Adhesion Promoter 111

Product Data Sheet

April, 2008
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Product Description

3M™ Adhesion Promoter 111 is an isopropyl alcohol based solution used to promote better and faster adhesion of 3M™ VHB™ Tapes to various surfaces including bare metals, galvanized steel, and painted surfaces. Since surfaces and paint formulations vary considerably, each application should be verified through testing.

Key Features

- Higher bond strength.
- Increased tape adhesion build rate at both normal and cooler temperatures.
- Isopropyl alcohol based solvent system.
- Non-offensive odor.
- Very quick drying.
- Can clean and promote adhesion in one step provided the surface is relatively clean and free of wax, grease, oil, and loose particles.

Physical Properties

Solvent	Isopropyl alcohol (IPA)
Active Ingredients	Less than 5% by weight
VOC's	780 g/l
Color:	clear
Flashpoint:	11℃ (52℉)
Coverage:	Approximately 19 sqm/l based on 0,050 mm wet coating thickness. Can vary greatly depending on method of application.
Drying Time	Approximately 1 minute depending on coating thickness, temperature, and humidity.

Application Instructions

Surface must be clean, dry, and free of wax, oil, grease and loose particles.

Substrate must be unified.

Contaminated surfaces must be cleaned with an appropriate cleaner and/or a 50/50 mixture of isopropyl alcohol and water.*

Apply a thin, uniform coating to the bonding surface before application of 3M™ VHB™ Tape. Use the minimum amount that will fully coat the area to be taped.

Application may be done with a clean lint-free cloth, pad, felt tipped dauber, absorbent paper towel or disposable tissue. Brushes, rollers, or spraying tend to apply excessive amounts of 3M™ Adhesion Promoter 111 and should therefore be avoided.

Allow to dry completely prior to application of tape. Depending on temperature and humidity, the drying and reacting time of 3M Adhesion Promoter 111 can vary.
Typical drying time will be 1-2 minutes.

	Forced, hot air drying of 3M Adhesion Promoter 111 is acceptable, but remember that 3M Adhesion Promoter 111 is flammable and must not be used near any open flames or ignition sources. Apply tape within 8 hours, or reapply 3M Adhesion Promoter 111. REPLACE CAP WHEN NOT IN USE. 3M Adhesion Promoter 111 is reactive with water including moisture (humidity) in air. *When using solvents, extinguish all ignition sources, including pilot lights, and follow the manufacturer's precautions and directions for use.
Cleanup	3M™ Adhesion Promoter 111 can be removed from unwanted surfaces with straight isopropyl alcohol (IPA) or a blend of IPA and water. Rubbing Alcohol is typically 70% IPA and 30% water.* Excessive 3M Adhesion Promoter 111 may cause a dull white appearance on the surface. A small amount of chalking should not adversely affect the adhesive strength. If desired, for appearance purposes, the dull white chalking may be removed after tape application with either a clean dry cloth or a clean cloth that is slightly wet with isopropyl alcohol. Before tape application, the dull white chalking may be removed with a clean cloth that is only slightly wet with more 3M Adhesion Promoter 111. *When using solvents, extinguish all ignition sources, including pilot lights, and follow the manufacturer's precautions and directions for use.
Storage	3M Adhesion Promoter 111 will tolerate storage and shipment temperatures from -40℃ (-40℉) to 66℃ (150℉), but needs to be at a minimum of 10℃ (50℉) when applied. Do not store in plastic container for more than 8 hours. Many plastics do not provide an adequate vapor barrier to prevent loss of liquid.
Shelf Life	One year from date of shipment. Once opened, it is best to use within one month. Shelf life may be decreased, especially if open or poorly resealed container is continuously exposed to hot or humid environments. Properly dispose of any 3M Adhesion Promoter 111 that is either cloudy or has white precipitate on the bottom of the container.
Precautionary Information	Refer to product label and Material Safety Data Sheet for health and safety information before using the product. For information please contact your local 3M Office. www.3M.com
For Additional Information	To request additional product information or to arrange for sales assistance, call 0870 6080050 Address correspondence to: 3M United Kingdom PLC, 3M House, 28 Great Jackson Street, Manchester, M15 4PA

Important Notice	All statements, technical information and recommendations contained in this document are based upon tests or experience that 3M believes are reliable. However, many factors beyond 3M's control can affect the use and performance of a 3M product in a particular application, including the conditions under which the product is used and the time and environmental conditions in which the product is expected to perform. Since these factors are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for the user's method or application. All questions of liability relating to this product are governed by the terms of the sale subject, where applicable, to the prevailing law

Values presented have been determined by standard test methods and are average values not to be used for specification purposes. Our recommendations on the use of our products are based on tests believed to be reliable but we would ask that you conduct your own tests to determine their suitability for your applications.
This is because 3M cannot accept any responsibility or liability direct or consequential for loss or damage caused as a result of our recommendations

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