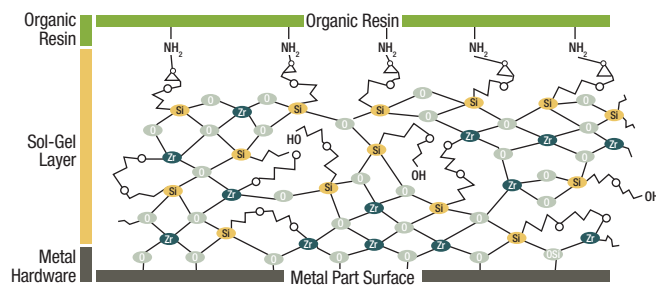




3M™ Surface Pre-treatment AC-130

Description

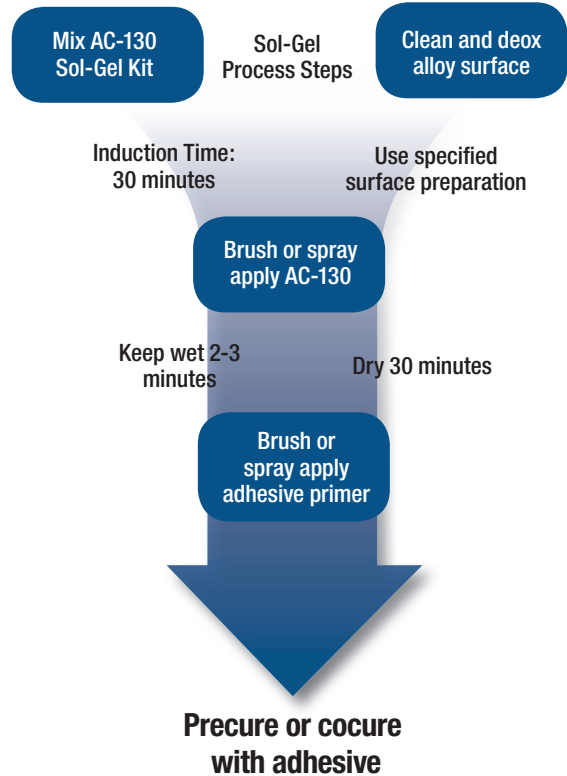
3M™ Surface Pre-treatment AC-130 is a high-performance sol-gel surface preparation for adhesive bonding of aluminum alloys, steel, titanium and composites. 3M AC-130 promotes enhanced adhesion as a result of the chemical interaction at the interfaces between the metal, the AC-130 and the primer.



Product Benefits

- Enables all metallic substances to be prepared with a single method.
- Reduces hazardous materials from the bonding surface preparation process.
 - Environmentally alternative to Acid Paste.
 - Etches, Grit Blast Silane and Phosphoric Acid anodizing. (PACS)
- Available in 4-part (AC-130) and 2-part (AC-130-2) configurations.
- Provides a variety of applications methods to suit your needs: brush, spray, dip or wipe.
- Available in kit sizes for specific applications; 50ml, 100ml, 500ml and 1 liter.
- Ambient-temperature curing makes field repairs possible.
- Process time savings over Grit Blast Silane, PACS and PANTA.
- Reduction in process flow time yields a minimum of a 35% reduction in labor-time.

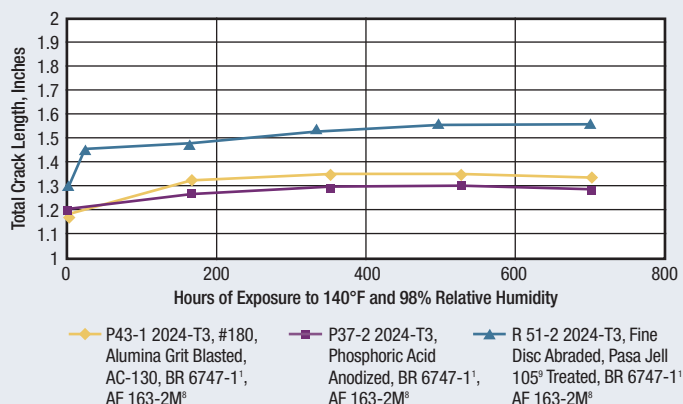
AC-130 Process



Surface Treatment Comparison

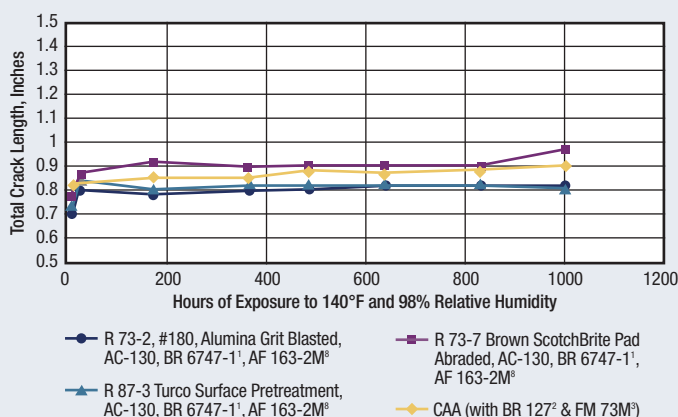
Aluminum Bonding 2024-T3

Wedge Crack Exposure Data



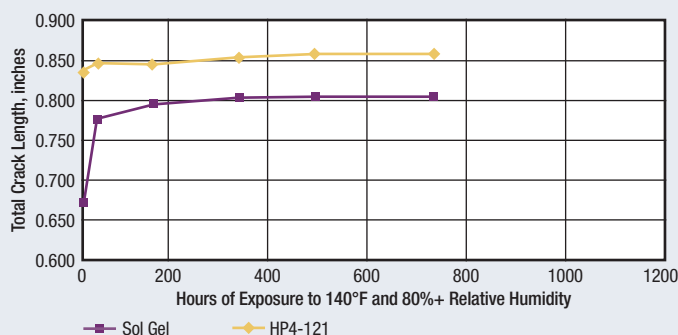
Titanium Bonding Ti-6Al-4V

Wedge Crack Exposure Data



Steel Bonding AM355 Stainless

Comparison of wedge crack extension



Note: Bonded with BR® 6747-1¹ primer and FM94⁴ adhesive

Note: HP 4-121 is a ferric chloride (FCHAE) etch process

3M Stock Numbers & National Stock Numbers

Product	3M ID	NSN	Size	Packaging
3M Surface Pre-Treatment AC-130	70-0052-0010-3	6850-01-504-5763	500 ML KIT	10/CASE
3M Surface Pre-Treatment AC-130	70-0052-0006-1	6850-01-505-8844	100 ML KIT	10/CASE

¹BR® 6747-1 Water-based Adhesive Bonding Primer System

²BR® 127 Corrosion Inhibiting Primer

³FM® 73 Epoxy Film Adhesive

⁴FM® 94 Modified Epoxy Film

⁵Turco® Surface Pretreatment

⁶3M™ Scotch-Weld™ Structural Adhesive Film AF 163-2M

⁷Semco® Pasa-Jell 105

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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