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**Technical Data Sheet 08681**

**Public**

Rev:2

**Effective:** 03/03/2004

**Status:** Active

## 3M™ Single Step Primer

### Data Sheet

3M Part No.(s)	3M Part Descriptor(s)
08681	125 ml Bottle

**3M Fax on Demand Identification Number:** 08681

#### Description

3M™ Single Step Primer is an integral component of the 3M Glass Urethane Bonding System. 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.



#### Features, Advantages, Benefits

Features
<ul style="list-style-type: none"> <li>Promotes urethane adhesion to automotive glass and frit</li> </ul>

<b>Advantages</b>	<ul style="list-style-type: none"> <li>● Promotes urethane adhesion to automotive paint primers</li> <li>● Protects urethane from harmful ultraviolet rays</li> <li>● Promotes adhesion of urethane to encapsulated (PVC) parts</li> <li>● Pinchweld touch-up primer for minor scratch corrosion prevention</li> </ul>
	<ul style="list-style-type: none"> <li>● One primer for the Glass &amp; Pinchweld</li> <li>● Does not need an activator</li> </ul>
<b>Benefits</b>	<ul style="list-style-type: none"> <li>● One step primer system</li> <li>● Economical</li> <li>● Easy to use</li> <li>● Saves Time</li> </ul>

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### Typical Physical Properties

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

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### Product Uses

**3M™ Single Step Primer (Part No. 08681):** 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.

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

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### 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	ONGOING
2000 QUV	PASSED
Weatherometer 2000 Hour	ONGOING
Two Year Florida Exposure	ONGOING
Two Year Arizona Exposure	ONGOING

## Handling and Application Information

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### 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 (Part No. 08681):**

#### **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, cleaning from the outer edge to the center of the windshield. 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 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 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 container.
7. Allow primer to dry for at least 10 minutes.
8. 3M™ Single Step Primer - Part No. 08681 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 to repaired area and allow to dry for at least 10 minutes. **DO NOT APPLY TO FRESH CUT EXISTING URETHANE!**

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#### **Applications**

3M™ Single Step Primer - Part No. 08681 is a black-out primer and adhesion promoter. This product is used when bonding windshields, backlites, and other stationary glass components in vehicles with 3M™ Auto Glass Urethane Adhesives. It can also be used to coat small exposed bare metal minor scratches resulting from the glass removal process to help prevent corrosion. It is also an urethane adhesion promoter for PVC encapsulated glass parts.

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#### **Storage and Handling**

Store between 40 - 80° 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.

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#### **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

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## Country

**This document is public. It may be distributed.**

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### **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.**

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### **For Additional Health and Safety Information**

3M Automotive After Markets 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**

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