



# Adhesion Promoter 4298

## For Professional Market Applications

Technical Data Sheet

March 2003

Supersedes Technical Data Sheet dated December 2001

### General Description

3M™ Adhesion Promoter 4298 is a liquid primer used for most low surface energy plastics. This would include common low surface energy plastics used for automotive dash and interior trim applications (TPO, PPO, PP, PC, PC + ABS, etc.). Since formulations and surface energies can vary for these types of materials, each application should be verified through testing. 3M adhesion promoter 4298 is specifically formulated to be used with 3M™ Acrylic Foam Tapes for automotive applications.

### Physical Properties

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	25 Centipose maximum
Flashpoint	-20°C (-4°F)
Drying Time	30-90 seconds
Net Weight	3.1 kg (6.8 lbs.) per gallon
Availability	Sponge applicator packet - 2.5 cc
Coverage	Approximately 150 in <sup>2</sup> per sponge applicator packet

### Safety Procedures

Observe proper handling precautions as outlined in the material safety data sheet (MSDS). MSDSs are available on request. If necessary, the 3M 24-hour emergency response telephone number is 1-800-364-3577 or 651-737-6501.

### Shelf Life

Shelf life is one year from date of receipt by customer when stored in the original container at 4°C - 38°C (40°F - 100°F) and 0 - 95% relative humidity. Storage at lower temperatures for short periods will not affect product performance if the primer is warmed to recommended temperatures before application.

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**Surface Preparation** The bonding surface should be clean and dry. Contaminated surfaces should be cleaned with an untreated, lint-free cloth and 3M™ General Purpose Adhesive Cleaner (Part No. 08984) or 3M™ Prep Solvent 70 Low VOC Cleaner (Part No. 08973). Follow this by wiping with another untreated, lint-free cloth and isopropyl alcohol. Observe precautions for solvent handling.

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**Application Procedure** 3M™ Adhesion Promoter 4298 is supplied in an easy-to-use sponge applicator packet. The liquid contents of the packet should be completely used as soon as possible after opening. Hold packet upright and avoid squeezing an opened packet to prevent spillage of liquid contents. The packet can be opened by tearing across the top of the packet at the notches. This will expose the sponge applicator. *Do not remove the sponge or squeeze a freshly opened packet.* Handling the bottom section of the packet should enable application of 3M adhesion promoter 4298 with no mess.

Apply a 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 is recommended. Apply promoter only to areas that will be fully covered with tape. Although drying times may vary due to temperature and/or humidity, a drying time of 30-90 seconds is typically indicative of this thickness. The primer should be dry before applying tape. For best results, apply tape immediately after primer application or no more than one hour after primer application. Be sure the primed surface remains free from contaminants prior to tape application.

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**Clean-Up** 3M adhesion promoter 4298 can be cleaned up with methylethyl ketone (MEK) or acetone solvents (be careful with solvents on plastics). Vigorous scrubbing may be required.

**Caution:** When using solvents for cleanup, use the precautionary measures recommended in the MSDS and/or label for the solvent.

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