

3M™ Adhesion Promoter N210

Technical Data Sheet



Description

3M™ Adhesion Promoter N210 is used to improve the adhesion of 3M™ Acrylic Foam and Acrylic Plus Tapes to automotive substrates such as polyvinyl chloride (PVC), acrylonitrile butadiene styrene (ABS), polypropylene (PP), polycarbonate (PC), glass, acrylic, nylon, polyester, polyurethane (PU), polybutylene terephthalate (PBT), and stainless steel (SUS). 3M adhesion promoter N210 is specifically formulated to be used with 3M acrylic foam tapes for automotive applications. Because substrate formulations and surface energies may vary for these materials, each application should be tested for compatibility.

Physical Properties

Components	Toluene, ethyl acetate, chlorinated rubber, polymeric isocyanate. Also contains molecular sieve pellets, containing silica, aluminum oxide and sodium oxide.
Color	Tan liquid
Solids	Approximately 3-5%
Drying Time	<60 seconds
Flashpoint	5°C (41°F)
Coverage	75 m ² (800 ft ²) per gallon (Based on 50 micron wet coating thickness)
Net Weight	880 g/l (7.34 lb/gal)

Equipment

3M adhesion promoter N210 can be applied with a pressurized flow gun or other similar type applicator. Applicator heads should be cleaned or replaced regularly. Your 3M Automotive and Aerospace Solutions Division representative can assist in identifying application options.

Surface Preparation

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

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

Handling

Shake well before using. One-liter cans contain solid pellets called molecular sieves that act as drying agents. The molecular sieves prevent 3M Adhesion Promoter N210 from prematurely curing. Do not remove these sieves from the can. Once 3M adhesion promoter N210 is decanted into another container and exposed to airborne moisture, curing can begin quickly, especially with high relative humidity. To prevent premature curing and excessive waste, transfer only enough 3M adhesion promoter N210 into a container for 8 to 12 hours of production. Cloudiness is indicative of moisture curing. Once 3M adhesion promoter N210 loses its clarity and becomes foggy or hazy, it is no longer

Application

Apply a thin, uniform coating to the bonding surface using the minimum amount that will fully coat the surface. This is typically less than 50 micron thick. Allow 3M adhesion promoter N210 to dry thoroughly before applying tape. Drying is usually accomplished in less than one minute. Allowing dry time of ten minutes can improve initial adhesion value. For best results, apply tape within 30 minutes after application of promoter. Be sure the primed surface remains free from contaminants prior to laminating the tape. Ultimate adhesion generally occurs after 24 hours of bonding.

Clean-Up

3M Adhesion Promoter N210 can be cleaned up with acetone solvents. Vigorous scrubbing may be required.

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

Shelf Life

Shelf life is one year from date of manufacture when stored in the original container at 5°C – 35°C (41°F – 95°F) and 0 – 80% relative humidity and the following precautions are observed:

- Store 3M adhesion promoter N210 in the original container
- Transfer only small amounts for 8 to 12 hours of production into other containers
- Return the original, tightly sealed container to storage to avoid moisture contamination

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/.

Important: Please consult Federal, State and Local Regulations. State Volatile Organic Compound (VOC) regulations may prohibit the use of certain alcohol solutions, solvents and other VOC-containing products. You should check with your state environmental authorities to determine whether use of a solution, solvent or product is restricted or prohibited.

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 application engineering representative or call 1-800-328-1684.

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