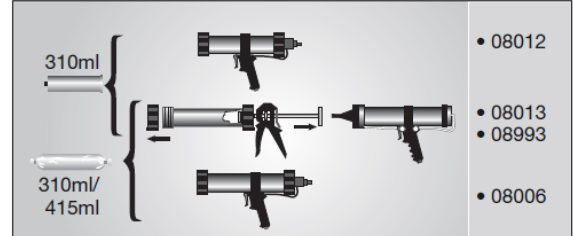
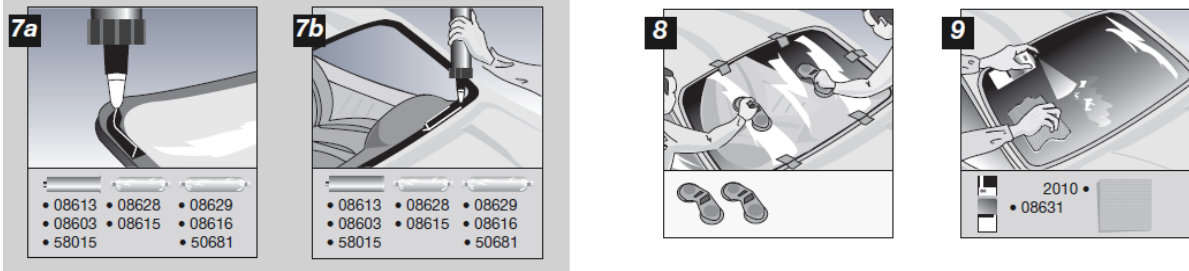
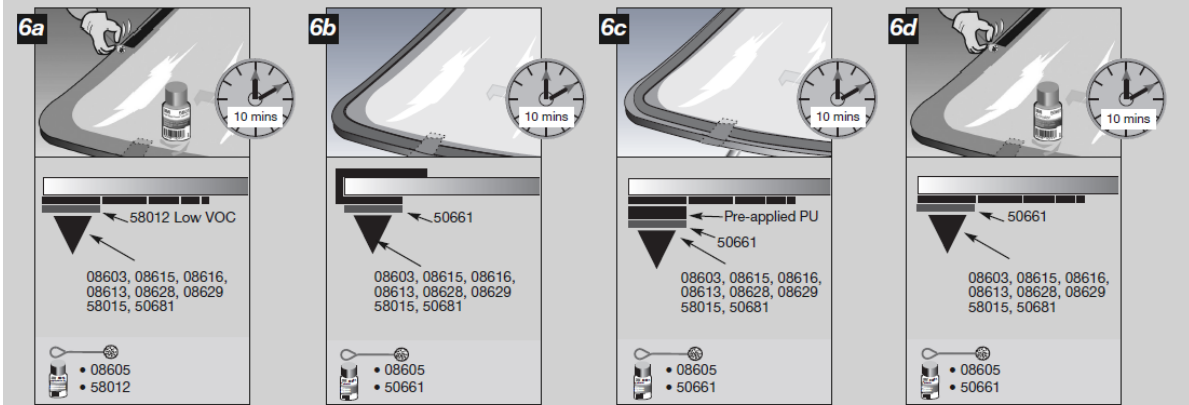
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## 4) Directions for Use



Ceramic Ceramique Keramik Keramikk Keraminnen Keraminn Cerámica Keramik Keramikk Cerámica	Keramikk Keramik Ceramica Keramik Keramikk Keramik Keramikk Cerámica Keramikk Keramik	Keramikk Sikkas su keramike joostele Ceramic С керамической облицовкой Keramik Keramikk Keramikk Keramikk Keramikk Keramikk Keramikk Keramikk Seramik קראמיק	PU Encapsulated PU PU Verkapselung PU Inkapsuliert PU Forseglet PU Encapsulado PU Inkapsuliert	PU Evbükapıyivro PU Inkapsulato Poliretan PU Keretes PU zapuzdenie Zapuzdeny PU Ekapsuliran PU Hermetik PU Inkapsulats Sikkas su PU remiki	PU protejekt С полиуретановой рамкой Obloženo С прадаржэннем нарэсена PU лясно Obloženo PU enkapsilė ליני בתרילי PU דבוק Polir etano aplikado anteri ormente	Pre-applied PU Pre-appliqué PU Voorbehandelde PU Voorbehandelde PU Vanha PU-lima Tälgene pihvit PU Pre-aplicação PU For-ålagt PU Polir etano aplikado anteri ormente	Fibrapplicerad PU Me proefprijozimj PU PU pre-applique Wegene pokrycie potratanen Etikõõne lüvitit PU Fibredn aplikovany PU Vopred aplikovany PU Prej nanesen PU Eelpäigaldatud PU Iepriekš noklāts ar PU	Sikkas, padentes PU kijais PU preapplied Со слоем полиуретана Tromski naneseno PU (jelo) С прадаржэннем нарэсена PU лясно Faktiski nanesen PU lepak Oncoden PU ugglanan ליני היסודי PU	Preprimed Pré-primé MR Haftvermittler behandelt Voorgreptmered Esige meretita Tälgene primet Pré primado For-primet Imprimación previa Fõõprimad	Me proefprijozimj Acríl Pre-primizzato Wegene pokrycie podkladem Etikõõne primenest Opulise zakladno nitrem Vopred aplikovany primer Prej nanesen primer Kunt Iepriekš grunsts Gruntotas sikkas	Primer preapplied Zarguytovaniye Tromski nanesen primer Pradargatanen nanesen primet Faktiski nanesen primer Oncoden primerlenimj ליני היסודי
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3M PRODUCT Application	58012 Single Step Primer Low VOC	08617 Bottle WSD Clear	50661 Activator
Fritted Glass - 6a	✓		
Encapsulated Glass (PU or PVC) - 6b			✓
Pre-primed - 6d		✓	✓
Fritted Glass with pre-applied PU - 6c			✓
Lacquered steel or Aluminium - 5			✓
Steel-Aluminium without paint (spot repair) - 5	✓		
Glass or Tinted Glass*	✓	✓	

Never use alcohol. \*The primer must not be directly under UV exposure, a frame has to be applied on the other side in order to avoid UV exposure.

Drive Away Time  
Temps de libération du véhicule  
Wegfahrzeit  
Rijvaardrijd  
Kulvimisaika  
"Kjer i vel tid"  
Tempo de condução  
Tempo de seguridad antes de conducir  
Klar att köra  
Χρόνος Αποχώρησης Αυτοκινήτου  
Tempo di riconsegna veicolo  
Gotowości do jazdy  
Teljes száradási idő

Doba před jízdou  
Bezpečný čas do odjázdu vozidla  
Čas varnega odhoda  
Säduks valmis  
Žušanas laiks  
Dziūvimo laikas  
Тimp de imobilizare  
Время высыхания  
Vrijeme sušenja  
Време за съхнене  
Vreme sušenja  
Uygulama sonrası yola çıkış zamanı  
גומי התנתה לפני תחילת נהיגה

08603 / 08615 / 08616	08613 / 08628 / 08629	58015 / 50681
310ml 310ml 415ml	310ml 310ml 415ml	310ml 415ml
4 Hours/Heures/Stunden/Урен/Tuntia/Timer/Horas/Timer/Hours/Timmer/Dpico/Ore/Gođiny/Orak/Hodiny/Hodiny/Use/Tundi/Stundas/val./Ore/48c./sata/48006/sata/Saetter/תלן/ש	90 Minutes/nn/Minuten/Minuten/Minutia/Minutier/Minutos/Minuter/Minutos/Minutis/Minuti/Minut/Percek/Minuty/Minuty/Minuta/Minuti/Minutis/min./Minute/Min./minuta/Minuta/Deikaler/תק/דק	60 Minutes/nn/Minuten/Minuten/Minutia/Minutier/Minutos/Minuter/Minutos/Minutis/Minuti/Minut/Minuty/Percek/Minuty/Minuty/Minuta/Minuti/Minutis/min./Minute/Min./minuta/Minuta/Deikaler/תק/דק
8 Hours/Heures/Stunden/Урен/Tuntia/Timer/Horas/Timer/Hours/Timmer/Dpico/Ore/Gođiny/Orak/Hodiny/Hodiny/Use/Tundi/Stundas/val./Ore/48c./sata/48006/sata/Saetter/תלן/ש	3 Hours/Heures/Stunden/Урен/Tuntia/Timer/Horas/Timer/Hours/Timmer/Dpico/Ore/Gođiny/Orak/Hodiny/Hodiny/Use/Tundi/Stundas/val./Ore/48c./sata/48006/sata/Saetter/תלן/ש	60 Minutes/nn/Minuten/Minuten/Minutia/Minutier/Minutos/Minuter/Minutos/Minutis/Minuti/Minut/Minuty/Percek/Minuty/Minuty/Minuta/Minuti/Minutis/min./Minute/Min./minuta/Minuta/Deikaler/תק/דק



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## a) Glass preparation:

1. Always ensure that surfaces are clean and free from contamination.
2. Use 08631 Glass cleaner or 08984 Adhesive cleaner on red ScotchBrite™.
3. Clean with a light action.
4. Wipe over surface with 08631 Glass cleaner or 08984 Adhesive cleaner on a clean wipe.
5. Shake 58012/51011 single step Low VOC primer for 30 seconds before use, ensuring the metal ball contained within is moving freely.
6. Apply a thin layer of 58012/51011 single step Low VOC primer to the glass ceramic and leave for a minimum of 10 minutes (see Fig 6A).
7. For pre-primed edges, ceramic edges with pre-applied PU and encapsulated edges use the 50661 Activator and clean without using red ScotchBrite™.

Special instruction: For pre-primed glass, check adhesion of the pre-applied primer before applying 3M™ 50661 Activator. If adhesion is poor remove the pre-applied primer.

For glass or tinted glass, the 3M™ 8617 first step primer must be applied before the 58012/51011 Low VOC primer. A frame must be applied on the other side in order to avoid UV exposure.

## b) Pinch weld preparation:

1) Where original polyurethane adhesive remains on the body frame, clean with 3M™ 08984 Adhesive Cleaner. Allow to dry before using a knife to reduce the thickness of the polyurethane to 1 mm. Apply 3M™ 58015 / 50681 glass adhesive. Use 3M™ 58012/51011 single step Low VOC primer to protect any exposed bare metal from corrosion. Do not apply any primer on the old polyurethane adhesive.

2) On a newly painted body frame (paint fully cured), apply 3M™ 50661 Activator. Allow to dry for a minimum of 10 minutes. Extrude a bead of 3M™ 58015 / 50681 Glass Adhesive onto the glass or the body frame (depending on car manufacturers' instructions). Install the glass within 10 minutes. Clean any excess adhesive using 3M 08984 Adhesive Cleaner. Application temperature is +10°C to +35°C.

## 5) Storage

12 months in unopened original packaging stored in dry premises between 0 and 25°C. Any contact with humidity (air moisture) will cause 3M™ 58012 to cure; therefore the product must be used within 24 hours after opening the bottle.

Hermetically seal the bottle immediately after use.



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## 6) Safety

3M™ 58012/51011 is highly flammable, extinguish all sources of ignition before use.

Harmful. Read material safety data sheet before use.

Do not breathe fumes and do not allow skin contact.

3M™ 58012/51011 Single Step Low VOC Primer is designed FOR PROFESSIONAL INDUSTRIAL USE ONLY.

## 7) Disclaimer

All statements, technical information and recommendations are based on tests we believe to be reliable as at the date of hereof, but the accuracy or completeness thereof is not guaranteed. Please ensure before using the product that it is suitable for your intended use. Since the conditions and methods of use of the product and of the information referred to herein are beyond our control, other than for fraudulent misrepresentation, 3M expressly disclaims any and all liability as to any results obtained or arising from any use of the product or reliance on such information.



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## For Additional Health and Safety Information

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