# **3M Tape Primer**94

<b>Product Description</b>	3M <sup>TM</sup> 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/I VOC	Substrates
	3M <sup>™</sup> Scotch-Weld <sup>™</sup> Plastic Adhesive 2262 Thin 5 or 10 to 1 in acetone		196	Powder Paints
	3M <sup>™</sup> Scotch-Weld <sup>™</sup> Plastic Adhesive 1099 Unthinned		0	Neoprene, Santoprene EPDM
Typical Physical	Note: The following	ontact your local Air Quality R technical information ar	egulation to be sure	e this primer is compliant.  De considered representative
Properties and Performance	Note: The following or typical only	ontact your local Air Quality R technical information ar and should not be used	egulation to be sur nd data should l for specification	pe considered representativ
Properties and Performance	Note: The following or typical only Solids:	technical information ar and should not be used	egulation to be sure	e this primer is compliant.  De considered representative n purposes.
Properties and Performance	Note: The following or typical only  Solids: Color:	technical information ar and should not be used  Approximately 6  Clear light yellow	nd data should l for specifications w – clear dark or	e this primer is compliant.  De considered representative n purposes.
Properties and Performance	Note: The following or typical only  Solids: Color: Flashpoint:	technical information ar and should not be used  Approximately 6 Clear light yellov -4°F (-20°C) O.C	nd data should lagrange for specification with a clear dark or clear dar	e this primer is compliant.  De considered representative purposes.  Tange
Properties and	Note: The following or typical only  Solids: Color:	technical information ar and should not be used  Approximately 6  Clear light yellow	nd data should I for specification  w – clear dark or clea	e this primer is compliant.  De considered representative purposes.  Tange

# **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 isopropyl alcohol. Vigorous scrubbing may be required.

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

# 3M<sup>™</sup> Tape Primer

94

#### **Shelf Life**

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

- Keep 3M<sup>TM</sup> 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**

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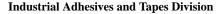
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ISO 9001:2000

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001:2000 standards.





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