



Technical Data Sheet

3M™ Metal Primer 3901



[Product Details](#)



[Regulatory Info/SDS](#)

Product Description

3M™ Scotch-Weld™ Metal Primer 3901 is a primer for 3M™ Scotch-Weld™ film and liquid adhesives in those applications where it is desired to obtain improved metal and glass adhesion or improved resistance to environmental exposure with epoxy and urethane adhesives.

Product Features

- Ensures complete wetting of film adhesive to adherend surfaces.
- Simplifies production scheduling by protecting the cleaned surfaces until the bonding operations can be completed.
- Imparts improved corrosion protection to metal.

Technical Information Note

The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

Typical Uncured Physical Properties

Attribute Name	Temperature	Value
Color		Red ¹
Base		Synthetic Resin
Viscosity	27 °C (80 °F)	5 ± 2 cP ²
Net Weight		6.5 ± 0.2 lb/gal

¹ Colors may vary from nearly white to yellow/amber. Adhesive performance is not affected by color variation.

² Brookfield, RVF, No. 1 spindle, 20 rpm

Typical Physical Properties

Attribute Name	Value
Solvent Resistance	Methyl Alcohol (Contains non-photochemically reactive solvent. Consult local air quality regulations which may regulate product use.)
Flash Point	16 °C (60 °F) ¹

¹ Closed Cup

Typical Performance Characteristics

Overlap Shear Strength

Temperature	Substrate	Value
22 °C (72 °F)	Titanium	5,280 lb/in ²
22 °C (72 °F)	Stainless Steel	6,310 lb/in ²
-55 °C (-67 °F)	Titanium	6,380 lb/in ²
-55 °C (-67 °F)	Stainless Steel	10,203 lb/in ²
82 °C (180 °F)	Titanium	3,650 lb/in ²
82 °C (180 °F)	Stainless Steel	3,600 lb/in ²

Handling/Application Information

Surface Preparation

Suggested Cleaning Procedure for Aluminum

1. Alkaline Degrease - Oakite 164 solution (9-11 oz./gallon water) at 190°F ± 10°F (88°C ± 5°C) for 10-20 minutes. Rinse immediately in large quantities of cold running water.
2. Optimized FPL Etch Solution (1 liter):

Material Amount

Distilled Water 700 ml plus balance of liter (see below)

Sodium Dichromate 28 to 67.3 grams

Sulfuric Acid 2 87.9 to 310.0 grams

Aluminum Chips 1.5 grams/liter of mixed solution

To prepare 1 liter of this solution, dissolve Sodium Dichromate in 700 ml of distilled water. Add sulfuric acid and mix well. Add additional distilled water to fill to 1 liter. Heat mixed solution to 66 to 71°C (150 to 160°F). Dissolve 1.5 grams of 2024 bare aluminum chips per liter of mixed solution. Gentle agitation will help aluminum dissolve in about 24 hours.

Place panels in FPL etch solution for 10 minutes at 155 ± 5°F (68 ± 2°C) for 12 to 15 minutes.

3. Rinse - Rinse panels in clear running water.
4. Dry - Air dry 15 minutes, force dry 10 minutes at 140°F (60°C) maximum.

Note: It is advisable to coat the freshly-cleaned surfaces with 3M™ Scotch-Weld™ Metal Primer 3901 within four (4) hours after surface preparation.

Care should be taken to avoid contaminating the cleaned aluminum by any substance which will hinder the wetting action of Scotch-Weld 3901.

Review and follow safety and precautionary recommendations from chemical supplier prior to preparing this etch solution.

Primer Application:

Scotch-Weld 3901 has been successfully applied by spraying and brushing. The following spray equipment is suggested to obtain optimum results:

Spray Gun DeVilbiss JGA

Air Cap No. 78

Needle-Nozzle AV-15-FX

Line Pressure 60-80 psi (4.1-5.5 bar)

Pot Pressure 1-2 psi (.07-.14 bar)

Distance from Panel 14 ± 3 inches (36 ± 8 cm)

Primer Thickness (dry) Less than .0001 inch (2.5 micron)

(**Note:** Only a micro-molecular layer of primer is required.)

Primer Dry:

The following dry cycle is suggested for 3M™ Scotch-Weld™ Metal Primer 3901:

Air Dry: Air dry at 75-85°F (24-33°C) for a minimum of one hour.

Force Dry: Circulating air oven 190°F (88°C) for 30 minutes.

Air dry cycles for periods as short as 1/2 hour have been used successfully with the force dry cycle. Humidity contributes greatly to satisfactory use of this primer. Relative humidity of 25% or lower may cause difficulties and should be thoroughly evaluated in the customer's application.

The primed surface, after cooling to ambient temperatures, is ready for adhesive bonding. The primed surface should be protected from contamination introduced by dust, fingerprints, oil, etc. Bonding should be completed within 7 days.

Primer Cleanup:

Excess primer and equipment may be cleaned up with ketone-type solvents.*

***Note:** When using solvents, extinguish all ignition sources, and follow the manufacturer's precautions and directions for use.

Application Techniques

A thoroughly cleaned, dry, grease-free surface is essential for maximum performance. Cleaning methods which will produce a break-free water film on metal surfaces are generally satisfactory. Surface preparations should be fully evaluated with the adhesive, especially if resistance to specific environments are anticipated.

Storage and Shelf Life

Store product at 60-80°F (16-27°C) for maximum storage life. Higher temperatures reduce normal storage life.

This product has a shelf life of 18 months from the date of manufacture when stored in the unopened original container at room temperature.

Precautionary Information

Refer to Product Label and Material Safety Data Sheet for health and safety information before using this product. For additional health and safety information, call 1-800-364-3577 or (651) 737-6501.

Automotive Disclaimer

Select Automotive Applications: This product is an industrial product and has not been designed or tested for use in certain automotive applications, such as automotive electric powertrain battery or high voltage applications, which may require the product to be manufactured in a IATF certified facility, meet a Ppk of 1.33 for all properties, undergo an automotive production part approval process (PPAP), or fully adhere to automotive design or quality system requirements (e.g., IATF 16949 or VDA 6.3). Customer assumes all responsibility and risk if customer chooses to use this product in these applications.

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ISO Statement

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