



Adhesion Promoter 06396

For Plastic Trim Attachment

Technical Data Sheet

July 2002

Supersedes Technical Data Sheet dated November 1997

General Description

3M™ Adhesion Promoter 06396 is a liquid primer used to improve the adhesion of 3M™ Automotive Attachment Tapes to most low surface energy plastic materials as well as injection- molded body side moldings and claddings used for automotive exterior trims. This would include common low surface energy plastics used for automotive interior and exterior trim applications (TPO, PPO, PP, PC, PC + ABS, etc.). Since formulations and surface energies can vary for these types of materials, each application should be verified through testing. 3M adhesion promoter 06396 is specifically formulated to be used on plastic parts with 3M™ Acrylic Foam Tapes and 3M™ Acrylic *Plus* Tapes (3M part numbers 06377, 06378, 06380, 06381, 06382, 06383, 06384, 06385, 06386 and 06397) for automotive applications.

Physical Properties

Components	Cyclohexane, xylene, ethyl alcohol, ethylbenzene, ethyl acetate, acrylic polymer, chlorinated polyolefins, isopropyl alcohol
	Contains less than 0.5% of the following: bisphenol a-epichlorohydrin copolymer, methyl alcohol, chlorobenzene

Solids	Approximately 5%
Color	Straw
Viscosity	25 Centipose maximum
Flashpoint	-4°F (-20°C)
Drying Time	30-90 seconds
Density	3.1 kg (6.8 lb) per gallon
Availability	Sponge applicator packet - 2.5 cc
Coverage	Approximately 150 in ² per sponge applicator packet

Safety Procedures

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. If necessary, the 3M 24-hour emergency response telephone number is 1-800-364-3577 or 651-737-6501.

Shelf Life

Shelf life is one year from date of receipt by customer when stored in the original container at 15°C - 27°C (60°F - 80°F). Storage at lower temperatures for short periods will not affect product performance if the primer is warmed to room temperature 22°C (72°F) before application.

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Surface Preparation The bonding surface should be clean and dry. Contaminated surfaces should be cleaned with an untreated, lint-free cloth and 3M™ General Purpose Adhesive Cleaner (Part No. 08984) or 3M™ Prep Solvent 70 Low VOC Cleaner (Part No. 08973). Follow this by wiping with another untreated, lint-free cloth and isopropyl alcohol. Observe precautions for solvent handling.

Application Procedure 3M™ Adhesion Promoter 06396 is supplied in an easy-to-use sponge applicator packet. The liquid contents of the packet should be completely used as soon as possible after opening. Hold packet upright and avoid squeezing an opened packet to prevent spillage of liquid contents. The packet can be opened by tearing across the top of the packet at the notches. This will expose the sponge applicator. *Do not remove the sponge or squeeze a freshly opened packet.* Handling the bottom section of the packet should enable application of 3M adhesion promoter 06396 with no mess.

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. Although drying times may vary due to temperature and/or humidity, a drying time of 30-90 seconds results with a coating of this thickness. The primer should be dry before applying tape. For best results, apply tape immediately after primer application or no more than one hour after primer application. Be sure the primer surface remains free from contaminants prior to tape application.

Clean Up 3M adhesion promoter 06396 can be cleaned up with methylethyl ketone (MEK) or acetone solvents (be careful with solvents on plastics). Vigorous scrubbing may be required. To prevent cosmetic damage to visible surfaces, be sure to apply the promoter or any solvents only to areas that will be fully covered by the part.

Caution: When using solvents for cleanup, use the precautionary measures recommended in the MSDS for the solvent.

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