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3M Scotch-Weld™

Instant Adhesive Activators and Primers

AC09 • AC11 • AC113 • AC452 • AC77• AC79

Technical Data **January, 2015**

Product Description

3M™ Scotch-Weld™ Instant Adhesive Activators and Primers are liquid chemical products used in conjunction with 3M™ Scotch-Weld™ Instant Adhesives. 3M™ Scotch-Weld™ Instant Adhesive Activators AC09, AC11, AC113, and AC452 are activators that promote very fast curing that may be useful for the fast cure of thick bond lines and in bonding situations where the absorption of a lower viscosity cyanoacrylate into a porous substrate needs to be curtailed. These activators may also be used to "fillet-cure" Scotch-Weld cyanoacrylates and to cure adhesives outside the joint. They primarily differ in their solvent base.

Scotch-Weld™ AC77 is a cyanoacrylate primer that aids bonding to low surface energy plastic substrates. Scotch-Weld™ AC79 is cyanoacrylate primer for elastomeric substrates.

Note: These products should be tested on substrates before use since their overspray or excess may attack certain substrates (especially some plastics) causing unsightly effects.

Specific Features

- 3M™ Scotch-Weld™ Instant Adhesive Activator AC09 is a fluorinated solvent based activator that is non-flammable.
- 3M™ Scotch-Weld™ Instant Adhesive Activator AC11 is a solvent based activator that is especially suitable for use with slower curing, high viscosity grades and with porous substrates where the adhesive must cure before being absorbed into the substrate
- 3M™ Scotch-Weld™ Instant Adhesive Activator AC113 is heptane based activator. This activator will not attack plastics.
- 3M™ Scotch-Weld™ Instant Adhesive Activator AC452 is an acetone based activator that may attack some plastics.
- 3M™ Scotch-Weld™ Instant Adhesive Primer AC77 is designed for difficult-to bond, low surface energy plastics such as polypropylene, polyethylene, and PTFE. This primer needs to be applied to each low surface energy substrate surface.
- 3M™ Scotch-Weld™ Instant Adhesive Primer AC79 helps to bind elastomeric materials including silicone.

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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™ General Purpose Instant Adhesive					
	AC09	**AC11***	**AC113**	**AC452***	**AC77**	**AC79**
Color	Clear	Clear	Clear	Light Amber	Clear	Clear
Solvent	Fluorinated Ether	Hydrocarbon mixture	Heptane	Acetone	Heptane	Acetone
Appearance	Liquid	Liquid	Liquid	Liquid	Liquid	Liquid
Specific Gravity (g/ml)	1.4	0.7	0.7	0.8	0.7	0.7
Viscosity (cps) **	1	< 3	< 3	< 2	< 3	2

* Not available in the Americas Region. ** Viscosity measured by Brookfield Viscometer RVT Spindle #1 @ 30 rpm

Handling Information

Surface Preparation

Prepare bonding surfaces according to Surface Preparation recommendations for the cyanoacrylate that will be used.

Directions for Use

3M™ Scotch-Weld™ Activators (AC09, AC11, AC113, AC452):
1. Apply activator by wipe, brush, or pump spray.
2. Allow activator's solvent to evaporate completely.
3. Apply cyanoacrylate adhesive within one minute of solvent drying.
4. Reapply activator if there is a delay greater than one minute between activator drying and cyanoacrylate dispensing.

3M™ Scotch-Weld™ Primers (AC77, AC79):
1. Apply primer to all difficult-to-bond plastic or elastomeric surfaces.
2. Allow solvent to dry completely.
3. Promptly bond with a Scotch-Weld™ cyanoacrylate for plastic or elastomeric bonding.

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Storage

Store product in cool, dry area out of direct sunlight.

Shelf Life

3M™ Scotch-Weld™ Instant Adhesive Activators and Primers, can be expected to have a shelf life of one year from the date of shipment from 3M.

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.

Product Use

Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. Given the variety of factors that can affect the use and performance of a 3M product, user is solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user's method of application.

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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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