



**AP-1 Adhesion Promoter**

AP-1 Adhesion Promoter is designed to work in conjunction with H.B. Fuller acrylic pressure sensitive tape bonding systems. AP-1 is specifically designed for general use on PVC, metals and paint systems. AP-1 will not stop plasticizer migration from various plastics such as PVC.

The recommended range for “wet” laydown thickness is 1 - 8 mils. Review the general instructions section before applying the adhesion promoter.

Technology / Base	Solvent Based Primer
Type of Product	Adhesion Promoter
Appearance / Color	Slightly cloudy clear
Consistency	Liquid

**Features and Benefits**

AP-1 leaves an acrylic polymer film on the surface of the material to which it is applied which our acrylic tapes will adhere to.

**Technical Data**

Property	Typical Value	Test Method
Specific Gravity	0.9	ASTM D1475
Solids Content	1.5% (+/-0.5%)	ASTM C681
Flash Point	-3°C (27° F)	ASTM D56



## Typical Applications

AP-1 is used as an adhesion promoter for H.B. Fuller's high performance acrylic bonding tapes. These tapes are available in a variety of adhesive and core combinations to efficiently match assembly and mounting needs. Contact H.B. Fuller to select the right tape for the intended application.

## Specifications

## Typical Packaging

1 gallon cans

## Storage and Shelf Life

Store material in original unopened packaging at temperatures between 4°C to 38°C (40°F to 100°F). Shelf life is 12 months when stored as recommended.

## Safety and Disposal

Prior to working with this or any product consult product label and Safety Data Sheet (SDS) for necessary health and safety precautions and disposal considerations.

## General Instructions

- 1. Substrate Evaluation:** Acrylic adhesive is suitable for bonding a variety of substrates, including many plastic composites, sealed wood, and metals. Low surface energy materials such as polyethylene, polypropylene, silicones and PTFE can be difficult to bond to. Thorough evaluation is recommended when bonding to any questionable surface. An adhesion promoter (primer) for use with pressure sensitive acrylic adhesives may be necessary to facilitate proper bonding, and is available from H.B. Fuller.
- 2. Preparation of Substrate:** The substrate to be bonded should be cleaned with an appropriate solvent, preferably isopropanol (IPA). The acrylic adhesive backed part should be applied within 15 minutes of cleaning. To ensure removal of all contaminants without leaving any residue, use a clean, lint-free wiping cloth or disposable wipe. Never use recycled rags. Other solvents such as hexane, heptane, or methanol may be suitable for cleaning various substrates after thorough evaluation. The substrate must be completely dry through evaporation of the solvent with radiant heat, hot air dryers, or with time before bonding acrylic adhesive backed parts.
- 3. Adhesive Promoter Application:** Apply the AP-1 Adhesion Promoter to the substrate(s) either with a lint-free applicator or foam brush. Apply the Adhesion Promoter in a "wet" laydown thickness range of 1-8 mils. Allow the Adhesion Promoter to dry approximately 5 minutes. Don't touch the Adhesion Promoter.
- 4. Application of Adhesive Backed Part to the Substrate:** Remove the protective release liner from the acrylic tape immediately prior to applying the part to be bonded, being careful not to contaminate the acrylic adhesive. Apply within 15 minutes after surface preparation. Apply the part to be bonded without entrapping air between the tape and the substrate with a recommended minimum application pressure of 15 pounds per inch of tape width to achieve adhesive to substrate contact and maximum bond strength.

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