



Scotch-Weld™

Anerobic Adhesive Activators

AC649 • 3989

Technical Data

March, 2010

Product Description

3M™ Scotch-Weld™ Anaerobic Adhesive Activators are general-purpose surface activators/ primers that cure anaerobic adhesives on inactive or very cold surfaces. For normal active surfaces, 3M™ Scotch-Weld™ Anaerobic Activators accelerate both fixture and cure times significantly.

Specific Features

- Useful for promoting the adhesion and cure of 3M™ Scotch-Weld™ Threadlockers, Pipe Sealants, Retaining Compounds and Gasket Makers.
- Can be pre-applied to parts days in advance.
- Aids the successful bonding of parts with larger bond gaps.
- 3M™ Scotch-Weld™ Anaerobic Adhesive Activator 3989 is a canned aerosol packaging of 3M™ Scotch-Weld™ Anaerobic Adhesive Activator AC649

Typical Uncured Physical Properties

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

	3M™ Scotch-Weld™ Anaerobic Adhesive Activators	
	AC649	3989
Color	Green	Green
Solvent	Acetone	Acetone
Appearance	Liquid	Aerosol
Specific Gravity (g/ml)	0.79	0.79
Viscosity (cps)	2	2
On-Part Life (days)	30	30

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Handling Information

Directions for Use

1. Ensure parts are clean, dry, and free from oil and grease.
2. Apply to one or both bonding surfaces.*
3. Allow parts to dry completely (usually 30-60 seconds). Activator-coated parts may be held up to their On-Part Life but surface contamination must be avoided.
4. Apply a 3M™ 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.

An alternative method of use is in post assembly application. After apply anaerobic adhesive and assembling parts the anaerobic activator is applied topically over the joint area to aid cure.

***Note:** 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.

Material Surface Activity and Cure Speed

Active (Fast) ←

- Brass
- Bronze
- Commercial aluminum
- Copper
- Iron
- Kovar®
- Manganese
- Monel®
- Nickel

→ Inactive (Slow)

- Anodized aluminum
- Cadmium
- Chemical black oxide
- Galvanized steel
- Gold
- Inconel®
- Magnesium
- Magnetite steel
- Plated parts
- Pure aluminum
- Silver
- Stainless steel
- Zinc

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Storage	Store product in cool, dry area out of direct sunlight.
Shelf Life	Twelve months when stored at 60° to 80°F (16° to 27°C) in the original unopened container.
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 or (651) 737-6501.
Technical Information	The technical information, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.
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ISO 9001:2000

This product was manufactured under a quality system registered to ISO 9001:2000 standards.



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40% pre-consumer
10% post-consumer

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