



Technical Data Sheet

Effective: 19/08/2020 Supersedes: 04/06/2019

Automotive Aftermarket Division

3M™ 58012 Single Step Low VOC Primer

1) Part Numbers

50812 : 30ml bottle
51011 : 250ml bottle

2) Description and end uses

3M™ 58012/51011 is a single step low VOC primer designed to prime surface in order to improve the adhesion of polyurethane sealants onto glass that has been treated with a ceramic silk screen printing. The application is common in the automotive industry.

3) Physical Properties

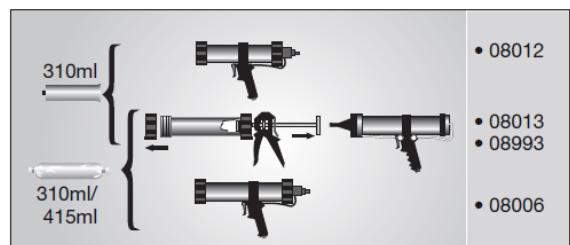
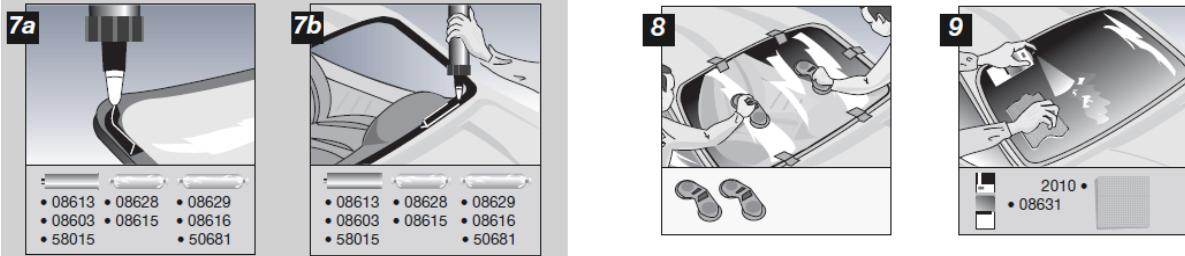
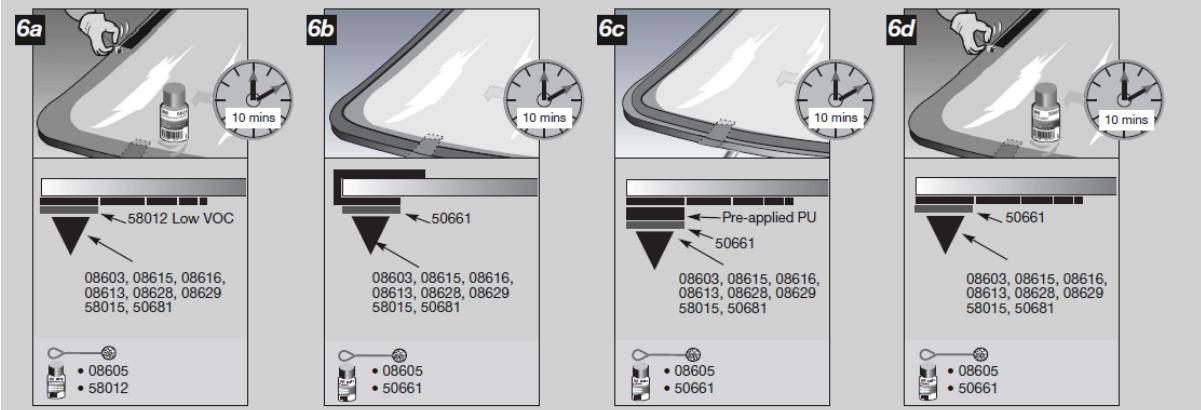
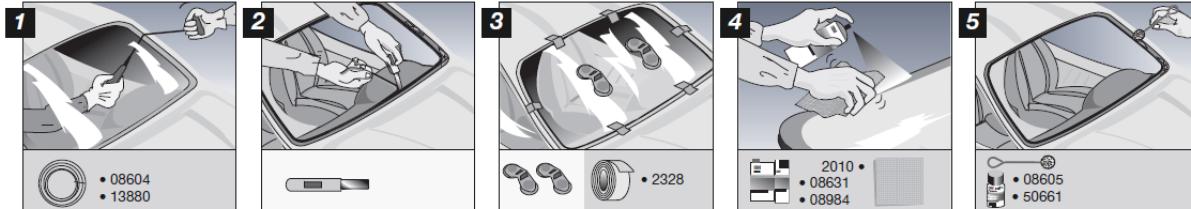
Colour	black liquid
Viscosity	100 ml DIN cup, Ø=4 mm: 12-15 sec
Density at 20°C	0.9 ± 0.05
Conventional solids content (EN 827)	28.5 ± 1.5%
Application temperature	5 to 25°C
Drying time	10 to 15 min



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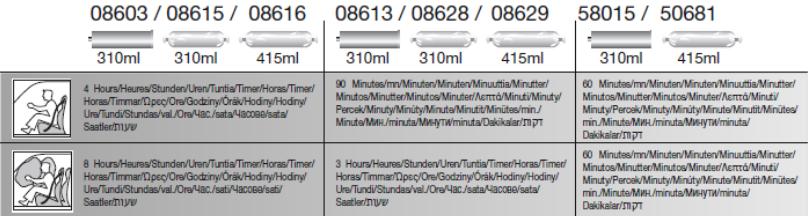
4) Directions for Use



3M PRODUCT Application	58012 Single Step Primer Low VOC	08617 Bottle WSD Clear	50661 Activator
Fritted Glass - 6a	✓		
Encapsulated Glass (PU or PVC) - 6b			✓
Pre-primed - 6d			✓
Fritted Glass with pre-applied PU - 6c			✓
Lacquered steel or Aluminium - 5			✓
Steel-Aluminium without paint (spot repair) - 5	✓		
Glass or Tinted Glass*	✓	✓	

Never use alcohol. *The primer must not be directly under UV exposure, a frame has to be applied on the other side in order to avoid UV exposure.

Drive Away Time	Doba p̄ed jízdou
Temps de libération du véhicule	Bezpečný čas do odjazdu vozidla
Wegfahrtzeit	Čas varnega odhoda
Rijkaartijd	Söidüs valmis
Kuivumisaja	Zūšanas laiks
"Kýr i vei tíð"	Dzīvīmo laikas
Tempo de condução	Tempo de mobilizare
Tiempo de seguridad antes de conducir	Время высыхания
Klar at kõra	Vrijeme sušenja
Χρόνος Αποχώρησης Αυτοκίνητου	Време за сушение
Tempo di riconsegna vettura	Vreme sušenja
Gotowosc do jazdy	Ugulyama sonras yola çıxış zamanı
Teljes száradási idő	בזמן ייבש רכב





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a) Glass preparation:

1. Always ensure that surfaces are clean and free from contamination.
2. Use 08631 Glass cleaner or 08984 Adhesive cleaner on red ScotchBrite™.
3. Clean with a light action.
4. Wipe over surface with 08631 Glass cleaner or 08984 Adhesive cleaner on a clean wipe.
5. Shake 58012/51011 single step Low VOC primer for 30 seconds before use, ensuring the metal ball contained within is moving freely.
6. Apply a thin layer of 58012/51011 single step Low VOC primer to the glass ceramic and leave for a minimum of 10 minutes (see Fig 6A).
7. For pre-primed edges, ceramic edges with pre-applied PU and encapsulated edges use the 50661 Activator and clean without using red ScotchBrite™.

Special instruction: For pre-primed glass, check adhesion of the pre-applied primer before applying 3M™ 50661 Activator. If adhesion is poor remove the pre-applied primer.

For glass or tinted glass, the 3M™ 8617 first step primer must be applied before the 58012/51011 Low VOC primer. A frame must be applied on the other side in order to avoid UV exposure.

b) Pinch weld preparation:

- 1) Where original polyurethane adhesive remains on the body frame, clean with 3M™ 08984 Adhesive Cleaner. Allow to dry before using a knife to reduce the thickness of the polyurethane to 1 mm. Apply 3M™ 58015 / 50681 glass adhesive. Use 3M™ 58012/51011 single step Low VOC primer to protect any exposed bare metal from corrosion. Do not apply any primer on the old polyurethane adhesive.
- 2) On a newly painted body frame (paint fully cured), apply 3M™ 50661 Activator. Allow to dry for a minimum of 10 minutes. Extrude a bead of 3M™ 58015 / 50681 Glass Adhesive onto the glass or the body frame (depending on car manufacturers' instructions). Install the glass within 10 minutes. Clean any excess adhesive using 3M 08984 Adhesive Cleaner. Application temperature is +10°C to +35°C.

5) Storage

12 months in unopened original packaging stored in dry premises between 0 and 25°C. Any contact with humidity (air moisture) will cause 3M™ 58012 to cure; therefore the product must be used within 24 hours after opening the bottle. Hermetically seal the bottle immediately after use.



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6) Safety

3M™ 58012/51011 is highly flammable, extinguish all sources of ignition before use.

Harmful. Read material safety data sheet before use.

Do not breathe fumes and do not allow skin contact.

3M™ 58012/51011 Single Step Low VOC Primer is designed FOR PROFESSIONAL INDUSTRIAL USE ONLY.

7) Disclaimer

All statements, technical information and recommendations are based on tests we believe to be reliable as at the date of hereof, but the accuracy or completeness thereof is not guaranteed. Please ensure before using the product that it is suitable for your intended use. Since the conditions and methods of use of the product and of the information referred to herein are beyond our control, other than for fraudulent misrepresentation, 3M expressly disclaims any and all liability as to any results obtained or arising from any use of the product or reliance on such information.



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For Additional Health and Safety Information

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