

Effective: 14/05/19 Supersedes: 04/05/16

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

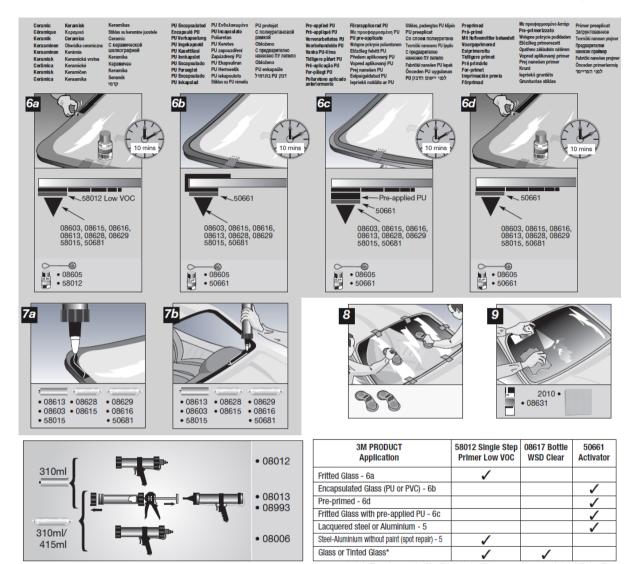
Colour	Transparent yellow
Viscosity	Ca 1mPa.s
Density at 20°C	0.94 ± 0.03
Conventional solids content (EN 827)	11 ± 1%
Application temperature	15 to 30°C
Drying time	15 min

4) Directions for Use





Effective: 14/05/19 Supersedes: 04/05/16



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 Temps de libération du véhicule Wegfahrzeit Rijklaartijd

Inguality of the conduction o

Telies száradási idő

Doba před jizdou Bezpečný čas do odjazdu vozidla Čas varnega odhoda Sčiduks vallnis Žūšanas laiks Džiúvimo laikas Timp de imobilizare Время высыхания

Vrijeme sušenja Bpeme за съхнене Vreme sušenja Uygulama sonrası yola çıkış zamanı זמו המתנה לפני תחילת נהיגה

	08603	/ 08615 /	08616	08613 /	08628 /	08629 58015 /		50681
	310ml	310ml	415ml	310ml	310ml	415ml	310ml	415ml
4 Hours/Heures/Stunder/Uren/Tuntis/Timer/Horas/Timer/ Horas/Timmar/Dpcy/Ore/Godziny/Orek/Hodmy/Hodmy/ Ure/Tund/Stundes/vel/Ore4/Bc//sata/4accee/sata/ Sastler/tit/pr/			90 Minutes/mr/Minuter/Minuter/Minutei/Minutte/ Minutos/Minuter/Minutos/Minutei/Acmtd/Minuti/Minuty/ Percek/Minuty/Minuty/Minute/Minute/Minute/minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/Minute/			60 Minutes/mn/Minuten/Minuten/Minuttis/Minutter/ Minutos/Minutter/Minutos/Minuter/Acrató/Minutis/ Minuty/Perceix/Minuty/Minuty/Minuter/Minutis/ min./Minute/Mirkt./minuta/MirkyTW/minuta/ Deixkaler/TIpT7		
8 House/House/Stunder/Len/Tunta/Timer/Horse/Timer/ Horse/Timer/Type/One/Sodziny/Oriel/Hodiny/Hodiny/ Use/Tund/Stundes/vsl./Ore/Nsc./set/Hacces/set/ Seatled/11/97		3 Hours/Heures/Stunden/Uren/Tuntia/Timer/Horas/Timer/ Horas/Timmar/Lipsc/Ore/Godziny/Orak/Hodiny/Hodiny/ Ure/Tundi/Stundas/val/Ore/Час/sata/4aco8e/sata/ Saatler/บบช			60 Minutes/mr/Minuter/Minuter/Minute/Minute/ Minutos/Minuter/Minutos/Minuter/Armtó/Minute/Minuter/Minuter/Minuter/Minuter/Minuter/Minuter/Minuter/Minuter/ Minuter/Minuter/Minuter/Minuter/Minuter/ Dakikalar/MipT			

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



Effective: 14/05/19 Supersedes: 04/05/16

(see Fig 6A). For pre-primed edges, ceramic edges with pre-applied PU and 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.

3M

Technical Data Sheet

Effective: 14/05/19 Supersedes: 04/05/16

7) Disclaimer

All statements, technical information and recommendations are based on tests we believe to be reliable but the accuracy or completeness thereof is not guaranteed. Please ensure before using our product that it is suitable for your intended use. All questions of reliability relating to this product are governed by the Terms of Sale subject, where applicable, to the prevailing law.

For Additional Health and Safety Information

3M South Africa & Sub-Saharan Africa, 146A Kelvin Drive, Woodmead, Sandton, South Africa, Tel: (0861) 225536

3M (East) AG Representation Office Tirane, Rruga Sami Frasheri, Pallati i Ri Perxhola Kati 2 Ap2, 1000 Albania

3M Arabia, LLC, Building 24-25 3M Saudi Arabia Zone C, Business Gate, Airport Road, Riyadh, Saudi Arabia

3M Bulgaria, Mladost 4, Business Park, bl.4, 2nd floor, Sofia 1766, Bulgaria

3M Česko, spol. s r.o., V Parku 2343/24, 148 00 - Praha 4, Czech Republic

3M (East) AG, Branch office Croatia, Avenija Većeslava Holjevca 40, 10 000 Zagreb, Croatia, Tel: +385 1 2499750, www.3m.com.hr

3M Egypt, Finance Center, New Cairo, Plot 140, Banking Sector, 5th settlement, Cairo, Egypt

3M Hellas MEPE, Automotive Aftermarket Division, 20 Kifisias Avenue, 151 25 Marousi, Greece,

Phone: +30 210 68 85 300, innovation.gr@mmm.com, www.3M.gr

3M Hungária Kft, Neumann János u. 1/E, 1117 Budapest, Hungary

3M Israel, 91 Medinat Hayehudim St., Herzliya, Israel

3M Kenya Ltd, Victoria Towers, 3rd Floor, Kilimanjaro Av, Upperhill, Kenya

3M Gulf Limited, Ein El Mreisseh, Saint Charles City Center, 4th. Floor, P.O.Box: 11-5025, Riad el Solh, Beirut 1107 2180 Lebanon

3M Minnesota Mining & Manufacturing Nigeria Limited, No 2 Sheraton Opebi Link Road, Ikeja, Lagos Nigeria

3M Pakistan, Islamic Chamber of Commerce Building, ST-2/A, Block 9, KDA Scheme 5, Clifton, Karachi, Pakistan

3M Poland, Al. Katowicka 117, Kajetany, 05-830 Nadarzyn, Poland, Telefon: +48 22 739 60 00, www.3m.pl/kontakt

3M Gulf (Representation Office), Suhaim Bin Hamad St., Al Mana Towers Tower B, 2nd Floor, Office No.4, Doha Qatar, P.O.Box 14685

3M Romania,12 Menuetului St., Bucharest Business Park, Building D, District 1 013713 Bucharest, Romania

3M (East) AG, Representation Office Serbia, Airport City, Omladinskih brigada 90B, 11070 Belgrade, Serbia, Tel: +381 11 2209 400, www.3m.co.rs/3M/sr RS/3m-south-east-europe/

3M Slovensko s.r.o., Polus Tower 2, Vajnorská 100/B, 83104 Bratislava

3M (East) AG, Branch office Slovenia, Cesta v Gorice 8, 1000, Ljubljana, Slovenia,

Tel: +386 1 2003 630, www.3m.com/3M/sl SI/3m-south-east-europe/

3M Sanayi ve Ticaret As, Barbaros Mah., Mor Sümbül Sok., No:7/3F, 27-51, Nidakule Ataşehir Güney, 34746 Ataşehir, İstanbul, Turkey



Effective: 14/05/19 Supersedes: 04/05/16

3M Gulf Limited, Dubai Internet City, Building No. 11, 3rd Floor, U.A.E

© 3M 2019. 3M is a trademark of the 3M company. All rights reserved