

Automotive Aftermarket Division

3M™ 58012 Single Step Primer

1) Part Numbers

50812 : 30 ml bottle
 51011 : 250 ml bottle

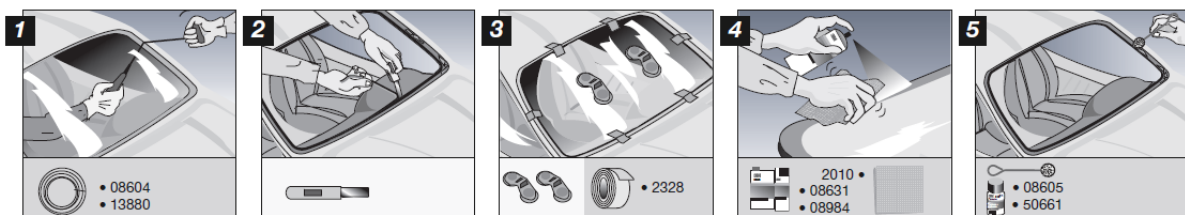
2) Description and end uses

3M™ 58012/51011 is a single step 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

4) Directions for Use



Ceramic Céramique Keramik Keramika	Keramick Κεραμικό Cerámico Keramik Keramik Keramik Keramik Keramik Keramik	Keramikas Stiklas su keramine juostele Ceramic С керамической облицовочной Kerámia Keramická vrstva Keramická Keramiken Seramik קראמיק	PU Encapsulated Encapsulé PU PU Verkapselung PU Inkapuslēt PU Forseglet PU Encapsulado PU Inkapuslēt	PU Evēlokuojimo PU Inkapuslēt Polietilēns PU Kerfles PU zapardzēci Zapardzēny PU Ekapsulāns PU Hermetik PU Inkapuslēt Stiklas su PU rēnulu	PU projekt С полимерной рамкой Обложено С предпримено нанесен PU ленто Обложено PU enkapsulē לכני בתווילי PU רנולו	Pre-applied PU Pré-appliqué PU Vorverarbeitetes PU Voorbehandelde PU Vorimta PU-lima Tālgarņe pīrēt PU Pré-aplicação PU For-āplēt PU Polietilēns aplicādo antēriormēte	Fīrāaplicērad PU Me pīroepīroojēvē PU PU pr-e-aplicāto Wāgēne pokrēje pīroētānēn Eižālēg fēlētvi PU Phēden aplikovāny PU Vopred aplikovāny PU Prej nānēn PU Eižpālgaldēt PU Iepriekš nāklēts ar PU	Sīklas, padēģēts PU kījās PU pīroapīcēt Со сломом полимеризации Tīvīnīki nānēn PU lējlo С pīdēģāpīroojē nānēn PU rēnulo Fābriķī nānēn PU lēpak Ōnēden PU uggulān PU לבי יימון סדיק	Preprimed Pré-prīmē Mit Haftvermittler behandelte Voorgaprimerd Eižpīmerulāto Tīdīgē primēt Prē primēro For-primēt Impregnación previa Főprimad	Me pīroepīroojēvo Actīvo Pre-primēzato Wāgēne pokrēje pīoklādēn Eižālēg primēroojēt Opātēro zāklādēn nāklēn Vopred aplikovāny primēr Prej nānēn primēr Kuntī Iepriekš grūnīts Grūntoātas stīklas	Primer pīroapīcēt Загрунтование Tīvīnīki nānēn primēr Pīdēģāpīroojē nānēn primēr Fābriķī nānēn primēr Ōnēden primērlemīg לבי הרטימר
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310ml		• 08012
310ml / 415ml		• 08013 • 08993
310ml / 415ml		• 08006

3M PRODUCT Application	58012 Single step Primer	50661 Activator
Fritted Glass – 6a	✓	
Encapsulated Glass (PU or PVC) – 6b		✓
Pre-primed – 6d		✓
Fritted Glass with pre-applied PU – 6c		✓
Lacquered steel or Aluminum - 5	✓	✓
Steel-Aluminum Without Paint (spot repair) - 5	✓	✓
Glass or Tinted Glass*	✓	✓
Organic Glass (PMMA or PC)**	✓	✓

Never use alcohol. **The Primer must not be under UV exposure, a frame has to be applied on the other side in order to avoid UV exposure. ** Use the Activator in combination with the single step Primer.

Drive Away Time Temps de libération du véhicule Wegfahrzeit Rijksaartijd Kuhumis aika "Kjer i vel tid" Tempo de condução Tempo de seguridad antes de conducir Klar att köra Χρόνος Αποχώρησης Αυτοκινήτου Tempo di riconsegna vettura Gotowość do jazdy Teljes száradási idő	Doba před jízdou Bezpečný čas do odjízdu vozidla Čas varnega odhoda Säiđuks valmis Žūšanas laiks Dziļvimo laikas Timp de imobilizare Время высыхания Vrijeme sušenja Време за съхнене Vreme sušenja Uygulama sonrası yola çıkış zamanı נזמן התנה לנני תחילת נהיגה	08603 / 08615 / 08616 310ml 310ml 415ml	08613 / 08628 / 08629 310ml 310ml 415ml	58015 / 50681 310ml 415ml		
	4 Hours/Heures/Stunden/Uren/Tantia/Timer/Horas/Timer/ Hours/Timer/Órák/Órák/Hodiny/Hodiny/ Ure/Tundi/Stundas/val./Ore/48c./sata/4ac06e/sata/ Sastien/TU/VV	90 Minutes/mv/Minuten/Minuten/Minutia/Minutia/ Minutos/Minutos/Minutos/Minutos/Minutis/Minutis/ Percek/Minuty/Minuty/Minuty/Minutis/min./ Minuta/Min./minuta/Minuta/Dakikalar/תק	60 Minutes/mv/Minuten/Minuten/Minutia/Minutia/ Minutos/Minutos/Minutos/Minutos/Minutis/Minutis/ Minuty/Percek/Minuty/Minuty/Minutis/Minutis/ min./Minuta/Min./minuta/Minuta/Dakikalar/תק	8 Hours/Heures/Stunden/Uren/Tantia/Timer/Horas/Timer/ Hours/Timer/Órák/Órák/Hodiny/Hodiny/ Ure/Tundi/Stundas/val./Ore/48c./sata/4ac06e/sata/ Sastien/TU/VV	3 Hours/Heures/Stunden/Uren/Tantia/Timer/Horas/Timer/ Hours/Timer/Órák/Órák/Hodiny/Hodiny/ Ure/Tundi/Stundas/val./Ore/48c./sata/4ac06e/sata/ Sastien/TU/VV	60 Minutes/mv/Minuten/Minuten/Minutia/Minutia/ Minutos/Minutos/Minutos/Minutos/Minutis/Minutis/ min./Minuta/Min./minuta/Minuta/Dakikalar/תק

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 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 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 single step 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 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 °C 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.

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 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.

For Additional Health and Safety Information

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