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TS Data Sheet 08620;
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Windo-Weld Sealer (Bulk)

Data Sheet

3M Part No.(s) 3M Part Descriptor(s)

08620;
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08632

3M Fax on Demand Identification Number:

Description

Tacky, solid sealers designed for use with structural urethane adhesive to bond automotive glass to the car body in full cut installation procedures. It may be used for installing windshields, backlites and bond to primed metal and glass. Compatible with urethane, polysulfide and butyl sealants.

Features, Advantages, Benefits

Features Excellent adhesion over with temperature range (20°F-120°F).
Aggressive tack provides immediate bonding.
Excellent water seal.

Advantages

Benefits

Typical Physical Properties

Base Butyl Rubber
Color Black

Flash Point - °F	None
Solids Content (Appx.)	99% by Weight

Product Uses

Performance Properties

Test	Condition	Results
Water Resistance	1000 Hours Immersion	Excellent (no change)
Ozone Resistance	72 Hours @ 150 ppm	Excellent (no change)
Low Temperature Flexibility	-20°F	Excellent (no failures)
Heat Resistance	45 minutes @ 275°F	Very Good (no change)
Tensile Strength	Glass to Glass	15 psi minimum

Handling and Application Information

Directions for Use

1. Remove all old sealant.
2. Prime bare metal with appropriate primer system (urethane primer if products used with a urethane adhesive).
3. Clean glass with 3M™ Glass Cleaner-P.N. 08968.
4. Position windshield or backlite on pinchweld.
5. Be certain sealer makes complete contact between glass and pinchweld.
6. Use hand pressure on glass to insure a good seal.
7. Back fill with liquid sealant.
8. Water test using a gentle spray of water on roof.

Applications

For installation of stationary glass when used as supplementary sealer/bonding material with urethane adhesive.

Storage and Handling

Store at room temperature. Rotate stock on a "first-in-first-out" basis. When stored at the recommended conditions in original, unopened containers, this product has a shelf life of 12 months.

Precautionary Information

Refer to Product Label and Material Safety Data Sheet for Health and Safety Information before using this product.

Country

US

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Important Notice to Purchaser

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responsible for determining whether the 3M product is fit for a particular purpose and suitable for user's method of application.

* If 'Directions for Use' reference P.N.'s 8984, 8986, or 8987, please read below.

Federal and local air quality regulations may regulate or prohibit the use of surface preparation and cleanup solvents based on VOC content. Consult your local and Federal air quality regulations for information. When using solvents, use in a well ventilated area. Extinguish all sources of ignition in the work area and observe precautionary measures for handling these materials. Refer to product label and MSDS for P.N. 8984, 8986, or 8987 for detailed precautionary information.

LIMITATION OF REMEDIES AND LIABILITY: If the 3M product is proved to be defective, **THE EXCLUSIVE REMEDY, AT 3M'S OPTION, SHALL BE TO REFUND THE PURCHASE OF OR TO REPAIR OR REPLACE THE DEFECTIVE 3M PRODUCT.**

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For Additional Health and Safety Information

See Material Safety Data Sheet (Fax on Demand 1-800-305-0419), or call: **3M Automotive Aftermarket Division** 3M Center, Building 223-6N-01
Phone: 877-MMM-CARS (877-666-2277)

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Reference: Goto Ref

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