

# 3M

# Scotch-Weld™

## Instant Adhesive Activators, Primers, and Debonder

AC09 • AC12 • AC68 • AC77 • AC78 • AC79 • AC113 • AC452

Technical Data

March, 2010

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### Product Description

3M™ Scotch-Weld™ Instant Adhesive Activators, Primers, and Debonder are liquid chemical products used in conjunction with 3M™ Scotch-Weld™ Instant Adhesives. 3M™ Scotch-Weld™ Instant Adhesive Activators AC09, AC12, 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. 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™ AC78 and AC79 are cyanoacrylate primers for elastomeric substrates. Scotch-Weld™ AC68 is a cyanoacrylate debonder/cleaner.

**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.

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### 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 AC12 is isopropyl alcohol based.
- 3M™ Scotch-Weld™ Instant Adhesive Debonder AC68 attacks and dissolves cured instant adhesives. It is formulated to have a relatively low evaporation rate and can be used to debond misaligned parts, clean up excess cyanoacrylate adhesive, and remove spilled instant adhesive from work areas.
- 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 AC78 helps to bind elastomeric materials including silicone.
- 3M™ Scotch-Weld™ Instant Adhesive Primer AC79 is a California compliant version of Scotch-Weld instant adhesive primer AC78.
- 3M™ Scotch-Weld™ Instant Adhesive Activator AC113 is heptane based. Generally this activator will not attack plastics.
- 3M™ Scotch-Weld™ Instant Adhesive Activator AC452 is acetone based and will attack some plastics.

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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™ Instant Adhesive Activators, Primers, and Debonder							
	AC09	AC12	AC68	AC77	AC78	AC79	AC113	AC452
<b>Color</b>	Colorless to Pale Yellow	Colorless to Pale Yellow	Colorless to Pale Yellow	Colorless	Colorless	Colorless	Colorless to Pale Yellow	Colorless to Pale Yellow
<b>Solvent</b>	Fluorinated Ether	Isopropyl Alcohol	Acetone	Heptane	Heptane	Acetone	Heptane	Acetone
<b>Appearance</b>	Liquid	Liquid	Liquid	Liquid	Liquid	Liquid	Liquid	Liquid
<b>Specific Gravity (g/ml)</b>	1.43	0.79	0.95	0.80	0.68	0.79	0.68	0.79
<b>Viscosity (cps)</b>	<5	1	<5	3	<5	<5	<1	<1

### 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, AC12, 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, AC78, 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.

3M™ Scotch-Weld™ Debonder (AC68):

1. For best results, apply debonder in small amounts with repeated applications rather than one excessively large application.
2. Apply debonder and allow it to dissolve the hardened cyanoacrylate.
3. Wipe away.
4. Repeat as necessary. Results will vary depending on the thickness of the adhesive film and the substrate to which it is bonded. With patience 3M™ Scotch-Weld™ AC68 will remove the adhesive entirely.

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<b>Storage</b>	Store product in cool, dry area out of direct sunlight.
<b>Shelf Life</b>	3M™ Scotch-Weld™ Instant Adhesive Activators, Primers, and Debonder can be expected to have a shelf life of one year from the date of shipment from 3M.
<b>Precautionary Information</b>	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.
<b>Technical Information</b>	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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