



Automotive Aftermarket Division

3M™ 08613/08628/08629 One Part Polyurethane Fast Cure Glass Bonding Adhesive

1) Part Numbers

3M™ 08613 3M™ 08628 3M™ 08629	:	310 ml cartridge 310 ml sachet 415 ml sachet
Dispensing system	:	3M™ 08012 air-powered gun (for cartridge) 3M™ 08006 air-powered gun (for sachet) 3M™ 08013 manual gun (for 310 ml cartridge or sachet) 3M™ 08993 universal gun (for 310 ml cartridge or sachet)

2) Description and end uses'

3M™ 08613 is a high-viscosity one component, moisture curing polyurethane adhesive designed specifically for bonding windscreens and rear windows, in accordance with main car manufacturer's specifications.

3M™ 08613 is used with associated primers:

- 3M™ Glass Adhesion Promoter (3M™ 08617).
- 3M™ Glass and Paint Black Primer (3M™ 08614).

3M™ 08613 is an adhesive that must be used for glass replacement or installation when a structural bond is required; this includes all the replacement for new windscreens and rear windows today bonded in O.E.M. with P.U. sealers.

High viscosity urethane products provide windscreen support, while the cure is attained to provide structural strength.



Technical Data Sheet

Effective: 19/08/2020 Supersedes: 31/07/2019

3) Physical Properties

Base	One-part moisture curing polyurethane
Consistency	Thick thixotropic paste
Colour	Black
Density	1.2
Solids content	>99 % (typical)
Tack Free Time	30 minutes (typical at 23°C, 50% RH)
Open time	10-15 minutes (typical at 23°C, 50% RH)
Cure through rate	3.8 mm after 24 hours (typical at 23°C, 50% RH)
Final Hardness	55-60 Shore A (typical)
Tensile strength (DIN 53504)	7 MPa
Elongation at break (DIN 53504)	> 400%
Ultimate Overlap Shear Strength	4 MPa
Safe drive away time	90 minutes minimum, for cars without airbag (at 23°C, 50% RH) 3 hours minimum, for cars with airbags (at 21°C, 54%RH)
Temperature resistance	-25°C to + 90°C
Temperature of application	+ 5°C to + 35°C

- Fast cure, rapid strength.
- High viscosity: immediate windshield support.
- When fully cured, meets OEM strength requirements.
- Successfully passes a real crash test following US standard FMVSS 212 with double airbags and non-attached dummies, after 3 hours at 21°C, 54%RH.
- TÜV approved.

4) Directions for Use

1. Remove old windscreen, wiper arms and trim necessary to expose the entire perimeter of glass.



Technical Data Sheet

Effective: 19/08/2020 Supersedes: 31/07/2019

2. Inspect urethane remaining on pinchweld for loose or unbonded areas. If existing urethane is not securely bonded, remove. Remove any rust and prime any bare or scratched metal with 3M™ Black Primer N°2.

Note: when excessive abrasive cleaning is required, prime pinchweld metal with an OEM recommended curing automotive paint primer and allow to cure properly.

3. Dry set the replacement glass into opening and align for uniform fit.

4. Glass preparation:

- a) Clean replacement windscreen with 3M™ Glass Cleaner 3M™ 08631 taking care to carefully clean surface where the adhesive bond will be made. Wipe dry.
- b) Apply the *Glass Adhesion Promoter N°1* (3M™ 08617 or 3M™ 08632) to clean and prepare the glass ceramic edges. Wipe-off immediately. Apply a second time, wipe-off and allow it to dry and activate the glass surface for 10 minutes minimum.
- c) Apply the *Glass and Paint Black Primer N°2* (3M™ 08614 or 3M™ 08633) over the primer N°1. Let it dry 10 minutes.

Note: if temperature in shop is below 15°C, allow primer to dry longer, up to 20 minutes to get proper surface preparation.

5. Pinchweld preparation:

- a) In case of old polyurethane sealer remaining on the body frame, use a knife to reduce the remaining sealer to a thickness of 1 mm. If needed, clean its surface with 3M™ 08984 Adhesive Cleaner and let it dry 10 minutes. Then apply 3M™ 08613 / 08628 / 08629 adhesive on.
- b) On newly painted body frame (paint fully cured), apply the primer N°2. Let it dry 10 minutes. Then apply 3M™ 08613 / 08628 / 08629 adhesive on.

Note: paint surface must be dried, degreased and free from dust.

6. Extrude a bead of 3M™ 08613 / 08628 / 08629 adhesive on the glass or on the body frame (depending on manufacturer's instructions). Extrude adhesive at sufficient height to assure proper wet-out of both glass and pinchweld is achieved when windscreen is set.
7. Set the glass, using the appropriate marks, within 15 minutes following the application of the adhesive.
8. Install trim mouldings and hardware.
9. Clean any excess using 3M™ 08984 Adhesive Cleaner.
10. Precautions to be taken after assembly: the curing time of 3M™ 08613 / 08628 / 08629 adhesive depends upon atmospheric humidity and temperature. The vehicle



Technical Data Sheet

Effective: 19/08/2020 Supersedes: 31/07/2019

must remain stationary for a minimum of 90 min. (for cars without airbags) or 3 hours (for cars with airbags).

5) Storage

Storage conditions	Cool dry place. Best results are obtained when material is stored and applied at room temperature, 15 to 30°C.
Shelf life	9 months from date of manufacture under normal storage conditions. Refer to 'Best Before Date' on cartridge or sachet.

6) Safety

Please refer to the Material Safety Data Sheet or contact your local 3M™ Toxicology Department.

3M™ 08613/08628/08629 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



Technical Data Sheet

Effective: 19/08/2020 Supersedes: 31/07/2019

For Additional Health and Safety Information

<p>3M United Kingdom plc Automotive Aftermarket 3M Centre, Cain Road, Bracknell, RG12 8HT Tel: +44 (0)161 237 6391 aadukenquiries@mmm.com www.3Mbodyshop.co.uk</p>	<p>3M Ireland Limited Automotive Aftermarket The Iveagh Building Carrickmines Park Carrickmines , Dublin 18 Tel: +353 12160301 aadukenquiries@mmm.com www.3Mbodyshop.co.uk</p>	<p>3M Denmark a/s Automotive Aftermarket Hannemanns Allé 53 2300 København S Tel: +45 43480100 aadukenquiries@mmm.com www.3MAuto.dk</p>
<p>3M Finland, Suomen 3M Oy Automotive Aftermarket Keilaranta 6 02150 Espoo Tel: 09 5252 1 aadukenquiries@mmm.com www.3M.fi/autotuotteet</p>	<p>3M Svenska AB Automotive Aftermarket Herrjärva torg 4 170 67 Solna Tel: 08-922100 aadukenquiries@mmm.com www.3M.se/bileftermarkad</p>	<p>3M Norge AS Automotive Aftermarket Kanalveien 2 2004 Lillestrøm Tel: 06384 aadukenquiries@mmm.com www.3m.no/auto</p>
<p>3M Latvija K.Ulmana 5 Riga, LV-1004 Tel: +371 67066120 aadukenquiries@mmm.com www.3m.lv</p>	<p>3M Eesti OU Pärnu mnt. 158 11317 Tallinn Tel: +372 6 115 902 aadukenquiries@mmm.com www.3m.ee</p>	<p>3M Lietuva A.Goštauto str. 40 A LT-01112 Vilnius Tel: +370 5 2160780 aadukenquiries@mmm.com www.3m.lt</p>

© 3M 2020. 3M is a trademark of the 3M company. All rights reserved