



Scotch-Weld™ Primer AC77

Product Data Sheet

Updated :February 2010
Supersedes : April 2007

Product Description Scotch-Weld AC77 is a single component primer for use in conjunction with Scotch-Weld cyanoacrylates. The heptane solvent carrier has zero Ozone Depletion Potential

Typical Applications Scotch-Weld AC77 enables the bonding of difficult to bond plastics such as polypropylene, polyethylene and silicone rubber by increasing the surface energy.

Properties

Chemical Type	Heptane carrier
Appearance	Clear liquid
Specific Gravity (at 25°C)	0.7
Viscosity (cPs)	1
Flash Point (°C)	1 (highly flammable)
On Part Life	Maximum 8 hrs
Drying Time	Approximately 30secs

Application Techniques

Scotch-Weld AC77 should be applied to the area to be bonded by spraying, brushing, wiping or dipping. Wait for the solvent carrier to evaporate (normally 10-30 seconds). Apply the appropriate RITE-LOK cyanoacrylate grade to the part to be bonded and assemble.

Scotch-Weld AC77 should be applied to all bond surfaces that are made from difficult to bond plastics. For example if the bond is polypropylene to polypropylene, both surfaces should be primed. However if the bond is polypropylene to ABS, only the polypropylene surfaces needs to be primed.

Additional Product Information

Scotch-Weld AC77 acts as an accelerator with cyanoacrylate adhesives. Cure speeds of under 5 seconds are achieved with most grades.

Scotch-Weld activators and primers are formulated for use in conjunction with Scotch-Weld adhesives and sealants

Storage Conditions

Store the adhesive in a cool place away from direct sunlight. Keep lids tightly closed to avoid evaporation of the solvent carrier.

Shelf Life	12 months from date of despatch by 3M when stored in the original carton at 21°C
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Precautionary Information	Refer to product label and material Safety Data Sheet for health and safety information before using the product. For information please contact your local 3M Office. www.3M.com
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For Additional Information	To request additional information or to arrange for sales assistance, call 0870 6080050 Address correspondence to: 3M United Kingdom PLC, 3M House, 28 Great Jackson Street, Manchester, M15 4PA
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Values presented have been determined by standard test methods and are average values not to be used for specification purposes. Our recommendations on the use of our products are based on tests believed to be reliable but we would ask that you conduct your own tests to determine their suitability for your applications. This is because 3M cannot accept any responsibility or liability direct or consequential for loss or damage caused as a result of our recommendations

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