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Public

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3M™ Windo-Weld™ Sealer (Bulk)

Data Sheet

3M Part No.(s)	3M Part Descriptor (s)
08620	Roll - 1/4" x 15'
08621	Roll - 5/16" x 15'
08622	Roll - 3/8" x 15'
08625	Roll - 1/8" x 1/4" x 30'

3M Fax on Demand Identification Number :

Description

Tacky, black, compressible sealant supplied in rolls. Used as a secondary sealant when automotive glass is installed with a structural urethane adhesive. Compatible with urethane, polysulfide and butyl sealants.

Features, Advantages, Benefits

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

Typical Physical Properties

Base	Butyl Rubber
Color	Black
Viscosity (CPS) Brookfield	N/A
Viscometer	
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

3M glass products are intended for use as part of the repair process outlined in service manuals provided by automotive manufacturers. For detailed instructions by car model, refer to information available from the automobile manufacturer.

3M™ Windo-Weld™ Ribbon Sealer is designed and intended for use as a replacement to original equipment butyl installations or as a supplementary sealant when installing stationary glass with urethane adhesive.

**** 3M™ WINDO-WELD™ RIBBON SEALER IS NOT INTENDED FOR A WINDSHIELD OR BACKGLASS WHERE OEM URETHANE WAS ORIGINALLY USED. For urethane set glass, refer to and follow 3M Auto Glass Replacement Urethane directions. In some urethane set applications, use of this product may be appropriate as a supplementary sealant.**

1. Remove glass using cold knife, power tool, or piano wire.
2. **Preparation of Glass:** Thoroughly clean perimeter of glass where the butyl will bond with 3M Glass Cleaner, PN 08888. Wipe completely dry with a clean, dry, lint-free cloth.
3. **Preparation of Metal:** Use an appropriate VOC-Compliant 3M Cleaner to remove any surface contamination, such as adhesive, grease, grime, oil, etc. Scuff lightly with Scotch-Brite. If paint is scratched during removal of old butyl, prime any bar metal scratches with 3M Single Step Primer, PN 08681 or 08682.
4. **Application of 3M™ Windo-Weld™ Ribbon Sealer:** Sealer may be applied to either pinchweld or glass. Applying sealer to pinchweld is preferred. Start seal on bottom of side pillar or glass. Line up sealer even with edge of pinchweld using thumb pressure. *Butt the ends of the sealer – do not overlap* . Strip liner from sealer.
5. **Use of Settling Blocks – IMPORTANT:** Setting blocks are necessary since 3M™ Windo-Weld™ Ribbon Sealer is compressible and tacky. Replace with blocks provided if originals are damaged during glass removal.
6. **Placement of Glass:** Position glass onto pinchweld. Be certain that glass makes contact with sealant. Use hand pressure to provide good contact and seal. Paddle sealant around edge if desired.
7. **WATER TEST**
8. **Clean up:** Replace moldings as needed and clean up. Use an appropriate VOC-Compliant 3M Cleaner to remove any surface contamination, such as adhesive, grease, grime, oil, etc.

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 24 months.

Precautionary Information

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

Country

US

This document is public . It may be distributed .

Warranty and Limited Remedy

This product will be free from defects in material and workmanship at the time of shipment. 3M MAKES NO OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR PARTICULAR PURPOSE. User is responsible for determining whether the 3M product is fit for a particular purpose and suitable for user's application. If this product is defective, your exclusive remedy and 3M's and seller's sole obligation shall be, at 3M's option, to replace the product or refund the purchase price.

LIMITATION OF LIABILITY : 3M and seller will not be liable for any loss or damage arising from this 3M product, whether direct , indirect , special , incidental or consequential , regardless of the legal theory asserted , including warranty , contract , negligence or strict liability .

For Additional Health and Safety Information

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1-877-666-2277 (1-877-MMM-CARS)

Material Safety Data Sheets and Technical Data Sheets are also available by calling Fax on Demand 1-800-305-0419.

Help Line 1-800-621-5455 (US) 1-650-596-4407 (International).

3M Fax on Demand /MSDS Identification Number**Author:** Claud Cui/CN-China/3M/US**Modifiers:** Jennifer L. Kamarainen/US-Corporate/3M/US**This is the last page**