



# Adhesion Promoter/Primer

3M<sup>TM</sup> Adhesion Promoter AP596

3M<sup>TM</sup> All Purpose Primer P591

3M<sup>TM</sup> Metal Primer P592

Technical Data

April 2018

## Product Description

3M<sup>TM</sup> Adhesion Promoter AP596 and 3M<sup>TM</sup> Primers P591, P592 are low viscosity adhesion promoters recommended for use with the 3M<sup>TM</sup> 500-Series Polyurethane Adhesives/Sealants and 3M<sup>TM</sup> 700-Series SMP Adhesives/Sealants, as well as the 3M<sup>TM</sup> Polyurethane Glass Adhesive Sealant 590 and Polyurethane Window Bonder Adhesive Sealant 595. 3M Adhesion Promoters and Primers are applied to a wide variety of materials including glass, acrylic/PMMA, polycarbonate, and many other materials prior to the adhesive/sealant use to assist in bonding.

Technical Data  
representative

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

|                      | 3M <sup>TM</sup><br>Adhesion<br>Promoter<br>AP596 | 3M <sup>TM</sup> All<br>Purpose<br>Primer<br>P591 | 3M <sup>TM</sup><br>Metal<br>Primer<br>P592 |
|----------------------|---------------------------------------------------|---------------------------------------------------|---------------------------------------------|
| Color                | Clear                                             | Black                                             | Clear                                       |
| Viscosity            | Water Thin                                        |                                                   |                                             |
| Solids (%)           | 3                                                 | 36.5                                              | 1.5                                         |
| VOC (g/l)            | 798                                               | 613                                               | 790                                         |
| Active<br>Ingredient | Silane /<br>Ethanol                               | Isocyanate /<br>MEK                               | Silane /<br>Ethanol                         |

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• Adhesion Promoter AP596 • All Purpose Primer P591 • Metal Primer P592

## Performance Data

The following table shows the impact in terms of adhesion strength of bonding common window substrates with and without 3M™ Adhesion Promoter AP596 / 3M™ Primer. 3M™ Polyurethane Glass Adhesive Sealant 590 was used for this test unless noted.

Note: The following data represents the overlap shear results of a 17 mil bond line. All substrates were abraded and solvent wiped prior to bonding, then cured for 30 days. Actual values will vary, as the final bond strengths are dependent upon many variables such as substrate type, substrate uniformity, and environmental conditions. The following data should be considered representative or typical only and should not be used for specification purposes.

## Overlap Shear Data

| Substrate                  | Primer |      |      |       | Failure Mode | Max load at Failure psi/MPa |
|----------------------------|--------|------|------|-------|--------------|-----------------------------|
|                            | None   | P591 | P592 | AP596 |              |                             |
| Acrylic                    | X      |      |      |       | Adhesive     | 107/0.7                     |
| Acrylic                    |        | X    |      |       | Substrate    | 474/3.3                     |
| Acrylic                    |        |      |      | X     | Adhesive     | 36/.3                       |
| Polycarbonate              | X      |      |      |       | Adhesive     | 167/1.2                     |
| Polycarbonate              |        | X    |      |       | Substrate    | 1065/7.3                    |
| Polycarbonate              |        |      |      | X     | Mixed        | 767/5.3                     |
| Glass                      | X      |      |      |       | Adhesive     | 361/2.5                     |
| Glass                      |        | X    |      |       | Substrate    | 332/2.3                     |
| Glass                      |        |      |      | X     | Substrate    | 455/3.1                     |
| Aluminum                   | X      |      |      |       | Adhesive     | 72/.5                       |
| Aluminum                   |        | X    |      |       | Mixed        | 136/.9                      |
| Aluminum                   |        |      |      | X     | Adhesive     | 86/.6                       |
| Cold Rolled Steel          | X      |      |      |       | Adhesive     | 56/.4                       |
| Cold Rolled Steel          |        | X    |      |       | Mixed        | 179/1.2                     |
| Cold Rolled Steel          |        |      |      | X     | Adhesive     | 112/.8                      |
| Cold Rolled Steel w/3M 540 | X      |      |      |       | Adhesive     | 84/.5                       |
| Cold Rolled Steel w/3M 540 |        |      | X    |       | Cohesive     | 107/.7                      |
| Stainless Steel            | X      |      |      |       | Adhesive     | 100/.7                      |
| Stainless Steel            |        | X    |      |       | Cohesive     | 340/2.3                     |
| Stainless Steel            |        |      |      | X     | Adhesive     | 128/.9                      |
| Stainless Steel w/3M 540   | X      |      |      |       | Adhesive     | 96/.6                       |
| Stainless Steel w/3M 540   |        |      | X    |       | Cohesive     | 101/.7                      |

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Primer Selection Chart:

| Substrate Priming Suggestions        | 3M™ Adhesion Promoter AP596 | 3M™ All Purpose Primer P591 | 3M™ Metal Primer P592 |
|--------------------------------------|-----------------------------|-----------------------------|-----------------------|
| Tinted Glass                         | XX                          |                             |                       |
| Fritted Glass                        |                             | XX                          |                       |
| Steel, anodized aluminum, galvanized |                             | X                           | XX                    |
| Polycarbonate                        | XX                          |                             |                       |
| PVC                                  | X                           |                             |                       |
| PMMA                                 | XX                          | XX                          |                       |
| Polyester                            | XX                          | XX                          |                       |

X = Good

XX = Best Choice

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## Directions for Use

### Surface Preparation:

Surfaces to be sealed or bonded should be clean and dry. Surfaces should be free from grease, mold release, oil, water/condensation, and other contaminants that may affect the adhesion of the sealant. Abrading with 180 to 220 grit abrasive followed by a solvent wipe will improve the bond strength. Suitable solvents include 3M™ Adhesive Remover, methyl ethyl ketone (MEK), isopropyl alcohol (IPA) or acetone.\*

\*When using solvents, use in a well ventilated area. Extinguish all sources of ignition in the work area and observe product directions for use and precautionary measures.

Refer to product label and MSDS for further precautions. Always pre-test solvent to ensure it is compatible with substrates.

Local and federal air quality regulations may regulate or prohibit the use of these products or surface preparation and cleanup materials. Consult local and federal air quality regulations before using these products.

Note: Alcohol will interfere with the curing process of polyurethane and extra care must be taken when using alcohol as a cleaning solvent to prevent any contact with the sealant.

### Primer:

Use of a primer is an extra step and cost and will depend on substrates and the final end use. Using primer can improve the corrosion resistance of certain metals as well as improve the durability of the bond when exposed to high humidity conditions.

For most applications, high strength bonds on metal can be achieved without the use of a primer. Pre-testing for adhesion is suggested to determine if a primer is needed.

Use of a 2-step surface preparation is recommended for certain substrates. Surface prep consists of applying 3M™ Adhesion Promoter AP596 followed by the appropriate 3M™ Primer to both bonding surfaces prior to using adhesive sealant. In areas with VOC restrictions, it is imperative that bonding surfaces are clean of contaminants. It may be acceptable to bond certain substrates without primer if the bonding area is abraded with 3M™ Scotch-Brite™ abrasive to improve adhesion. Contact 3M for technical support.

Do not apply 3M™ Adhesion Promoter and Primer on frozen nor wet surfaces. Do not apply over silicone nor in the presence of curing silicone.

### Application:

#### Supplies:

- 3M Adhesive Sealant in cartridges or 600 ml sausage packs
- 3M AP596 Adhesion Promoter
- Appropriate 3M Primer matched to the substrate(s)
- Soft lint-free cloths for 3M AP596 Adhesion Promoter and/or 3M P591/P592 Primer application
- Wool dauber(s) for 3M Primer application

# 3M™ Adhesion Promoter/Primer

• Adhesion Promoter AP596 • All Purpose Primer P591 • Metal Primer P592

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## Directions for Use

(continued)

- Applicator gun
  - Nozzle(s)
  - Substrates
  - Personal protective gear (safety glasses, powder-free gloves, etc)
- Clean entire surface of substrates using a solvent or non-greasy cleaner.

Apply 3M™ Adhesion Promoter AP596 to both substrates: Pour 3M AP596 Adhesion Promoter onto a soft lint-free cloth folded in quarters. Wipe the bonding area, flipping the cloth at regular intervals to reveal a clean section. With a new clean folded cloth, wipe off the 3M AP596 Adhesion Promoter in the same manner, flipping the cloth at regular intervals to reveal a clean section. Wait 15 minutes to dry.

Apply appropriate 3M™ Primer to both substrates: Shake appropriate 3M Primer for 30 seconds after you hear the ball moving inside the bottle. Dip a clean wool dauber into the primer. Roll the dauber around the edge of the bottle to squeeze out excess primer. Replace cover on primer bottle. Apply a single continuous layer of primer to the surface. Wait 30 minutes to dry.

Refer to the Instructions for Use for the appropriate adhesive/sealant chosen and proceed accordingly.

Cleanup: Use a solvent such as MEK to clean up any excess primer.

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|--------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Application Equipment for 3M™ Primer | Wool dauber is recommended for applying 3M Primers. Use of a paint brush or other method of application is not recommended because there will be voids in the coating after application. Any voids will cause a defect in the coating and will affect bond quality. Contact your 3M Sales Representative for information on ordering Wool Daubers. |
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| Storage | 3M™ Adhesion Promoter AP596 and 3M™ Primers P591 and P592 must be stored in an appropriate climate controlled space suitable for flammable materials. Store the products in the original unopened containers below 77°F (25°C) to maximize shelf life. |
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| Shelf Life | When stored at recommended conditions, the shelf life is 12 months from the date of manufacture. After opening, the 3M AP596 Adhesion Promoter must be used within 30 days (if the product begins to turn cloudy, dispose of properly). After opening the 3M Primers P591 and P592, they must be used within 7 days (the viscosity will increase with each exposure to air). |
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• Adhesion Promoter AP596 • All Purpose Primer P591 • Metal Primer P592

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|------------------------------------------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
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