

Automotive Aftermarket Division

3M™ 58012 Single Step Primer

1) Part Numbers

50812 : 30 ml bottle
 51011 : 250 ml bottle

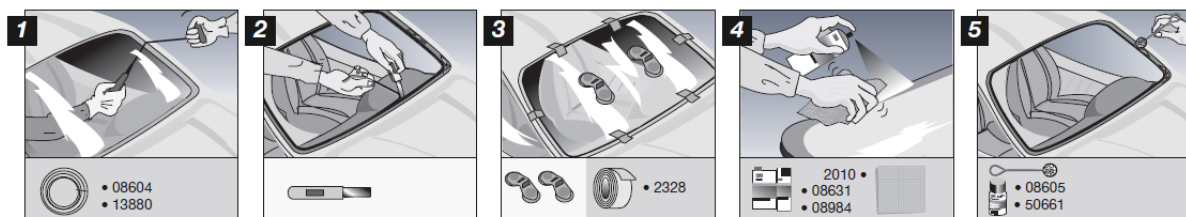
2) Description and end uses

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





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.



Technical Data Sheet

Effective: 11/06/2024 Supersedes: 19/08/2020

For Additional Health and Safety Information

3M South Africa & Sub-Saharan Africa, 146A Kelvin Drive, Woodmead, Sandton, South Africa, Tel: (0861) 225536
3M (East) AG Representation Office Tirane, Rruga Sami Frasheri, Pallati i Ri Perxhola Kati 2 Ap2, 1000 Albania
3M Arabia, LLC, Building 24-25 3M Saudi Arabia Zone C, Business Gate, Airport Road, Riyadh, Saudi Arabia
3M Bulgaria, Mladost 4, Business Park, bl.4, 2nd floor, Sofia 1766, Bulgaria
3M Česko, spol. s r.o., V Parku 2343/24, 148 00 - Praha 4, Czech Republic
3M (East) AG, Branch office Croatia, Avenija Većeslava Holjevca 40, 10 000 Zagreb, Croatia, Tel: +385 1 2499750, www.3m.com.hr
3M Egypt, Finance Center , New Cairo , Plot 140 , Banking Sector , 5th settlement , Cairo , Egypt
3M Hellas MEPE, Automotive Aftermarket Division, 20 Kifisias Avenue, 151 25 Marousi, Greece, Phone: +30 210 68 85 300, innovation.gr@mmm.com, www.3M.gr
3M Hungária Kft, Neumann János u. 1/E, 1117 Budapest, Hungary
3M Israel, 91 Medinat Hayehudim St., Herzliya, Israel
3M Kenya Ltd, Victoria Towers, 3rd Floor, Kilimanjaro Av, Upperhill, Kenya
3M Gulf Limited, Ein El Mreisseh, Saint Charles City Center, 4th. Floor, P.O.Box: 11-5025, Riad el Solh, Beirut 1107 2180 Lebanon
3M Minnesota Mining & Manufacturing Nigeria Limited, No 2 Sheraton Opebi Link Road, Ikeja, Lagos Nigeria
3M Pakistan, Islamic Chamber of Commerce Building, ST-2/A, Block 9, KDA Scheme 5, Clifton, Karachi, Pakistan
3M Poland, Al. Katowicka 117, Kajetany, 05-830 Nadarzyn, Poland, Telefon: +48 22 739 60 00, www.3m.pl/kontakt
3M Gulf (Representation Office), Suhaim Bin Hamad St., Al Mana Towers Tower B, 2nd Floor, Office No.4, Doha Qatar, P.O.Box 14685
3M Romania, 12 Meneuțului St., Bucharest Business Park, Building D, District 1 013713 Bucharest, Romania
3M (East) AG, Representation Office Serbia, Airport City, Omladinskih brigada 90B, 11070 Belgrade, Serbia, Tel: +381 11 2209 400, www.3m.co.rs/3M/sr_RS/3m-south-east-europe/
3M Slovensko s.r.o., Polus Tower 2, Vajnorská 100/B, 83104 Bratislava
3M (East) AG, Branch office Slovenia, Cesta v Gorice 8, 1000, Ljubljana, Slovenia, Tel: +386 1 2003 630, www.3m.com/3M/sl_SI/3m-south-east-europe/
3M Sanayi ve Ticaret As, Barbaros Mah., Mor Sümbül Sok., No:7/3F, 27-51, Nidakule Ataşehir Güney, 34746 Ataşehir, İstanbul, Turkey
3M Gulf Limited, Dubai Internet City, Building No. 11, 3rd Floor, U.A.E
3M España, S.L., sucursal em Portugal, Edifício Office Oriente, Rua do Mar da China N°3 - Piso A, 1990-138 Lisboa, www.3m.com.pt/3M/pt_PT/empresa-pt/ajuda/

© 3M 2024. 3M and ScotchBrite are trademarks of the 3M company. All rights reserved



Technical Data Sheet

Effective: 11/06/2024 Supersedes: 19/08/2020