



# Technical Data Sheet

## 3M™ Scotch-Weld™ Instant Adhesive Primer AC77



[Product Details](#)



[Regulatory Info/SDS](#)

### **Product Description**

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

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

### **Product Features**

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.

### **Technical Information Note**

The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

### **Typical Uncured Physical Properties**

Attribute Name	Value
Color	Clear <sup>1</sup>
Viscosity	3 cP <sup>2</sup>

<sup>1</sup> Colors may vary from nearly white to yellow/amber. Adhesive performance is not affected by color variation.

<sup>2</sup> Viscosity measured by Brookfield Viscometer RVT Spindle #1 @ 30 rpm

### **Typical Physical Properties**

Attribute Name	Value
Appearance	Liquid
Solvent Resistance	Heptane
Specific Gravity	0.7 g/mL

### **Handling/Application Information**

#### **Directions for Use**

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.

#### **Surface Preparation**

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

### **Storage and Shelf Life**

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

Product retains its performance and properties for 21 months from date of manufacture when stored at 60° to 80°F (16° to 27°C) in the original unopened container.

## **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.

## **Automotive Disclaimer**

**Select Automotive Applications:** This product is an industrial product and has not been designed or tested for use in certain automotive applications, such as automotive electric powertrain battery or high voltage applications, which may require the product to be manufactured in a IATF certified facility, meet a Ppk of 1.33 for all properties, undergo an automotive production part approval process (PPAP), or fully adhere to automotive design or quality system requirements (e.g., IATF 16949 or VDA 6.3). Customer assumes all responsibility and risk if customer chooses to use this product in these applications.

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## **ISO Statement**

This product was manufactured under a quality system registered to ISO 9001 standards.

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