3M™ Windscreen Bonding System

Glass Adhesive
A range of one-component polyurethane adhesives, designed for windscreen, side and rear window bonding. Easy to extrude with 3M™ Applicators, the adhesive comes in various sizes of sachet and cartridge. Three versions are available allowing drive-away times of one, three or eight hours.

DRIVE AWAY TIME

<table>
<thead>
<tr>
<th>Part No.</th>
<th>Description</th>
<th>Pack</th>
<th>Qty/case</th>
<th>Size</th>
</tr>
</thead>
<tbody>
<tr>
<td>58015</td>
<td>3M™ Glass Adhesive 1-hour HLMC Cartridge</td>
<td>12</td>
<td>310 ml</td>
<td></td>
</tr>
<tr>
<td>50081</td>
<td>3M™ Glass Adhesive 1-hour HLMC Sachet</td>
<td>9</td>
<td>415 ml</td>
<td></td>
</tr>
<tr>
<td>08613</td>
<td>3M™ Glass Adhesive FC Cartridge</td>
<td>12</td>
<td>310 ml</td>
<td></td>
</tr>
<tr>
<td>08628</td>
<td>3M™ Glass Adhesive FC Sachet</td>
<td>12</td>
<td>310 ml</td>
<td></td>
</tr>
<tr>
<td>08629</td>
<td>3M™ Glass Adhesive FC Sachet</td>
<td>9</td>
<td>415 ml</td>
<td></td>
</tr>
<tr>
<td>08603</td>
<td>3M™ Glass Adhesive Cartridge</td>
<td>12</td>
<td>310 ml</td>
<td></td>
</tr>
<tr>
<td>08615</td>
<td>3M™ Glass Adhesive Sachet</td>
<td>12</td>
<td>310 ml</td>
<td></td>
</tr>
<tr>
<td>08616</td>
<td>3M™ Glass Adhesive Sachet</td>
<td>9</td>
<td>415 ml</td>
<td></td>
</tr>
</tbody>
</table>

Primer/Activator
Designed to promote adhesion between the chosen 3M™ Adhesive and the glass. Select the correct primer/activator depending on windshield type.

- 3M PRODUCT
  - 58012 Single Step Primer Low VOC
  - 50081 Bottle WSD Clear
  - 08603 Adhesive Cartridge
  - 08615 Adhesive Sachet
  - 08616 Adhesive Sachet

- Glass or Tinted Glass
- Fritted Glass
- Encapsulated Glass (PU or PVC)
- Pre-printed
- Fritted Glass with pre-applied PU
- Lacqued steel or Aluminium
- Steel-Aluminium without paint (spot repair)
- Never use alcohol

NEW
windshield replacement

• Wide range offering 1 to 8-hour drive-away times
• Clear and safe application method
• User friendly cartridges and sachets
• New 1-hour High Modulus Low Conductivity product
3-stage easy Windscreen replacement system

**STAGE 1** Pinch weld preparation

Remove the old windshield and clean the original polyurethane adhesive using 3M™ Adhesive Cleaner 08984. Allow to dry and, using a knife, reduce the polyurethane thickness to 1mm. Use 3M™ Single Step Low VOC Primer 58012 to protect exposed bare metal from corrosion.

- All cartridges have easy ring-pull opening
- All cartridges are developed specifically for use with pneumatic guns

3M™ Glass Adhesives (Cartridges & Sachets)

<table>
<thead>
<tr>
<th></th>
<th>08613</th>
<th>08628</th>
<th>08629</th>
<th>08603</th>
<th>08615</th>
<th>08616</th>
</tr>
</thead>
<tbody>
<tr>
<td>58015</td>
<td>310ml</td>
<td>310ml</td>
<td>310ml</td>
<td>310ml</td>
<td>310ml</td>
<td>310ml</td>
</tr>
<tr>
<td>50681</td>
<td>415ml</td>
<td>415ml</td>
<td>415ml</td>
<td>415ml</td>
<td>415ml</td>
<td>415ml</td>
</tr>
</tbody>
</table>

60 Minutes | 60 Minutes | 3 Hours | 4 Hours | 8 Hours

3M™ Guns

**STAGE 2** Windshield preparation

Ceramic (Fritted glass)

Always ensure that surfaces are clean and free from contamination. Use 3M™ Glass Cleaner 08631 or 3M™ Adhesive Cleaner 08984 on Red Scotch-Brite™ Material. Clean with a light action.

Apply 3M™ Glass Adhesive to the newly prepared windshield or prepared pinch weld

- Shake 3M™ Single Step Low VOC Primer 58012 for 30 seconds before use, ensuring that the metal ball container inside is moving freely.
- Apply a thin layer of 3M™ Single Step Low VOC Primer 58012 to the Glass Ceramic with a 3M™ Applicator 08605 and leave for a minimum of 10 minutes.

3M™ Activator 50661 is developed specifically for Encapsulated, Pre-Applied and Pre-Primed windshields (see user manual for further explanation)

Encapsulated

- Pre-applied PU

Pre-Primed

- Pre-Primed

Apply 3M™ Glass Adhesive to the newly prepared windshield or prepared pinch weld

- Fit the windshield on the pinch weld, clean with 3M™ Glass Cleaner 08631 and 3M™ Wipe 2010

**STAGE 3** Fitting the windshield

Fit the windshield on the pinch weld, clean with 3M™ Glass Cleaner 08631 and 3M™ Wipe 2010

Apply 3M™ Glass Adhesive to the newly prepared windshield or prepared pinch weld