



Adhesion Promoter 4298UV

General Description 3M™ Adhesion Promoter 4298UV is a liquid primer used to improve the adhesion of 3M acrylic foam tapes to low surface energy plastics such as thermoplastic olefins (TPO), thermoplastic urethanes (TPU), and polypropylene. A fluorescent dye has been added so that the primer coverage can be verified. Since formulations and surface energies vary for these materials, each application should be verified through testing. 4298UV is specifically formulated to be used with 3M Acrylic Foam Tapes for automotive applications.

Physical Properties **4298UV**

Components	Cyclohexane, xylene, ethyl alcohol, ethylbenzene, ethyl acetate, acrylic polymer, chlorinated polyolefins, isopropyl alcohol. Contains less than 0.5% of the following: bisphenol a-epichlorohydrin copolymer, methyl alcohol, chlorobenzene
Solids	Approximately 5%
Color	Straw
Viscosity	5-40 Centipoise
Flashpoint	-4°F (-20°C)
Drying Time	30-90 Seconds
Coverage	800 ft ² (75 m ²) per gallon (Based on 0.002" wet coating thickness)
Net Weight	6.8 lb/gal (820 g/l)

Application Procedure OBSERVE PROPER HANDLING PRECAUTIONS AS OUTLINED IN THE MATERIAL SAFETY DATA SHEET. MSDS'S ARE AVAILABLE ON REQUEST. IF NECESSARY, THE 3M 24-HOUR EMERGENCY RESPONSE TELEPHONE NUMBER IS: 1-800-733-1110, OPERATOR 55.

Equipment 3M Adhesion Promoter 4298UV can be applied by a gravity feed wipe, knurled roller, sprayer and felt tipped applicator or other similar type applicator. Applicator heads should be cleaned or replaced regularly. A convenient application system is available through your Automotive Engineered Systems Division representative.

Surface Preparation	The bonding surface should be clean and dry. Contaminated surfaces should be cleaned with an untreated, lint-free cloth and an appropriate solvent (typically isopropyl alcohol). Observe proper precautions for solvent handling.
Application	Shake well before using. Apply thin, uniform coating to the bonding surface, using the minimum amount that will fully coat the surface. A wet coating thickness of 0.002 inch or less ensures a good application. Although drying times may vary due to temperature and/or humidity, a drying time of 30-90 seconds is indicative of this thickness. The primer should be dry before applying the tape. For best results, apply tape within 1 hour after primer application. Be sure the primer surface remains free from contaminants prior to laminating the tape.
Clean-Up	3M Adhesion Promoter 4298UV can be cleaned up with methylethyl ketone (MEK) or acetone solvents. Vigorous scrubbing may be required.
Shelf Life	One year from date of receipt by customer when stored in the original container at 60-80°F (15-27°C). Storage at lower temperatures for short periods will not affect product performance if the primer is warmed to room temperature before application.

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