

## 3M™ Adhesion Promoter AC-160

AC-160 is a waterborne adhesion promoter for bonding polysulfide sealants to a variety of metal, composite, and solvent-sensitive substrates. A blend of water and coupling agent, AC-160 accelerates adhesion development and enhances sealants' ability to bond to aged or low-energy surfaces.



### Surface Preparation

For best results, dirt, grease, oils, fingerprints, etc., should be removed from surfaces to be bonded by solvent wiping just prior to application of adhesion promoter. Use clean solvent that is compatible with the substrate and clean, approved cloths, such as those specified by AMS3819. Carefully pour solvent onto the cloth to avoid contaminating the solvent supply. Clean only a small area at a time, quickly wiping it dry with another clean cloth before the solvent evaporates. Turn cleaning cloth frequently to prevent redeposition of contaminants.

### Benefits

- Compatible with 3M Aerospace polysulfide sealants
- Accelerates adhesion of sealants to metal, composite, and coated substrates.
- Waterborne formula for surfaces that are sensitive to organic solvents
- Enables more robust adhesion of sealants to challenging substrates
- One component product for easy application

### Physical & Performance Properties

<b>Color</b>	Pink
<b>180° Peel Strength*</b>	
<b>Substrate</b>	<b>Typical Value</b>
AMS-C-27725 TY 2 (Polyurethane)	68 lbf/in
AMS2629 TY 1 JRF / 3% NaCl	(299 N/25 mm)
7 days, 140°F (60°C)	100% Cohesive
AMS-C-27725 TY 2 – Aged	66 lbf/in
Non-immersed	(288 N/25 mm)
	100% Cohesive
AMS-C-27725 TY 2 - Aged	68 lbf/in
AMS2629 TY 1 JRF / 3% NaCl	(299 N/25 mm)
7 days, 140°F (60°C)	100% Cohesive
AMS4911 (Titanium)	59 lbf/in
AMS2629 TY 1 JRF / 3% NaCl	(257 N/25 mm)
7 days, 140°F (60°C)	100% Cohesive
MIL-PRF-23377 (Epoxy Primer - solvent)	64 lbf/in
3% Aqueous NaCl	(282 N/25 mm)
7 days, 140°F (60°C)	100% Cohesive
MIL-PRF-85582 (Epoxy Primer - water)	65 lbf/in
3% Aqueous NaCl	(286 N/25 mm)
7 days, 140°F (60°C)	100% Cohesive

\* In accordance with specification AMS3100, Class 3

## Application Instructions

3M™ Adhesion Promoter AC-160 may be applied to clean, dry surfaces with a gauze, cloth, or brush. AC-160 should be applied sparingly to the surface to produce a transparent and uniform pink tint. Excess adhesion promoter should be wiped off while still wet with a clean cloth or gauze. Allow adhesion promoter to air dry for 15 - 30 minutes before applying sealant. For best results, apply sealant to the adhesion promoted surface within 4 hours. If sealant is not applied within 24 hours, reclean the surface and reapply the adhesion promoter.

## Shelf Life and Storage

The shelf life of 3M™ Adhesion Promoter AC-160 is 6 months from date of packaging, when stored between 40°F (4.4°C) and 80°F (27°C) in the original unopened containers. AC-160 is waterborne and should not be exposed to freezing conditions. The product should not be used if it appears cloudy.

*Note: The shelf life and storage conditions listed in this Technical Data Sheet are based on product capability and align with the 3M Standard internal specification. Other industry and/or OEM specifications to which the product is qualified may establish different storage requirements. The information shown on the product label and/or the accompanying Certificate of Analysis (COA) takes precedence over the Technical Data Sheet.*

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