English
Last Revision Date: May, 2022

Technical Data Sheet

3M™ Tape Primer 94

Product Description

3M™ Tape Primer 94 can be used to promote adhesion of 3M tapes to surfaces such polyethylene, polypropylene, ABS, PET/PBT blends, concrete, wood, glass, metal and painted metal surfaces.

Technical Information Note

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

Typical Physical Properties

Property	Values	Additional Information
Solids Content by Weight	6 %	
Color	Clear light yellow – clear dark orange	
Net Weight	820 g/L	
Flash Point	-20 °C	
Flash Point	-4 °F	
Coverage	14.7 m²/L	
Coverage	600 sq ft/gal	

Typical Uncured Physical Properties

Property	Values	Additional Information
Viscosity	Typical range is 1-10 cps (35 cps maximum) cP	

Low VOC Alternates

Storage and Shelf Life

When stored under proper conditions, product retains its performance and properties for 18 months from date of manufacture when stored in the original container at 60-80°F (15-27°C).

- Keep 3M™ Tape Primer 94 in the original container.
- Transfer only a small amount into a work vessel for use.
- Keep original container tightly sealed to avoid solvent evaporation.

Automotive Disclaimer

Select Automotive Applications: This product is an industrial product and has not been designed or tested for use in certain automotive applications, such as automotive electric powertrain battery or high voltage applications, which may require the product to be manufactured in a IATF certified facility, meet a Ppk of 1.33 for all properties, undergo an automotive production part approval process (PPAP), or fully adhere to automotive design or quality system requirements (e.g., IATF 16949 or VDA 6.3). Customer assumes all responsibility and risk if customer chooses to use this product in these applications.

Bottom Matter

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Trademarks

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Handling/Application Information

Application Techniques

Shake 3M Primer 94 well before using. Apply a thin uniform coating to the bonding surface using the minimum amount that will fully coat the surface. Allow 3M Primer 94 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 3M Primer 94 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: 3M Primer 94 can be removed with acetone. Vigorous scrubbing may be required. Test in small area to insure acetone will not affect the substrate surface.

Note: Carefully read and follow manufacturer's precautions and directions for use when handling cleaning solvents.

Surface Preparation

The bonding surface must be relatively clean and dry. Contaminated surfaces should be cleaned with a 50/50 Isopropyl Alcohol and water mixture. A clean lint-free cloth should be used.

References

Property	Values
3m.com Product Page	https://www.3m.com/3M/en_US/p/d/b40065491/
Safety Data Sheet SDS	https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&msdsLocale=en_US&co=ptn&q=94

Family Group

Link Tags:

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ISO Statement

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001 standards.

Information

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