

Technical Data Sheet : Adhesive Promoting Primer (KAT-N09PMR)

Product Description:

KAT-N09PMR is a primer for promoting adhesion for double sided tape applications to the surfaces such polyethylene, polypropylene, ABS, PET/PBT blends, polyolefins (TPO, PP) or cured EPDM, concrete, wood, glass, metal and painted metal surfaces and other low surface energy substrates.

Features :

- Easy to apply
- Facile handling and drying
- Excellent bonding strength
- Promising heat resistance

Product Use:

Mixing – No agitation is required before or during use.

Applying – Apply primer by brush, spray or dip methods.

Drying/Curing – Allow primer to air-dry for 3 - 5 minutes at room temperature.

Physical Properties & Specifications:

Properties	Metric
Appearance	Light Yellow Liquid
Density (kg/m ³)	Hot Melt PS adhesive
Solids Content by Weight, %	3.00 - 5.00
Solvents	Toluene
Coverage:	600 sq. ft. (14.7 sq. m/l) per gallon
Net Weight:	820 grams per liter
Viscosity:	Typical range is 1-10 cps (35 cps maximum)

Shelf Life/Storage –

Shelf life is 1 year from date of production when stored in a well ventilated area at 25° C in original, unopened container.

- Keep Primer in the original container.
- Transfer only a small amount into a work vessel for use.
- Keep original container tightly sealed to avoid solvent evaporation.

Application Techniques:

Surface Preparation:- Remove grease, oil, fingerprints, dust, mold release agents, rust and other contaminants from the surface to be bonded. Wear chemical resistant gloves. Wipe the surface with a clean cloth soaked in a solvent such as, acetone, toluene, MEK or isopropyl alcohol.

Application:- Shake well before using. Apply a thin uniform coating to the bonding surface using the minimum amount that will fully coat the surface. Allow primer to dry thoroughly before applying tape. This is usually accomplished in 5 minutes at room temperature. Be sure the primed surface remains free from contaminants prior to applying the tape. Porous surfaces may require 2 applications of Primer for uniform coverage and good adhesion. Allow first application of primer to dry before applying the second coat. 3M Primer 94 may be applied with brush or swab. It can also be applied with a pressurized flow gun, knurled roller or other similar type of application equipment.

Clean up:- Primer can be removed with acetone. Vigorous scrubbing may be required. Test in small area to insure acetone will not affect the substrate surface.

Note : The above product recommendations are done in the best knowledge and experience we have at **Klebstoff**, however, we advice that the product has to be tested for a particular purpose and real time application by the customer before ordering. **Klebstoff**, holds the right to make any modifications/improvement in the product in the interest of better performance in the product.

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