

3M™ Windscreen Bonding System

Glass Adhesive

A range of one-component polyurethane adhesives, designed for windscreen, side and rear window bonding. Easy to extrude with 3M™ Applicators, the adhesive comes in various sizes of sachet and cartridge. Three versions are available allowing drive-away times of one, three or eight hours.

DRIVE AWAY TIME



NEW

Part No.	Description	Pack	Qty/case	Size
58015	3M™ Glass Adhesive 1-hour HLMC	Cartridge	12	310 ml
50681	3M™ Glass Adhesive 1-hour HLMC	Sachet	9	415 ml



Part No.	Description	Pack	Qty/case	Size
08613	3M™ Glass Adhesive FC	Cartridge	12	310 ml
08628	3M™ Glass Adhesive FC	Sachet	12	310 ml
08629	3M™ Glass Adhesive FC	Sachet	9	415 ml



Part No.	Description	Pack	Qty/case	Size
08603	3M™ Glass Adhesive	Cartridge	12	310 ml
08615	3M™ Glass Adhesive	Sachet	12	310 ml
08616	3M™ Glass Adhesive	Sachet	9	415 ml

Primer/Activator

Designed to promote adhesion between the chosen 3M™ Adhesive and the glass. Select the correct primer/activator depending on windshield type.

3M PRODUCT Application	58012 Single Step Primer Low VOC	08617 Bottle WSD Clear	50661 Activator
Fritted Glass	✓		
Encapsulated Glass (PU or PVC)			✓
Pre-primed			✓
Fritted Glass with pre-applied PU			✓
Laqued steel or Aluminium			✓
Steel-Aluminium without paint (spot repair)	✓		
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.

Part No.	Description	Pack	Qty/case	Size
58012	3M™ Single Step Primer Low VOC	Bottle	6	30 ml
50661	3M™ Activator	Bottle	6	30 ml
08617	3M™ Clear Primer	Bottle	12	30 ml



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www.3mbodyshop.co.uk

3M Automotive Aftermarket 3M™ Windscreen Bonding System



Glass bonding SOLUTION for windshield replacement

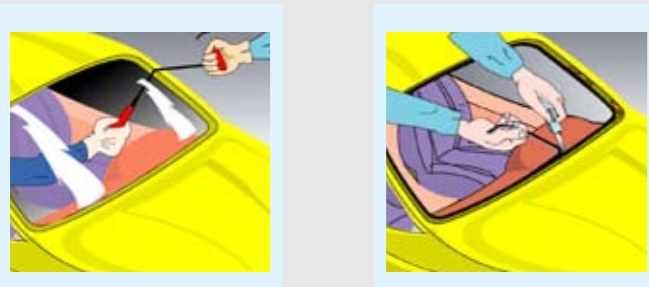
- Wide range offering 1 to 8-hour drive-away times
- Clear and safe application method
- User friendly cartridges and sachets
- New 1-hour High Modulus Low Conductivity product

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3-stage easy **Windscreen replacement** system

STAGE 1 Pinch weld preparation



Remove the old windshield and clean the original polyurethane adhesive using 3M™ Adhesive Cleaner 08984. Allow to dry and, using a knife, reduce the polyurethane thickness to 1mm. Use 3M™ Single Step Low VOC Primer 58012 to protect exposed bare metal from corrosion.

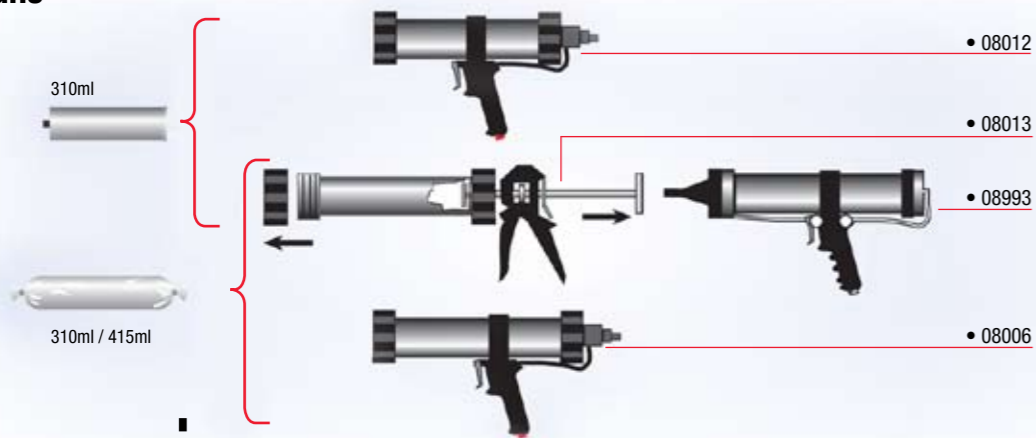
- All cartridges have easy ring-pull opening
- All cartridges are developed specifically for use with pneumatic guns



3M™ Glass Adhesives (Cartridges & Sachets)

	58015	50681	08613	08628	08629	08603	08615	08616
	310ml	415ml	310ml	310ml	415ml	310ml	310ml	415ml
	60 Minutes		90 Minutes			4 Hours		
	60 Minutes		3 Hours			8 Hours		

3M™ Guns



STAGE 2 Windshield preparation

Ceramic (Fritted glass)



58012 Low VOC
08603, 08615, 08616, 08613, 08628, 08629, 58015, 50681

- 08605
- 58012

Always ensure that surfaces are clean and free from contamination. Use 3M™ Glass Cleaner 08631 or 3M™ Adhesive Cleaner 08984 on Red Scotch-Brite™ Material. Clean with a light action.

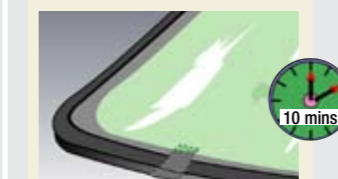
Wipe surface with 3M™ Glass Cleaner 08631 or 3M™ Adhesive Cleaner 08984 on a 3M™ Wipe 2010

Shake 3M™ Single Step Low VOC Primer 58012 for 30 seconds before use, ensuring that the metal ball container inside is moving freely.

Apply a thin layer of 3M™ Single Step Low VOC Primer 58012 to the Glass Ceramic with a 3M™ Applicator 08605 and leave for a minimum of 10 minutes.

3M™ Activator 50661 is developed specifically for Encapsulated , Pre-Applied and Pre-Primed windshields (see user manual for further explanation)

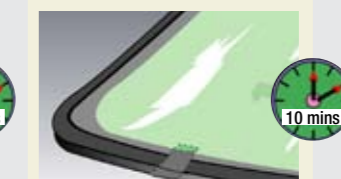
Encapsulated



50661
08603, 08615, 08616, 08613, 08628, 08629, 58015, 50681

- 08605
- 50661

Pre-Applied PU



Pre-applied PU
50661
08603, 08615, 08616, 08613, 08628, 08629, 58015, 50681

- 08605
- 50661

Pre-Primed



50661
08603, 08615, 08616, 08613, 08628, 08629, 58015, 50681

- 08605
- 50661

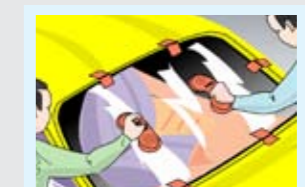
STAGE 3 Fitting the windshield



- 08613
- 08603
- 58015
- 08628
- 08615
- 08629
- 08616
- 50681



- 08613
- 08603
- 58015
- 08628
- 08615
- 08629
- 08616
- 50681



- 08631
- 2010



- 08631
- 2010

Apply 3M™ Glass Adhesive to the newly prepared windshield or prepared pinch weld

Fit the windshield on the pinch weld , clean with 3M™ Glass Cleaner 08631 and 3M™ Wipe 2010

fast curing
quick drive-away times