



Adhesion Promoter 4296T

Technical Data Sheet

December 2001

Supersedes data sheet dated January 1996

General Description	3M™ Adhesion Promoter 4296T is a liquid primer for flexible high solids paints and raw RIM. It is specifically formulated to be used with 3M™ Acrylic Foam Tapes for automotive applications.	
Physical Properties	Components	Alkyd resin, nitrocellulose resin, methyl isobutyl ketone, toluene, n-butyl acetate, ethyl alcohol, phosphoric acid, xylene.
	Solids	Approximately 13%
	Color	Straw
	Viscosity	Less than 100 cps.
	Flashpoint	6.5°C (44°F)
	Drying Time	45-75 Seconds
	Coverage	75 m ² (800 ft ²) per gallon (Based on 0.002 inch wet coating thickness)
	Net Weight	3.3 kg (7.2 lbs.) per gallon
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.	
Equipment	3M adhesion promoter 4296T can be applied with a pressurized flow gun, knurled roller 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.	
Shelf Life	One year from date of receipt by customer when stored in the original container at 15-27°C (60-80°F). Storage at lower temperatures for short periods will not affect product performance if the primer is warmed to room temperature before application.	
Surface Preparation	The bonding surface must be relatively clean and dry. Contaminated surfaces should be cleaned with an untreated, lint-free cloth and a ketone or alcohol solvent. Observe proper precautions for solvent handling.	

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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. Although drying times may vary due to temperature or humidity, a drying time of about 60 seconds is indicative of this thickness. Allow to dry thoroughly before applying tape. For best results, apply tape within one hour after application of primer. Be sure the primed surface remains free from contaminants prior to laminating the tape.

Clean-Up

3M™ Adhesion Promoter 4296T can be removed with acetone solvent. Vigorous scrubbing may be required.

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