



Technical Data

Tape Primer 94

Product Description

3M™ Tape Primer 94 can be used to promote adhesion of 3M tapes to surfaces such as polyethylene, polypropylene, ABS, PET/PBT blends, concrete, wood, glass, metal and painted metal surfaces.

Low VOC Alternates

	g/l VOC	Substrates
3M™ Scotch-Weld™ Plastic Adhesive 2262 Thin 5 or 10 to 1 in acetone	196	Powder Paints
3M™ Scotch-Weld™ Plastic Adhesive 1099 Unthinned		Neoprene, Santoprene, EPDM

Note: 3M primer 94 contains greater than 250 g/l of volatile organic carbons (VOC). Less water, less exempt solvents. Please contact your local Air Quality Regulation to be sure this primer is compliant.

Typical Physical Properties and Performance Characteristics

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

Solids:	Approximately 6%
Colour:	Clear light yellow – clear dark orange
Flashpoint:	-20°C (-4°F) O.C.
Coverage:	14.7 sq. m/l (600 sq. ft.) per gallon
Net Weight:	820 grams per liter
Viscosity:	Typical range is 1-10 cps (35 cps maximum)

Application Techniques

Surface Preparation: The bonding surface must be relatively clean and dry. Contaminated surfaces should be cleaned with a 50/50 isopropyl alcohol and water mixture. A clean lint-free, cloth should be used.

Application: Shake 3M™ Primer 94 well before using. Apply a thin uniform coating to the bonding surface using the minimum amount that will fully coat the surface. Allow 3M™ Primer 94 to dry thoroughly before applying tape. This is usually accomplished in 5 minutes at room temperature. Be sure the primed surface remains free from contaminants prior to applying the tape. Porous surfaces may require 2 applications of 3M™ Primer 94 for uniform coverage and good adhesion. Allow first application of primer to dry before applying the second coat. 3M™ Primer 94 may be applied with brush or swab. It can also be applied with a pressurized flow gun, knurled roller or other similar type of application equipment.

Clean up: 3M™ Primer 94 can be removed with acetone. Vigorous scrubbing may be required. Test in small area to insure acetone will not affect the substrate surface.

Note: Carefully read and follow manufacturer's precautions and directions for use when handling cleaning solvents.

Shelf Life

18 months from date of manufacture when stored in the original container at 15°C-27°C (60°F-80°F).

- Keep 3M™ Tape Primer 94 in the original container.
- Transfer only a small amount into a work vessel for use.
- Keep original container tightly sealed to avoid solvent evaporation.

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ISO 9001 This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001 standards.



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