

# 3M™ Adhesion Promoter K500

## Technical Data Sheet

### Description

3M™ Adhesion Promoter K-500 is a liquid adhesion promoter used for most EPDM, polypropylene, chlorinated rubbers, ABS, AES compounds and certain PET/PBT blends. 3M Adhesion Promoter K-500 is a moisture cured system that is specifically formulated to be used with 3M™ Acrylic Foam and Acrylic *Plus* Tapes for automotive applications. Because substrate formulations and surface energies for these materials may vary, each application should be tested for compatibility.

### Physical Properties

<b>Components</b>	Toluene; chlorinated polypropylene; isocyanic acid, methylene di-p-phenylene ester; isocyanic acid, poly-methylene polyphenylene ester; molecular sieves
<b>Solids</b>	Approximately 8%
<b>Color</b>	Straw
<b>Flashpoint</b>	4.4°C (40° F)
<b>Coverage</b>	75 m <sup>2</sup> (800 ft <sup>2</sup> ) per gallon (Based on 0.002 inch wet coating thickness)
<b>Net Weight</b>	880 grams per liter

### Equipment

3M adhesion promoter K-500 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 K500 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 this is usually accomplished in less than one minute, allowing 10 minutes yields the ultimate adhesion. For best results apply tape within 30 minutes after application of adhesion promoter. Be sure the primed surface remains free from contaminants prior to laminating the tape.

### Clean-Up

3M Adhesion Promoter K500 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

Shelf life is 2 years from date of manufacturing when stored in the original container. Transfer only small amounts for 8 to 12 hours of production into other vessels. Return the original tightly sealed container to storage to avoid moisture contamination. Although room temperature storage is acceptable, refrigerated storage at 1.7° to 7.2° C (35° to 45° F) is recommended.

## 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/](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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