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Technical Data Sheet 08681
08682

Public

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3M™ Single Step Primer

Data Sheet

3M Part No.(s)	3M Part Descriptor(s)
08681	125 ml Bottle - Approximately 25 Installations
08682	30 ml Bottle - Approximately 6 Installations

3M Fax on Demand Identification Number : 08681, 08682

Description



3M™ Single Step Primer is an integral component of the 3M Glass Urethane Bonding System and must be used with all 3M urethanes when installing auto glass. 3M™ Single Step Primer is a polyurethane based primer that promotes adhesion of the polyurethane adhesives to glass, primed pinchweld metal and PVC Encapsulated parts. It is also a black-out primer to block out the sun's ultraviolet rays. The 3M™ Single Step Primer should not be used after it has been opened and used for 7 days as moisture and other contaminants can render the primer ineffective. 3M™ Single Step Primer is available in two package sizes to provide a volume that will be used within this period of time dependant on your

business needs.

Features, Advantages, Benefits

Features	<ul style="list-style-type: none"> ● Promotes urethane adhesion to automotive glass, automotive paint primers, encapsulated (PVC) parts and pre-applied adhesive (PAAS) systems.. ● Protects urethane from harmful ultraviolet rays. ● Pinchweld touch-up primer for minor scratches to inhibit corrosion. ● Two package sizes.
Advantages	<ul style="list-style-type: none"> ● One Primer for the Glass, Pinchweld, Encapsulated parts and PAAS systems. ● Purchase package size to match your business needs.
Benefits	<ul style="list-style-type: none"> ● One step primer system. ● Economical. ● Easy to Use.

Typical Physical Properties

Container	Aluminum Bottles (125ml & 30ml)
Base	Polyurethane Resins
Density lbs/Gallon (Appx.)	1.0 g/ml
Color	Black
Flash Point - °F	25° F(-4° C) Closed Cup
Viscosity (CPS)	50 centipoise
Consistency	Liquid
Solvent	Methyl Ethyl Ketone
Drying Time	10 Minutes @70° F (21° C) 50 %RH

Product Uses

3M™ Single Step Primer: A black fast drying product, designed for the following applications and uses:

1. Priming automotive glass prior to bonding with 3M™ Autoglass Urethane Windshield Adhesives
2. To coat minor, bare metal scratches on the pinchweld to prevent corrosion.
3. Promoting urethane adhesion to PVC/Encapsulated parts.
4. Primer for PAAS windshield systems.

NOTE: 3M has not tested and does not recommend the product for any other use or application.

Performance Properties

Qualification Tests	Status
Initial 72 Hours at 72° F (22° C) and 50%RH	PASSED
10 day Water Immersion	PASSED
14 day Heat Age 190° F (87.8° C)	PASSED
14 day Humidity Age 100° F/100%RH (37.8° C)	PASSED
Cycle Testing	PASSED
2000 QUV	PASSED
Weatherometer 2000 Hour	PASSED

Two Year Florida Exposure	PASSED
Two Year Arizona Exposure	PASSED

Handling and Application Information

Directions for Use

These instructions describe the proper use of 3M™ Auto Glass Urethanes and related 3M glass shop products and are intended for use as a supplement to detailed service manuals and instructions provided by automotive manufacturers. Automobile manufacturers instructions should be followed when removing automotive trim and moldings as well as other special requirements pertaining to specific car models.

3M™ Single Step Primer Directions for Use:

1. Wear appropriate safety equipment, such as Nitrile rubber, Butyl rubber, chemical resistant gloves, safety glasses, apron or other protective equipment required by safety or company regulations.
2. Clean the windshield with 3M™ Glass Cleaner - Part No. 08888 and a clean lint free paper towel. Take care to thoroughly clean the surface where the urethane bond will be made.
3. **BEFORE EACH USE:** Verify that the primer and the urethane are within use by dates and the primer was not originally opened more than (7) days prior. Shake the container of 3M™ Single Step Primer - Part No. 08681/08682 well until agitator ball is moving freely, continuing to shake for at least 30 seconds. **Please Note:** If ball cannot be heard, discard, do not use! **CAUTION:** Do not use product beyond stated expiration date. Product may not perform as designed, which could result in bond failure.
4. Apply a uniform, continuous solid coating of 3M™ Single Step Primer - Part No. 08681/08682 over the bonding area using a wool dauber or other suitable clean unused applicator. Be careful not to spill on vehicle paint or interior surfaces.
5. Replace plastic insert and cap immediately.
6. Dispose of dauber in appropriate waste container.
7. Allow primer to dry for at least 10 minutes.
8. 3M™ Single Step Primer can be applied to fresh bare metal scratches on the pinchweld to help prevent corrosion. **Note:** When excessive abrasive cleaning is required, prime pinchweld metal with a 2 part epoxy automotive paint primer and allow to cure properly. Apply 3M™ Single Step Primer - Part No. 08681/08682 to repaired area and allow to dry for at least 10 minutes. **DO NOT APPLY TO FRESH CUT EXISTING URETHANE!**

Note: When bonding encapsulated parts, clean the plastic encapsulation or windshield trim with 3M™ General Purpose Adhesive Cleaner on a clean wipe. Abrade the plastic bonding area with 3M™ Scotch-Brite™ Multi-FLex Abrasive Sheet, Part Number 07521 followed by another solvent wipe. Allow to dry and then prime with 3M™ Single Step Primer.

* If 'Directions for Use' reference P.N.'s 08984, 08986, or 08987, please read. Federal and local air quality regulations may regulate or prohibit the use of surface preparation and cleanup solvents based on VOC content. Consult your local and Federal air quality regulations for information. When using solvents, use in a well ventilated area. Extinguish all sources of ignition in the work area and observe precautionary measures for handling these materials. Refer to product label and MSDS for P.N. 8984, 8986, or 8987 for detailed precautionary information.

Applications

3M™ Single Step Primer is a black-out primer and adhesion promoter used when bonding windshields, backlites, and other stationary glass components in vehicles with 3M™ Auto Glass Urethane Adhesives. It is used to coat small exposed bare metal minor scratches resulting from the glass removal process to help inhibit the initiation of corrosion and provide adhesion to PVC encapsulated glass parts.

Storage and Handling

Store between 40 - 80⁰ Fahrenheit. Rotate stock on a "first-in, first-out" basis. When stored at the recommended conditions in original, unopened containers, this product has a shelf life of 9 months.

Precautionary Information

Refer to Product Label and Material Safety Data Sheet for Health and Safety Information before using this product
MSDS Doc# - 16-5685-9 FCC G48 PSC A FCS 3

Country

US

This document is public. It may be distributed.

Warranty and Limited Remedy

This product will be free from defects in material and workmanship at the time of shipment. 3M MAKES NO OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE. User is responsible for determining whether the 3M product is fit for a particular purpose and suitable for user's application. If this product is defective, your exclusive remedy and 3M's and seller's sole obligation shall be, at 3M's option, to replace the product or refund the purchase price.

LIMITATION OF LIABILITY: 3M and seller will not be liable for any loss or damage arising from this 3M product, whether direct, indirect, special, incidental or consequential, regardless of the legal theory asserted, including warranty, contract, negligence or strict liability.

For Additional Health and Safety Information

3M Automotive Aftermarket Division

3M Center, Building 223-6N-01

Saint Paul, MN 55144-1000

1-877-666-2277 (1-877-MMM-CARS)

Material Safety Data Sheets and Technical Data Sheets are also available by calling Fax on Demand 1-800-305-0419.

Help Line 1-800-621-5455 (US) 1-650-596-4407 (International).

3M Fax on Demand/MSDS Identification Number 08681, 08682

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