



3M™ Scotch-Weld™ Structural Adhesive Primer EC-1290

Technical Data Sheet

Introduction

Scotch-Weld™ Structural Adhesive Primer EC-1290 is a sprayable primer for Scotch-Weld™ films. It is especially suggested for use with 3M™ Scotch-Weld™ Structural Adhesive Films AF-6 and AF-10. Specific data can be found under the test result section of the Scotch-Weld AF-6 and AF-10 technical data sheet.

Scotch-Weld EC-1290 when properly applied, offers the following advantages:

- Simplified production scheduling by protecting the cleaned surfaces until the bonding operations can be completed.
- Improved resistance to environmental exposures.
- Improved adhesion at elevated temperatures.

Product Description

Color:	Clear to Light Amber
Base:	Synthetic Rubber
Solvent:	Blend of Ketones
Viscosity:	14-16 cps (No. 1 Spindle 20 rpm at 77°F[25°C])
Solids Content:	10% ± 1%

Note: The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

Application

A thoroughly cleaned, dry, grease-free surface is essential for maximum performance.

leaning methods which will produce a break-free water film on metal surfaces are generally satisfactory.

Surface preparations should be fully evaluated with the adhesive, especially if resistance to severe environments are anticipated.

For aluminum, the best performance will be achieved with the surface preparation by alkaline degreasing, then FPL etching according to ASTM D2674, and followed by phosphoric acid anodizing according to ASTM D3933.

Scotch-Weld EC-1290 is satisfactorily applied by brush coating or spraying with a conventional HVLP spray gun. Primer must be thoroughly stirred just prior to application. Apply a dry film thickness of 0.002 - 0.0004 inches.

Primer Dry/Cure

The following cures for Scotch-Weld EC-1290 are suggested for use with 3M™ Scotch-Weld™ Structural Adhesive Films AF-6, AF-10, and AF-13.

Air Dry – 30 minutes minimum at 75 ± 5°F (24 ± 3°C).

Force Dry – Bake in a circulating air oven. Two cycles have proved satisfactory.

- Primed surface held at 180°F ± 5°F (82°C ± -15°C) for 30 ± 10 minutes.
- Primed surface held at 250°F ± 5°F (121°C ± -15°C) for 30 ± 10 minutes.

Primer Dry/Cure (*continued*)

The primed surface, after cooling to ambient temperatures, is ready for adhesive bonding. The primed surface should be protected from contamination introduced by dust, fingerprints, oil, etc.

If extended periods of storage is contemplated, wrap the parts in unplasticized Kraft paper. If the primed surface is contaminated with dust, it may be cleaned prior to bonding by wiping with clean, unsized cheese-cloth.

Primer Cleanup

Excess primer and equipment may be cleaned up, prior to curing, with ketone* type solvents.

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

Storage

3M™ Scotch-Weld™ Structural Adhesive Primer EC-1290 shelf life is 6 months from the date of shipment when stored between 35° to 45°F (1° to 7°C) or below in the original unopened container.

Caution: Primer should be permitted to thoroughly warm to room temperature before being used in order to prevent moisture condensation.

Regulatory Information

Please refer to the product label and Safety Data Sheet (SDS) for health and safety information before using.

Contact Information

The information provided in this technical document is intended as a guide for these products. For more information or help in selecting a 3M product for an application, please contact your 3M technical service representative or call 1-800-328-1684.

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