



Technical Data Sheet

3M™ Scotch-Weld™ General Purpose Instant Adhesive Accelerator AC113



[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.

3M™ Scotch-Weld™ Instant Adhesive Activators AC09, AC11, AC113, and AC452 are activators that promote very fast curing that may be useful for the fast cure of thick bond lines and in bonding situations where the absorption of a lower viscosity cyanoacrylate into a porous substrate needs to be curtailed. These activators may also be used to “fillet-cure” Scotch-Weld cyanoacrylates and to cure adhesives outside the joint. They primarily differ in their solvent base.

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 Activator AC113 is heptane based activator. This activator will not attack plastics.

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 ¹
Viscosity	3 cP ²

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

² 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 activator by wipe, brush, or pump spray.
2. Allow activator's solvent to evaporate completely.
3. Apply cyanoacrylate adhesive within one minute of solvent drying.
4. Reapply activator if there is a delay greater than one minute between activator drying and cyanoacrylate dispensing.

Surface Preparation

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

Storage and Shelf Life

Store under normal conditions of 16° to 27°C (60° to 80°F) in the original, unopened packaging, out of direct sunlight. For best performance, use this product within 12 months from date of manufacture.

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

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 3M quality system registered to ISO 9001 standards.

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