



Scotch-Weld™ Liquid Activator AC11

Product Data Sheet

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Supersedes: April 2007

Product Description Scotch-Weld AC11 is a solvent- based activator formulated to increase the cure speed of Scotch-Weld cyanoacrylate adhesives.

Typical Applications Scotch-Weld AC11 is used to give instant, “on-demand” curing of Scotch-Weld cyanoacrylates. It 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.
Scotch-Weld AC11 may also be used to “fillet-cure” Scotch-Weld cyanoacrylates and to cure adhesives outside the joint.

Properties

Chemical Type	Organic solvent base
Appearance	Clear liquid
Specific Gravity (at 25°C)	0.7
Viscosity (cPs)	1
Flash Point (°C)	<15(highly flammable)
On Part Life	Maximum 1minute
Drying Time	Approximately 30secs

Application Techniques

Scotch-Weld AC11 should be applied to the area to be bonded by brushing, wiping or dipping. Wait for the solvent carrier to evaporate (normally 10-30 seconds). Apply the appropriate Scotch-Weld cyanoacrylate grade to the part to be bonded and assemble. AC11 has an on part life of approximately 1 minute. If the parts are not assembled within 1 minute, AC11 should be re-applied.

Alternatively, assemble parts using Scotch-Weld cyanoacrylate then apply AC11to the exposed joint to cure the adhesive instantly.

Additional Product Information

The speed of cure with Scotch-Weld AC11 activator will depend on the substrates being bonded and the adhesive grade.

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

Storage Conditions

Store the adhesive in a cool place away from direct sunlight.
Keep lids tightly closed to avoid evaporation of the solvent carrier.

Shelf Life	12 months from date of despatch by 3M when stored in the original carton at 21°C
Precautionary Information	Refer to product label and material Safety Data Sheet for health and safety information before using the 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
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