



# Automotive Technical Datasheet

## 3M™ Adhesion Promoter

### 4299

#### Description

3M™ Adhesion Promoter 4299 is suitable for the use on glass surfaces in order to get an optimal bond between glass and Acrylic Foam Tapes. The adhesion promoter provides an excellent humidity resistance.

#### Features

3M™ Adhesion Promoter 4299 keeps its full performance in a wide area of coating weights. The adhesion promoter is very user-friendly because the solvent consists of 98% ethanol. If the Adhesion Promoter is coated beyond the edges of the adhesive tape it will not be visible after drying.

Properties	
Base	Methoxysilane
Solvent	98% Ethanol
Colour	Transparent
Density	0.8 g/cm <sup>3</sup>
Viscosity	comparable to water
Recommended surface	glass

#### Typical Adhesion Values

(in combination with Acrylic Foam Tape 4205; separation speed = 300 mm/min)

Test	Result
90° adhesion on glass 20 min RT	45 N/cm (pop off glass)
90° adhesion on glass 3 days RT	80 N/cm (foam split)
90° adhesion on glass 3 days RT + 3 days water 70°C + 1 hour water 23°C	42 N/cm (foam split)



## Handling Instructions 3M™ Adhesion Promoter 4299

### Surface Preparation

The surface must be clean which means dry, free of dust, oil and other impurities. We recommend cleaning the glass surface with Isopropanol / water (1:1).

### Application

The Adhesion Promoter can be applied with the usual methods. Application by hand using a tissue is especially recommended.

The recommended coating weight of the adhesion promoter is in a range of 0.2 – 1 g/m<sup>2</sup>. (Wipe ON/Off is possible.)

### Drying time

As soon as the solvent has evaporated, the glass surface is ready for bonding. At room temperature the drying time is 1-2 minutes. Provided that the glass surface will not be contaminated bonding can be made up to 8 hours after the application. After more than 8 hours the adhesion promoter must be re-applied. Removal of the first layer is necessary.

### Storage and Handling

The Adhesion Promoter can be stored in the sealed original cans at temperatures below 30°C.

It shall be used within one year after its filling date, please refer to the “best before” date on the can’s label.

After the end of that period the customer must test the primer’s functionality in case he intends to use it still.

As humidity influences the effectiveness of the adhesion promoter it must be stored under dry conditions. The can it must be closed immediately and thoroughly after use.

Impurities must be kept out of the solution.

Under recommended condition the adhesion promoter will keep its full performance in already opened cans for several weeks.

### Safety Instructions

See material safety data sheet

### Important notice to purchaser

All statements, technical information and recommendations herein are based on tests we believe to be reliable, but the accuracy or completeness there of is not guaranteed. Please ensure before using our product that it is suitable for your intended use. All questions of liability relating to this product are governed by the Terms of Sale subject, where applicable, to the prevailing law.



3M Deutschland GmbH  
**AASD Laboratory**  
Carl-Schurz-Strasse-1  
D-41453 Neuss  
Tel. (+49)-2131-14-3291  
Fax: (+49)-2131-14-12-3291

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