

Technical data sheet



Product: AC 11

Manufacturer: 3M DEUTSCHLAND GMBH

Product group: KLEBSTOFF

Article group: CYANACRYLAT

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3M™ SCOTCH-WELD™ LIQUID ACTIVATOR AC11

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Scotch-Weld™ Liquid Activator AC11 & Aerosol Activator AC11

Product Data Sheet

Date: November 2014
Supersedes: September 2014

Product Description

3M™ Scotch-Weld™ Liquid Activators, Aerosol Activators and Primers are liquid chemical products used in conjunction with 3M™ Scotch-Weld™ Instant Adhesives.

These activators may also be used to “fillet-cure” Scotch-Weld™ cyanoacrylates and to cure adhesives outside the joint.

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.

Key Features

3M™ Scotch-Weld™ Liquid 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™ Aerosol Activator AC11 is used where increased cure speed of Scotch-Weld™ Instant Adhesives is required. It can be either pre- or post-applied to the bond.

Properties

	AC11 Liquid
Colour	Clear
Solvent	Hydrocarbon mixture
Appearance	Liquid
Specific Gravity (g/ml)	0.7
Viscosity (cps) **	< 3

** Viscosity measured by Brookfield Viscometer RVT Spindle #1 @ 30 rpm

	AC11 Aerosol
Colour	Clear
Solvent	Heptane
Appearance	Aerosol
Propellant	Blend of propane and butane
Propellant Ratio	2:1
Specific Gravity (g/ml)	0.7
Viscosity (cps) **	< 3
Flashpoint	See MSDS

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™ Liquid Activator AC11:

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.

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

Directions for Use - 3M™ Scotch-Weld™ Aerosol Activator AC11:

Note: UNDER NO CIRCUMSTANCES SHOULD ACTIVATOR AND ADHESIVE BE MIXED DIRECTLY AS ADHESIVES.

Activator must be handled in a manner applicable to highly flammable materials and in compliance with relevant local regulations. For example, special care must be taken to void contact of the activator or its vapour with naked flame or any electrical equipment that is not flame proofed.

The carrying solvent can affect certain plastics or coatings.

It is recommended to check all surfaces for compatibility before use.

Avoid prolonged or repeated skin contact.

Use only in a well ventilated area.

No smoking in presence of activator.

Directions for use

Post Activation:

1. Apply cyanoacrylate adhesive to the parts to be bonded or fixed.
2. Apply activator over adhesive by spray or by drop.
Use one drop of activator per one drop of adhesive.

Handling Information

Directions for use

Surface Activation:

1. Apply one coating of activator to the area to be bonded by spray, brush or dipping. Contaminated surfaces may need special cleaning or degreasing prior to activation to remove any dissolvable contamination.
2. Allow the solvent time to evaporate until the surfaces are completely dry (approx. 60 sec).

Storage Conditions

Store product in cool, dry area out of direct sunlight.
The aerosol activator is classified as being HIGHLY FLAMMABLE and therefore must be stored in an appropriate manner and in compliance with relevant regulations. Do not store near oxidising agents or combustible materials. The activator is light sensitive and the container should be kept in a dark place when not in use.
Product shall be ideally stored in a cool, dry location in unopened containers at a temperature between 8°C to 28°C unless otherwise labelled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused product, do not return any material to its original container.

Shelf Life

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 information please contact your local 3M Office. www.3M.com

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

Important Notice

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 to the user's method or application. All questions of liability relating to this product are governed by the terms of the sale subject, where applicable, to the prevailing law

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 result of our recommendation

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