

3M™ Adhesion Promoter 4296T

Technical Data Sheet



Description

3M™ Adhesion Promoter 4296T is a liquid adhesion promoter for flexible, high solids paints and raw RIM (like TPU). 3M Adhesion Promoter 4296T is specifically formulated to be used with 3M™ Acrylic Foam and Acrylic *Plus* Tapes for automotive applications. Because substrate formulations and surface energies may vary for these materials, each application should be tested for compatibility.

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

Equipment

3M adhesion promoter 4296T can be applied by a gravity feed wipe, knurled roller, and felt-tipped applicator or other similar type applicator. Applicator heads should be cleaned or replaced regularly.

Surface Preparation

The bonding surface should be clean and dry. Contaminated surfaces should be cleaned with an appropriate solvent* such as isopropyl alcohol. Observe precautions for solvent handling.

Application

Shake well before using. Apply a thin, uniform coating of the 3M™ Adhesion Promoter 4296T to the bonding surface, using the minimum amount that will fully coat the surface. A wet coating thickness of approximately 0.002 inch (0.05 mm) or less is recommended. Although drying times may vary due to temperature or humidity, a drying time of about 60 seconds is typical 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 cleaned up with acetone solvents*. Vigorous scrubbing may be required.

***Note:** When using solvents for cleanup, use the precautionary measures recommended in the SDS and/or label for the solvent.

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 adhesion promoter is warmed to room temperature before application.

Regulatory Information

Observe proper handling precautions as outlined in the Safety Data Sheet (SDS), which is available on request. The website address for 3M SDSs is http://www.3m.com/3M/en_US/company-us/SDS-search/.

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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