



Automotive Aftermarket Division

3M™ 50661 Activator

1) Part Numbers

3M™ 50661 30ml Activator

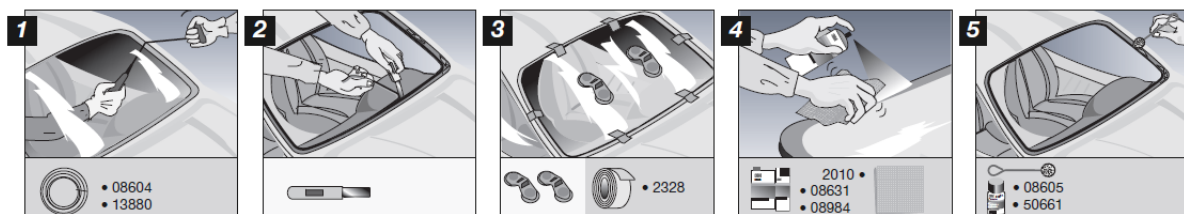
2) Description and end uses

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





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(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.



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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

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