Tape Primer
94

Technical Data **May, 2013**

Product Description

3M™ Tape Primer 94 can be used to promote adhesion of 3M tapes to surfaces such polyethylene, polypropylene, ABS, PET/PBT blends, concrete, wood, glass, metal and painted metal surfaces.

Low VOC Alternates

	g/l VOC	Substrates
3M™ Scotch-Weld™ Plastic Adhesive 2262 Thin 5 or 10 to 1 in acetone	196	Powder Paints
3M™ Scotch-Weld™ Plastic Adhesive 1099 Unthinned	0	Neoprene, Santoprene, EPDM

Note: 3M primer 94 contains greater than 250 g/l of volatile organic carbons (VOC). Less water, less exempt solvents. Please contact your local Air Quality Regulation to be sure this primer is compliant.

Typical Physical Properties and Performance Characteristics

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

Solids:	Approximately 6%
Color:	Clear light yellow – clear dark orange
Flashpoint:	-4°F (-20°C) O.C.
Coverage:	600 sq. ft. (14.7 sq. m/l) per gallon
Net Weight:	820 grams per liter
Viscosity:	Typical range is 1-10 cps (35 cps maximum)

Application Techniques

Surface Preparation: The bonding surface must be relatively clean and dry. Contaminated surfaces should be cleaned with a 50/50 Isopropyl Alcohol and water mixture. A clean lint-free cloth should be used.

Application: Shake 3M Primer 94 well before using. Apply a thin uniform coating to the bonding surface using the minimum amount that will fully coat the surface. Allow 3M Primer 94 to dry thoroughly before applying tape. This is usually accomplished in 5 minutes at room temperature. Be sure the primed surface remains free from contaminants prior to applying the tape. Porous surfaces may require 2 applications of 3M Primer 94 for uniform coverage and good adhesion. Allow first application of primer to dry before applying the second coat. 3M Primer 94 may be applied with brush or swab. It can also be applied with a pressurized flow gun, knurled roller or other similar type of application equipment.

Clean up: 3M Primer 94 can be removed with acetone. Vigorous scrubbing may be required. Test in small area to insure acetone will not affect the substrate surface.

Note: Carefully read and follow manufacturer's precautions and directions for use when handling cleaning solvents.

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Shelf Life

18 months from date of manufacture when stored in the original container at 60-80°F (15-27°C).

- Keep 3M™ Tape Primer 94 in the original container.
- Transfer only a small amount into a work vessel for use.
- Keep original container tightly sealed to avoid solvent evaporation.

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.

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ISO 9001

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001 standards.

3M

Industrial Adhesives and Tapes Division
3M Center, Building 225-3S-06
St. Paul, MN 55144-1000
800-362-3550 • 877-369-2923 (Fax)
www.3M.com/industrial

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