

3M

Scotch-Weld™

Activator

3989

Technical Data

July, 2005

Product Description

3M™ Scotch-Weld™ Activator 3989 is an aerosol general-purpose surface activator that cures anaerobic adhesives on inactive surfaces or cold surfaces. For normal active surfaces, Scotch-Weld activator 3989 accelerates the cure significantly.

Features

- Used for anaerobics 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.

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.

Color	Green
Solvent Type	Acetone
Appearance	Aerosol
Viscosity (cps)	2

Handling/Curing Information

Directions for Use

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

1. Spray Scotch-Weld activator 3989 on one or both bonding surfaces* Scotch-Weld activator 3989 degreases and cleans parts while priming. Activator-coated parts are good up to one month when kept cleaned and not contaminated.
2. Allow the parts to dry completely (approximately 30-60 seconds) before applying the 3M™ Scotch-Weld™ Anaerobic Product.
3. Apply the Scotch-Weld anaerobic product and make sure to have sufficient product coverage.
4. Performance is dependent on the gap fill and type of materials being bonded. For typical applications, fixture times would be achieved in approximately 2 minutes.

*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.

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Material Surface Activity and Cure Speed

Active (Fast) ←

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

→ Inactive (Slow)

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

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.

Product Use

All statements, technical information and recommendations contained in this document are based upon tests or experience that 3M believes are reliable. However, many factors beyond 3M's control can affect the use and performance of a 3M product in a particular application, including the conditions under which the product is used and the time and environmental conditions in which the product is expected to perform. Since these factors are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for the user's method of application.

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