



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.

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