



# Technical Data Sheet

## 3M™ OEM Polyurethane Glass Adhesive Sealant 590

### Product Description

3M™ OEM Polyurethane Glass Adhesive Sealant 590 is a one component, fast curing adhesive which forms a rigid yet elastic permanent bond. 3M 590 bonds to a wide variety of materials including glass, acrylic/PMMA, polycarbonate, and many other materials.

### Product Features

### 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
Color	Black	
VOC	18.7 g/L	
VOC	0.16 lb/gal	
Approximate Coverage	38 lineal m	View
Notes: 10.5 oz. [310 mm Cartridge]; 1/8 in (3 mm) bead		
Approximate Coverage	126 lineal ft	View
Notes: 10.5 oz. [310 mm Cartridge]; 1/8 in (3 mm) bead		
Specific Gravity	1.2	
Water and salt spray resistance	Excellent	

### Typical Uncured Physical Properties

Property	Values	Additional Information
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Consistency

Thixotropic paste




### Typical Mixed Physical Properties

Property	Values	Additional Information
Tack Free Time	25 to 40 min	
Rate of Cure	>1/8 in per 24 hr	
Rate of Cure	3.5 mm per 24 hr	

### Typical Cured Characteristics

Property	Values	Additional Information
Shore A Hardness	63	View 
Test Method: ASTM C661		
Modulus at 100% Elongation	3.2 MPa	View 
Test Method: ASTM D412		
Modulus at 100% Elongation	450 lb/in <sup>2</sup>	View 
Test Method: ASTM D412		

### Typical Performance Characteristics


Property	Values	Additional Information
Tensile Strength	7.6 MPa	View 
Test Method: ASTM D412		
Tensile Strength	1100 lb/in <sup>2</sup>	View 
Test Method: ASTM D412		
Elongation at Break	375 %	View 
Test Method: ASTM D412		

Application Temperature 5 to 35 °C

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Application Temperature 40 to 95 °F

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Crash Test Pass View 

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Test Method: standard FMVSS 212

Dwell/Cure Time: 3.0  
Dwell Time Units: hr  
Temp C: 23C  
Temp F: 72F

## Product Certifications and Listings

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## Typical Environmental Performance

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Long term exposure to temperatures greater than 212°F (100°C) will decrease tensile strength over time. Do not use these products in applications where the temperatures will continuously exceed 212°F (100°C).

## Storage and Shelf Life

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3M™ OEM Polyurethane Glass Adhesive Sealant 590 must be stored in a controlled environment to maximize shelf life. Store the products in the original unopened containers below 77°F (25°C). When stored at recommended conditions, the shelf life is 12 months from the date of manufacture.

## Bottom Matter

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## Trademarks

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3M and Scotch-Brite are trademarks of 3M Company.

## Automotive Disclaimer

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Automotive Applications: This product is an industrial product and has not been designed or tested for use in certain automotive applications, including, but not limited to, automotive electric powertrain battery or high voltage applications. This product does not fully adhere to typical automotive design or quality system requirements, such as IATF 16949 or VDA 6.3. This product may not be manufactured in an IATF certified facility and may not meet a Ppk of 1.33 for all properties. The product may not undergo an automotive production part approval process (PPAP). Customer is solely responsible for evaluating the product and determining whether it is appropriate and suitable for customer's automotive application and for conducting incoming inspections before use of the product. Failure to do so may result in injury, death, and/or harm to property. No written or verbal statement, report, data or recommendation by 3M related to automotive use of the product shall have any force or effect unless in an agreement signed by the Technical Director of 3M's Automotive Division. Customer assumes all responsibility and risk if customer chooses to use this product in an automotive electric powertrain battery or high voltage application, and 3M will not be liable for any loss or damage arising from or related to the 3M product or customer's use of the product, whether direct, indirect, special, incidental, or consequential (including, but not limited to, lost profits or business opportunity or recall costs), regardless of the legal or equitable theory asserted, including, but not limited to, warranty, contract, negligence, or strict liability. In no event shall 3M be liable for any damages in excess of the purchase price paid for the product.

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## Handling/Application Information

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Application Examples

## Application Equipment

### Cartridge and Sausage Pack:

A variety of applicators are available. Please contact your sales rep for assistance in selecting an applicator.

### Bulk Dispensing:

A 38:1 ratio dual action piston pump with a ram is suggested. Actual equipment should be designed for your application based on the volume required. Please contact your sales rep or the technical service group to suggest equipment manufacturers (Graco: [www.graco.com](http://www.graco.com)).

## Directions for Use

### Surface Preparation:

Surfaces to be sealed or bonded should be clean and dry. Surfaces should be free from grease, mold release, oil, water/condensation, and other contaminants that may affect the adhesion of the sealant. Abrading with 180 to 220 grit abrasive followed by a solvent wipe will improve the bond strength. Suitable solvents include 3M™ Adhesive Remover or methyl ethyl ketone (MEK).\*

\*When using solvents, use in a well ventilated area. Extinguish all sources of ignition in the work area and observe product directions for use and precautionary measures. Refer to product label and MSDS

for further precautions. Always pre-test solvent to ensure it is compatible with substrates.

Local and federal air quality regulations may regulate or prohibit the use of these products or surface preparation and cleanup materials. Consult local and federal air quality regulations before using these products.

### Primer:

Use of a primer is recommended for window bonding using 3M™ OEM Polyurethane Glass Adhesive Sealant 590. Surface prep consists of the appropriate 3M Primer to both bonding surfaces. In areas with VOC restrictions, it is imperative that bonding surfaces are clean of contaminants. It may be acceptable to bond fritted glass without primer if the frit area is abraded with 3M™ Scotch-Brite™ abrasive to improve adhesion. Contact 3M for technical support.

Do not apply 3M 590 on frozen nor wet surfaces. Do not apply over silicone nor in the presence of curing silicone.

### Window Bonding Application:

#### Supplies:

- 3M™ OEM Polyurethane Glass Adhesive Sealant 590 in cartridges or 600 ml sausage packs
- Solvent or non-greasy cleaner
- Appropriate 3M Primer matched to the substrate:

Fritted Glass 3M™ All Purpose Primer P591

Fiberglass 3M™ All Purpose Primer P591

Metal 3M™ All Purpose Primer P591 or

3M™ Metal Primer P592

- Wool dauber(s) for 3M Primer application
- Applicator gun
- Nozzle(s)
- Glass or plastic window/windshield
- Personal protective gear (safety glasses, powder-free gloves, etc)

Alignment: Dry-set glass and align for uniform fit. Adjust setting blocks as required. Apply masking tape to the corners and frame to aid with alignment when bonding. Clean entire surface of main body using a solvent or non-greasy cleaner. Clean entire surface of window using a non-greasy glass cleaner: clean back side first, then flip over and clean front side (bonding side) second.

Apply appropriate 3M Primer to Main Body and Window: Shake appropriate 3M Primer for 30 seconds after you hear the ball moving inside the bottle. Dip a clean wool dauber into the primer. Roll the dauber around the edge of the bottle to squeeze out excess primer. Replace cover on primer bottle. Apply a single continuous layer of primer to the surface. Wait 30 minutes to dry.

Loading the applicator gun: make sure the applicator is set up with correct plunger attachment for cartridge or sausage pack.

Cartridge: Puncture seal in the center of the nozzle connection on top and remove the pull-tab seal at the bottom of the cartridge. Load into applicator and fix retaining ring (if applicable). Attach the

nozzle and cut to desired size and shape.

Sausage Pack: Make a 1" slit close to the crimp on one end of the sausage pack. Load the sausage pack into the applicator barrel (slit side out). Take care to not squeeze the sausage pack when inserting into the applicator. Place the rounded end of the supplied sausage nozzle onto the slit end of the sausage pack and fix with retaining ring. Cut nozzle to desired size and shape.

Suggested nozzle size and shape: Use a nozzle with a triangle cut. A notch clipper for pig ears or a blade can be used to make the cut. The desired size of the triangle cut is 1/2" (10-12 mm) high and 1/4" (5-6 mm) wide.

3M™ OEM Polyurethane Glass Adhesive Sealant 590 should be used within 24 hours after cartridge is opened. Dispense 3M 590 onto the primed main body with the nozzle tip perpendicular to the substrate to insure uniform contact with the substrate. Press window into the frame until the triangle bead is squeezed to half its original height. The cross-section of the bond should be approximately 1/4" x 1/4" (5 mm x 5 mm) square after application:

Apply clamps if necessary. Curing time is dependent upon the temperature and humidity. Please see attached chart for reference.

Typical Curing Time:

Time (Hours) to Reach Overlap Shear Strength

Note: Data should be considered representative or typical only and should not be used for specification purposes.

Cleanup:

While sealant is still soft, cleaning can be done with the same solvents used for surface preparation. Avoid cleaning with alcohol as it will interfere with the curing process. If sealant is already cured, removal is done mechanically with razor knife, piano wire, sanding or 3M™ Scotch-Brite™ Molding Adhesive and Stripe Removal Disc. This disc is available from 3M Automotive Aftermarket Division.

## References

Property	Values
3m.com Product Page	<a href="https://www.3m.com/3M/en_US/p/d/b40066994/">https://www.3m.com/3M/en_US/p/d/b40066994/</a>
Safety Data Sheet SDS	<a href="https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&amp;msdsLocale=en_US&amp;co=ptn&amp;q=590">https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&amp;msdsLocale=en_US&amp;co=ptn&amp;q=590</a>

## ISO Statement

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

## Precautionary Information

Refer to Product Label and Material Safety Data Sheet for health and safety information before using this product. For additional health and safety information, call 1-800-364-3577 or (651) 737-6501.

## Information

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