



Technical Data Sheet

3M™ Scotch-Weld™ Activator AC649



[Product Details](#)



[Regulatory Info/SDS](#)

Product Description

3M™ Scotch-Weld™ Activator AC649 is a general-purpose surface activator that cure anaerobic adhesives on inactive or very cold surfaces. For normal active surface, 3M™ Scotch-Weld™ Anaerobic Activator accelerate both fixture and cure times significantly.

Product Features

- Used for anaerobic adhesives to accelerate the cure of the material at lower temperatures or for inactive surfaces.
- Accelerates cure on normal, active surfaces.
- Can be pre-applied in advance and has an on-part life of 30 days.
- Aids the successful bonding of parts with larger bond gaps

Technical Information Note

The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

Typical Uncured Physical Properties

Attribute Name	Value
Color	Green ¹
Viscosity	2 cP
On-Part Life	30 d

¹ Colors may vary from nearly white to yellow/amber. Adhesive performance is not affected by color variation.

Typical Physical Properties

Attribute Name	Value
Appearance	Liquid
Specific Gravity	0.79 g/mL
Solvent Resistance	Acetone

Handling/Application Information

Directions for Use

Not recommended for 3M™ Gasket Makers due to up to 20% loss in strength.

1. Ensure parts are clean, dry and free from oil and grease.
2. Apply to one or both bonbon surfaces.*
3. Allow parts to dry completely (~30-60 seconds). Activator-coated parts may be held up to their on-part life but surface contamination must be avoided.
4. Apply a 3MTM Scotch-Weld™ Anaerobic Adhesive to one or both parts making sure there is sufficient product coverage.
5. Assemble immediately, moving surfaces back and forth to ensure full distribution of the adhesive.
6. Secure the assembly until fixtured.

*When using solvents and/or aerosols, extinguish all ignition sources, including pilot lights, and follow the manufacturer's precautions and directions for use.

Caution: Never mix adhesives and activator/primer liquids together.

Storage and Shelf Life

Store under normal conditions of 16° to 27°C (60° to 80°F) in the original, unopened packaging, out of direct sunlight. For best performance, use this product within 21 months from date of manufacture.

Precautionary Information

Refer to Product Label and Material Safety Data Sheet for health and safety information before using this product. For additional health and safety information, call 1-800-364-3577

Automotive Disclaimer

Select Automotive Applications:

This product is an industrial product and has not been designed or tested for use in certain automotive applications, such as automotive electric powertrain battery or high voltage applications, which may require the product to be manufactured in a IATF certified facility, meet a Ppk of 1.33 for all properties, undergo an automotive production part approval process (PPAP), or fully adhere to automotive design or quality system requirements (e.g., IATF 16949 or VDA 6.3). Customer assumes all responsibility and risk if customer chooses to use this product in these applications.

Information

Technical Information: The technical information, guidance, and other statements contained in this document or otherwise provided by 3M are based upon records, tests, or experience that 3M believes to be reliable, but the accuracy, completeness, and representative nature of such information is not guaranteed. Such information is intended for people with knowledge and technical skills sufficient to assess and apply their own informed judgment to the information. No license under any 3M or third party intellectual property rights is granted or implied with this information.

Product Selection and Use: Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. As a result, customer is solely responsible for evaluating the product and determining whether it is appropriate and suitable for customer's application, including conducting a workplace hazard assessment and reviewing all applicable regulations and standards (e.g., OSHA, ANSI, etc.). Failure to properly evaluate, select, and use a 3M product and appropriate safety products, or to meet all applicable safety regulations, may result in injury, sickness, death, and/or harm to property.

Warranty, Limited Remedy, and Disclaimer: Unless a different warranty is specifically stated on the applicable 3M product packaging or product literature (in which case such warranty governs), 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, OR ARISING OUT OF A COURSE OF DEALING, CUSTOM, OR USAGE OF TRADE. If a 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M's option, replacement of the 3M product or refund of the purchase price.

Limitation of Liability: Except for the limited remedy stated above, and except to the extent prohibited by law, 3M will not be liable for any loss or damage arising from or related to the 3M product, whether direct, indirect, special, incidental, or consequential (including, but not limited to, lost profits or business opportunity), regardless of the legal or equitable theory asserted, including, but not limited to, warranty, contract, negligence, or strict liability.

Disclaimer: 3M industrial and occupational products are intended, labeled, and packaged for sale to trained industrial and occupational customers for workplace use. Unless specifically stated otherwise on the applicable product packaging or literature, these products are not intended, labeled, or packaged for sale to or use by consumers (e.g., for home, personal, primary or secondary school, recreational/sporting, or other uses not described in the applicable product packaging or literature), and must be selected and used in compliance with applicable health and safety regulations and standards (e.g., U.S. OSHA, ANSI), as well as all product literature, user instructions, warnings, and limitations, and the user must take any action required under any recall, field action or other product use notice. Misuse of 3M industrial and occupational products may result in injury, sickness, or death. For help with product selection and use, consult your on-site safety professional, industrial hygienist, or other subject matter expert. For additional product information, visit www.3M.com.

3M™ Industrial Adhesives and Tapes Division
3M Center, St. Paul, MN 55144-1000
3M.com/iatd

©3M 2025 (4/25)