



## Automotive Aftermarket Division

### 3M™ 50661 Activator

#### 1) Part Numbers

3M™ 50661 30ml Activator

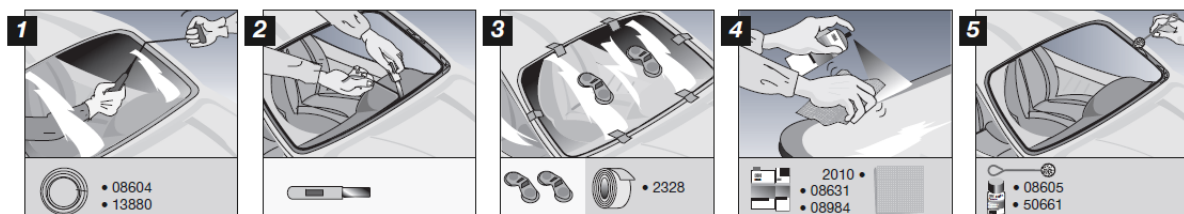
#### 2) Description and end uses

3M™ 50661 is an activator designed to prime windshields with pre-primed edges, ceramic edges with pre-applied PU and encapsulated edges in order to improve the adhesion of polyurethane sealants, methyl styrene, and SPUR hybrids sealants.

#### 3) Physical Properties

Colour	Transparent yellow
Viscosity	Ca 1mPa.s
Density at 20°C	0.94 ± 0.03
Conventional solids content (EN 827)	11 ± 1%
Application temperature	15 to 30°C
Drying time	15 min

#### 4) Directions for Use

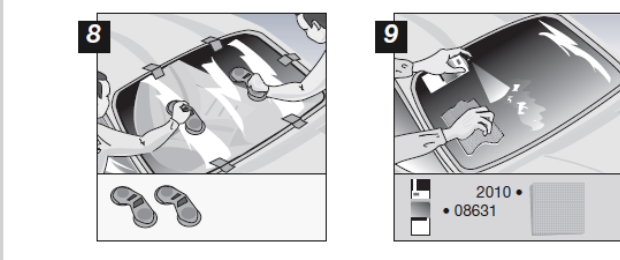
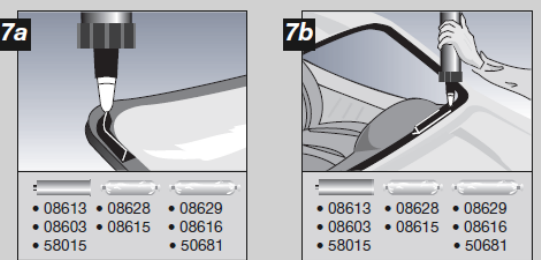
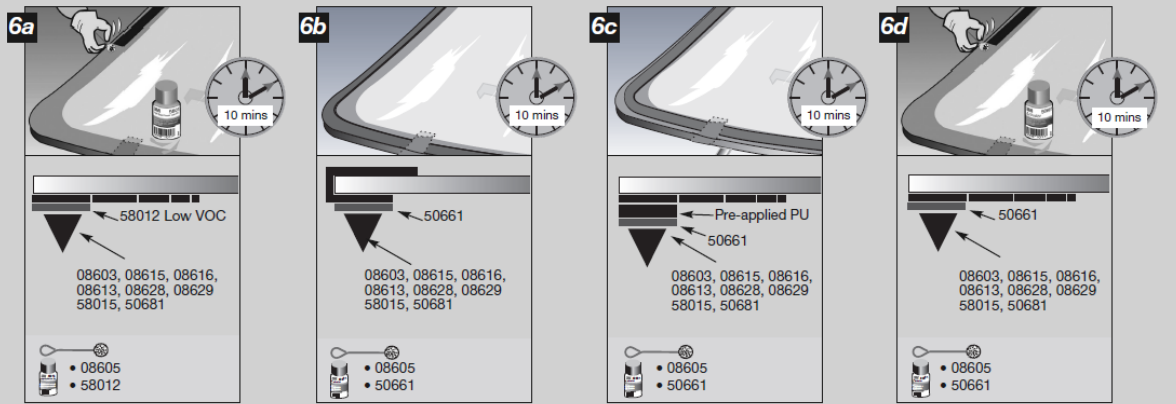




# Technical Data Sheet

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Ceramic Céramique Керамик Keramik Keramīn Keramīn Kerámica Kerámica Cerámica Cerámica	Keramisk Κεραμικό Cerámico Ceramika Ceramīn Keramická vrstva Keramické Keramīčen Keramika Saramik Керамика	Keramikas Stiklas su keramine juostele Ceramic С керамической шпательной Kerámica Keramīčen Kerámica Saramik Керамика	PU Encapsulated Encapsulé PU PU Verkapelung PU Inkapulad PU Kasettasal PU Inkapulad PU Encapsulado PU Foraglet PU Encapsulado PU Inkapulad	PU Evbüköngüvü PU Inkapulato Poliretan PU Kerebes PU zapovzdreni Zapovzdreny PU PU Ekapsuliran PU Hermetik PU Inkapuleto Stiklas su PU rimulu	PU protejat С полиуретановой рамкой Обloženo С предаритално нанесено PU лепило Обloženo PU ankapulle Уплотнители PU прът	Pre-applied PU Pré-appliqué PU Vorverarbeitete PU Vorbehandelte PU Vastu PU-tinta Tidligare påfärd PU Pré-aplicação PU For-pålagd PU Polurabano aplicado anteriormente	Fibras aplicadas PU Με προσφοροποιημένη PU PU pre-aplicada Włosne pokrycie polimerem Elszögleg felvett PU Fibred aplikovaný PU Vopred nanášený PU Prej nanášený PU Elszögeltetett PU Prepriki noklatis ar PU	Stiklas, padengtas PU klijais PU preaplicat Cio stonow polipuratawa Tymolbi nanáseno PU lepilo C predaritalno nanáseno PU lepilo Fabrički nanášen PU lakak Önceden PU uygulanan PU לבי תחילת לפני הרכיבה	Preprimed Pré-primé Mit fe fivemittler behandelt Vooropprimerd Ealprimertu Tidligare primet Pré-primário For-primet Ingrimeadisa previa Förprimad	Me προσφοροποιημένο Ακόμη Pre-primér tzzato Włosne pokrycie podkładem Bioszögleg primmeszett Opáreno základním náterem Vopred aplikovaný primer Prej nanášen primer Kruant Fabrički nanášen primer Önceden primerlenmiş Lpbi תחילת לפני הרכיבה	Primer preaplicat Загрунтованное Tymolbi nanášen primer Preopprimertu sasacco primet Fabrički nanášen primer Önceden primerlenmiş Lpbi תחילת לפני הרכיבה
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310ml		• 08012
310ml / 415ml		• 08013
		• 08993
310ml / 415ml		• 08006

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	08603 / 08615 / 08616	08613 / 08628 / 08629	58015 / 50681
Temps de libération du véhicule	310ml 310ml 415ml	310ml 310ml 415ml	310ml 415ml
Wegfahrzeit			
Rijklaartijd	4 Hours/Heures/Stunden/Урен/Tuntia/Timer/Horas/Time/Hours/Тимар/Цыс/Оре/Годзинь/Орак/Нодинь/Hodiny/Ура/Тунд/Стандис/вал./Ора/Час./sata/Часове/sata/Saatler/ת/שע	90 Minutes/mn/Minuten/Minuten/Minuutia/Minuter/Minutos/Minuter/Minutos/Minuter/Minuot/Minuti/Minuty/Perok/Minuty/Minuty/Minuta/Minuti/Minutes/mn./Minuta/Mink./minuta/Minkyt/minuta/Dakkalar/ת/דק	60 Minutes/mn/Minuten/Minuten/Minuutia/Minuter/Minutos/Minuter/Minutos/Minuter/Minuot/Minuti/Minuty/Perok/Minuty/Minuty/Minuta/Minuti/Minutes/mn./Minuta/Mink./minuta/Minkyt/minuta/Dakkalar/ת/דק
Kuivumisaika	8 Hours/Heures/Stunden/Урен/Tuntia/Timer/Horas/Time/Hours/Тимар/Цыс/Оре/Годзинь/Орак/Нодинь/Hodiny/Ура/Тунд/Стандис/вал./Ора/Час./sata/Часове/sata/Saatler/ת/שע	3 Hours/Heures/Stunden/Урен/Tuntia/Timer/Horas/Time/Hours/Тимар/Цыс/Оре/Годзинь/Орак/Нодинь/Hodiny/Ура/Тунд/Стандис/вал./Ора/Час./sata/Часове/sata/Saatler/ת/שע	60 Minutes/mn/Minuten/Minuten/Minuutia/Minuter/Minutos/Minuter/Minutos/Minuter/Minuot/Minuti/Minuty/Perok/Minuty/Minuty/Minuta/Minuti/Minutes/mn./Minuta/Mink./minuta/Minkyt/minuta/Dakkalar/ת/דק
"Kjar i vei" tid			
Tempo de condução			
Tempo de seguridad antes de conducir			
Klar att köra			
Χρόνος Αποχώρησης Αυτοκινήτου			
Tempo di riconsegna vettura			
Gotowość do jazdy			
Teljes száradási idő			

### a) Glass preparation:

Always ensure that surfaces are clean and free from contamination. Use 08631 Glass cleaner or 08984 Adhesive cleaner on red Scotch-Brite. Clean with a light action. Wipe over surface with 08631 Glass cleaner or 08984 Adhesive cleaner on a clean wipe. Shake 58012 single step Low VOC primer for 30 seconds before use, ensuring the metal ball contained within is moving freely. Apply a thin layer of 58012 single step Low VOC primer to the glass ceramic and leave for a minimum of 10 minutes (see Fig 6A). For pre-primed edges, ceramic edges with pre-applied PU and



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encapsulated edges use the 50661 Activator and clean without using red Scotch-Brite™. 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 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 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 35°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.

## 6) Safety

3M™ 50661 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™ 50661 Activator is designed FOR PROFESSIONAL INDUSTRIAL USE ONLY.



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## 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.

### For Additional Health and Safety Information

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