



# 3M™ Adhesion Promoters

## Application Guidelines - Repackaging Promoters for Use

3M provides a number of adhesion promoters that are suited for different substrate and application combinations. These adhesion promoters are not interchangeable. Mixing or substituting adhesion promoters without consultation with 3M application engineering personnel can lead to adhesion failures. Care must be taken to ensure that adhesion promoters are not inadvertently mixed or substituted when poured into bottles or other containers to facilitate application to parts.

### Adhesion Promoter Color-Coded Labels

To simplify the immediate identification of pre-packaged adhesion promoters, a color-coded label system is being implemented. The color codes are as follows:

3M™ Adhesion Promoter 4298UV	Blue	
3M™ Adhesion Promoter K520UV	Red	
3M™ Adhesion Promoter 2262AT	Orange	
3M™ Adhesion Promoter K500	Yellow	
3M™ Adhesion Promoter K500NT	Pink	
3M™ Adhesion Promoter K540NTUV	Lavender	
3M™ Adhesion Promoter C110	Magenta	
3M™ Adhesion Promoter G200	Gray	
3M™ Adhesion Promoter N210	Navy Blue	

### Application Bottles

Application bottles for adhesion promoter must be clean of contaminants and made of solvent-resistant plastic. Use of other bottles may allow the adhesion promoter to become contaminated with moisture from the air, thus reducing adhesion. Appropriate bottles, applicator tips, and funnels may be sourced from various vendors including:

Designetics  
 1624 S Eber Rd  
 Holland, OH 43528  
 Phone (419)-866-0700  
[www.designetics.com](http://www.designetics.com)

### Color-Coding of Application Bottles

It is recommended that application bottles be color coded to match the adhesion promoter color-coded labels. This may be accomplished by the use of colored vinyl tape or stickers, pre-printed colored labels, colored bottle tops or collars, or some other method.

3M Adhesion Promoters 4298UV, K520UV and K540NTUV contain a UV-visible dye. Primer on parts will glow under black light, to allow visual verification of primer coverage.

## Distinguishing Between 3M Adhesion Promoters in Unlabeled Bottles

In the event that a user is uncertain which adhesion promoter is in a bottle, 3M may be able to assist. Please contact your 3M application engineering representative or call 1-800-328-1684.

## Special Handling Instructions for 3M Adhesion Promoters

Shake well before using. As a best practice for 3M Adhesion Promoters in general, to prevent premature curing and excessive waste, transfer only enough adhesion promoter into a container for 8 to 12 hours of production.

Containers of 3M™ Adhesion Promoter K500, K500NT, N210, and C110 contain solid pellets called molecular sieves that act as drying agents. The molecular sieves prevent 3M adhesion promoter K500, K500NT, N210, and C110 from prematurely curing. Do not remove these sieves from the container. Once 3M adhesion promoter K500, K500NT, N210, and C110 is decanted into another container and exposed to airborne moisture, curing can begin quickly, especially with high relative humidity. Cloudiness is indicative of moisture curing. Once 3M adhesion promoter K500, K500NT, N210, and C110 loses clarity and becomes foggy or hazy, the products are no longer usable.

## Special Handling Instructions

See product SDS for special handling instructions and PPE requirements when transferring and or using these products.

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

Technical Information: The technical information, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed. Product Use: Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. Given the variety of factors that can affect the use and performance of a 3M product, user is solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user's method of application. Warranty, Limited Remedy, and Disclaimer: Unless an additional warranty is specifically stated on the applicable 3M product packaging or product literature, 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY IMPLIED WARRANTY OR CONDITION ARISING OUT OF A COURSE OF DEALING, CUSTOM OR USAGE OF TRADE. If the 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M's option, replacement of the 3M product or refund of the purchase price. Limitation of Liability: Except where prohibited by law, 3M will not be liable for any loss or damage arising from the 3M product, whether direct, indirect, special, incidental or consequential, regardless of the legal theory asserted, including warranty, contract, negligence or strict liability.



Automotive and Aerospace Solutions Division  
3M Center  
St. Paul, MN 55144-1000  
Phone 1-800-328-1684  
Web [www.3M.com/autosolutions](http://www.3M.com/autosolutions)

3M is a trademark of 3M Company  
Please recycle. Printed in USA.  
© 3M 2020. All rights reserved.