



Plastic Primer P591

Preliminary Product Data Sheet

November 2008
Supersedes: New

Product Description 3M Plastic Primer P591 is an Isocyanate- and solvent-based single step primer.

Key Features 3M Plastic Primer P591 for polyurethane sealants has been specially developed to get a good adhesion on PMMA, Polycarbonate and polyester. For other uses, refer to our technical service.

Typical Uncured Properties

Viscosity at 20 °C (Ford Cup Ø 4mm)	12 – 15 s
Density at 20 °C	0.95 ± 0.05
First setting at 20 °C	10 – 15 min
Conventional solids content (EN 827)	35 – 38 %
Colour	Black

Performance Characteristics

Application temperature	5 – 35 °C
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Instructions for Use

Substrates preparation :

The substrates to be coated must be clean, dry, dust free and not have any traces of grease or other contaminants that could adversely affect the bonding performance. If the substrates need to be cleaned, acetone or methylethylketone (MEK) may be used. Solvents must comply with local regulations. Check the compatibility of the solvent used with the substrates. When using solvents, extinguish all sources of ignition and carefully follow the safety and handling instructions given by the manufacturer or supplier.

Application Techniques

Shake bottle thoroughly before use. Seal the container immediately after use. Any contact with humidity will make the primer cure. For this reason, the product must be used within 24 hours after opening. Apply the primer by a fluff-free felt dauber with a uniform and light pressure in order to get a homogenous and dull film. After drying, apply the sealant within a one hour deadline, proceeding according to instructions of its technical data sheet.

Shelf Life

3M Plastic Primer P591 has a shelf life of 12 months from date of dispatch by 3M when stored in the original carton at 21°C (70°F) & 50 % relative humidity

Precautionary Information

Refer to product label and Material Safety Data Sheet for health and safety information before using the product.

Important Notice

All statements, technical information and recommendations contained in this document are based upon tests or experience that 3M believes are reliable. However, many factors beyond 3M's control can affect the use and performance of a 3M product in a particular application, including the conditions under which the product is used and the time and environmental conditions in which the product is expected to perform. Since these factors are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for the user's method or application. All questions of liability relating to this product are governed by the terms of the sale subject, where applicable, to the prevailing law

Values presented have been determined by standard test methods and are average values not to be used for specification purposes. Our recommendations on the use of our products are based on tests believed to be reliable but we would ask that you conduct your own tests to determine their suitability for your applications. This is because 3M cannot accept any responsibility or liability direct or consequential for loss or damage caused as a result of our recommendations

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