

# 3M™ Adhesion Promoter AC-137 Red

## Product Description

3M™ Adhesion Promoter AC-137 Red is an adhesion promoter for 3M™ Aerospace Sealant AC-251 Class B Gray and Black used on metal, polycarbonate, acrylic, glass and/or solvent-resistant coatings. It contains mixed solvents blended with a surfactant, which produce an effective adhesion promoter.

## Typical Physical and Application Properties

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

<b>Color</b>	Pale Red
<b>Flammability</b>	Flammable, Flash Point 55°F Setflash closed cup
<b>Drying Time</b>	Less than 1 minute
<b>Overcoat Time</b>	Between 15 minutes and 4 hours
<b>Crazing</b>	
<b>On Annealed Acrylic</b>	None (3000 psi / 30 min / 77°F)
<b>On Polycarbonate</b>	None (5000 psi / 30 min / 77°F)

## Surface Preparation

For maximum adhesion, clean surfaces with an appropriate solvent (reclaimed solvents should not be used) to remove dirt, grease and processing oils just prior to application. Use approved cheesecloth, or equivalent, that is free of dirt, oil and soap. Turn cloth frequently to prevent recontamination. Always pour solvent onto the cloth to avoid contaminating the solvent supply.

Clean only a small area at a time, quickly wiping it dry, before the solvent evaporates, with another clean cloth to prevent redeposition of oil, wax or other contaminants.

## Application Instructions

3M™ Adhesion Promoter AC-137 Red may be applied to solvent-cleaned surfaces with a clean brush or gauze. Excess should be wiped off-while still wet-with clean gauze sponges. The surface should remain a uniform light red color. Wait at least 15 minutes before applying sealant. Surface preparation and adhesion promoter application procedure should be repeated if sealant is not applied within 4 hours

## Health and Safety Precaution

3M™ Adhesion Promoter AC-137 Red is safe to use and apply when recommended precautions are followed. Before using this product, read and understand the Material Safety Data Sheet (MSDS), which provides information on health, physical and environmental hazards, handling precautions and first aid recommendations. An MSDS is available on request.

## Storage

The shelf life of 3M™ Adhesion Promoter AC-137 Red is 12 months from date of manufacture between 40°F and 90°F in the original unopened bottles. Storage at lower temperatures increases shelf life. 3M AC-137 Red Promoter is hygroscopic and will become cloudy due to hydrolysis. The product should be disposed of when it becomes cloudy.

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## For Additional Information

In the U.S., call toll free 1-800-235-2376, or fax 1-800-435-3082 or 651-737-2171. For U.S. Military, call 1-866-556-5714. If you are outside of the U.S., please contact your nearest 3M office or one of the following branches:

<b>Australia</b> 61-2-498-9711 tel 61-2-498-9710 fax	<b>Austria</b> 01-86686-298 tel 01-86686-229 fax	<b>Brazil</b> 55 19 3838-7876 tel 55 19 3838-6892 fax	<b>Canada</b> 800-410-6880 ext. 6018 tel 800-263-3489 fax
<b>China</b> 86-21-62753535 tel 86-21-62190698 fax	<b>Denmark</b> 45-43-480100 tel 45-43-968596 fax	<b>France</b> 0810-331-300 tel 30-31-6195 fax	<b>Germany</b> 02131-14-2344 tel 02131-14-3647 fax
<b>Italy</b> 02-7035-2177 tel 02-7035-2125 fax	<b>Japan</b> 03-3709-8245 tel 03-3709-8743 fax	<b>Korea</b> 02-3771-4114 tel 02-786-7429 fax	<b>Netherlands</b> 31-71-5-450-272 tel 31-71-5-450-280 fax
<b>South Africa</b> 11-922-9111 tel 11-922-2116 fax	<b>Spain</b> 34-91-321-6000 tel 34-91-321-6002 fax	<b>Switzerland</b> 01-724-9114 tel 01-724-9068 fax	<b>United Kingdom</b> (0) 161-237-6174 tel (0) 161-237-3371 fax

## Technical Information

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.

## Product Use

Many factors beyond 3M's control and uniquely within user's knowledge and control can affect the use and performance of a 3M product in a particular application. Given the variety of factors that can affect the use and performance of a 3M product, user is solely responsible for evaluating the 3M product and determining whether it is fit for a particular purpose and suitable for user's method of application.

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These products were manufactured under a 3M Quality Management System registered to the AS9100 standard.



### Aerospace and Aircraft Maintenance Department

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