

# 3M™ Adhesion Promoter K540NTUV

## Technical Data Sheet



### Description

3M™ Adhesion Promoter K540NTUV is a liquid adhesion promoter used to improve the adhesion of 3M™ Acrylic Foam and Acrylic *Plus* Tapes to low surface energy plastics such as thermoplastic olefins (TPO), EPDM, and polypropylene. A fluorescent dye has been added so that adhesion promoter coverage can be verified. 3M Adhesion Promoter K540NTUV is specifically formulated to be used with 3M Acrylic Foam and Acrylic *Plus* tapes for automotive applications. Because substrate formulations and surface energies may vary, each application should be tested for compatibility.

### Physical Properties

<b>Color</b>	Straw
<b>Solid Material</b>	Synthetic Resin
<b>Solvent Material</b>	Methylcyclohexane and N-Butyl acetate
<b>Solid</b>	Approximately 3%

### Equipment

3M adhesion promoter K540NTUV 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 K540NTUV 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 drying times may vary due to temperature and/or humidity, a drying time of 10 minutes to 3 hours is typical of this thickness. The adhesion promoter should be dry before applying the tape. For best results, apply tape within one hour after applying adhesion promoter. Be sure the primer surface remains free from contaminants prior to laminating the tape.

### Clean-Up

3M Adhesion Promoter K540NTUV 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 one year from the date of shipment when stored in the original container at 4°C – 38°C (40°F – 100°F), 0-95% relative humidity, and away from light sources. Storage at lower temperatures for short periods will not affect product performance if the primer is warmed to recommended temperatures before application.

## 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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