

# 3M™ Adhesion Promoter K500NT

## Technical Data Sheet



### Description

3M™ Adhesion Promoter K500NT is a liquid primer used to improve the adhesion of 3M™ Acrylic Foam and Acrylic *Plus* Tapes to polyolefin-based materials such as polypropylene, TPO and EPDM. Since formulations and surface energies vary for these materials, each application should be verified through testing. 3M Adhesion Promoter K500NT is specifically formulated to be used with 3M Acrylic Foam and Acrylic *Plus* Tapes for automotive applications.

### Physical Properties

<b>Color</b>	Straw
<b>Solid Material</b>	Synthetic Resin
<b>Solvent Material</b>	Methylcyclohexane and N-Butyl acetate
<b>Solid %</b>	Approximately 8%

### Equipment

3M adhesion promoter K500NT can be applied by a gravity feed wipe, knurled roller, sprayer and felt-tipped applicator or other similar type applicator. Applicator heads should be cleaned or replaced regularly. A convenient application system is available through your 3M Automotive Division representative.

### Surface Preparation

The bonding surface should be clean and dry. Contaminated surfaces should be cleaned with an untreated, lint-free cloth and an appropriate solvent (typically isopropyl alcohol).\*

### Application

Shake well before using. Apply a thin, uniform coating to the bonding surface, using the minimum amount that will fully coat the surface. A wet coating thickness of 0.002 inch or less ensures a good application. In general, the drying time under standard conditions (23° and 65% relative humidity) is 30 seconds to 24 hours. Drying time varies depending on the ambient temperature and humidity, as well as the coating thickness. Recommended drying time is 10 minutes to 3 hours under standard conditions. Be sure the primed surface remains free from contaminants prior to laminating the tape. If drying time is more than 24 hours, re-apply the adhesion promoter.

## Clean-Up

3M™ Adhesion Promoter K500NT can be removed with acetone solvent.\* Vigorous scrubbing may be required. \***Note:** When using solvents, extinguish all ignition sources and follow the manufacturer's precautions and directions for use.

## Shelf Life

Two years from the date of manufacture when stored in the original container at 4°C–38°C (40°F–100°F), 0–95% relative humidity, and away from light sources. Storage at lower temperatures for short periods will not affect product performance if the primer is warmed to recommended temperatures before application.

## Regulatory Information

Observe proper handling precautions as outlined in the Material Safety Data Sheet (MSDS), which is available on request. The website address for 3M MSDSs is [www.3M.com/MSDS](http://www.3M.com/MSDS).

## 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 technical service representative or call 1-800-328-1684.

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