July 2026
Supersedes version dated February 2012

3M Science. Applied to Life.™

3M™ Adhesion Promoter AC-137 Red

Technical Data Sheet

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



3M™ Adhesion Promoter AC-137 Red is a solvent-based adhesion promoter developed for bonding aerospace polysulfide sealants to a variety of metals and coatings. It may also be used to prepare aircraft transparency surfaces, including polycarbonate, acrylic, and glass for sealing with 3M™ Aerospace Sealant AC-251 Black.

Key Features

- Accelerates adhesion development of sealants to various substrates
- Enhances ability of sealants to bond to low-energy and aged surfaces
- One component product requires no mixing
- Tinted red for visibility upon application

180° Peel Strength[1]

100% cohesive failure, all specimens

Substrate[2]	Immersion Fluid[3]	Conditioning[4]	Load lbf/inch (N/25 mm)
AMS 4911 Titanium Alloy	JRF/Salt Water	7 days at 140 °F (60 °C) 70 days at 140 °F (60 °C)	33 (140) 36 (160)
MIL-PRF-5425 Acrylic	None	None Aged AC-137	20 (90) 26 (110)
AMS-C-27725 Fuel Tank Coating	JRF/Salt Water	7 days at 140 °F (60 °C) Aged AC-137, 7 days at 140 °F (60 °C) 70 days at 140°F (60 °C)	43 (190) 32 (140) 41 (180)
Aged AMS-C-27725 Fuel Tank Coating	None	None Aged AC-137	27 (120) 31 (140)
	JRF/Salt Water	7 days at 140°F (60 °C) Aged AC-137, 7 days at 140°F (60 °C) 70 days at 140°F (60 °C)	36 (160) 39 (170) 41 (180)
MIL-PRF-23377 Epoxy Primer, High-Solids	Water Salt Water	7 days at 140°F (60 °C) 7 days at 140°F (60 °C)	35 (150) 34 (150)
MIL-PRF-85582 Epoxy Primer, Waterborne	Water Salt Water	7 days at 140°F (60 °C) 7 days at 140°F (60 °C)	34 (150) 30 (130)

[1] Tested per AMS3100 and AS5127/1 with AC-350 Class B sealant. Std Cure: 14 days at 77 °F (25 °C) and 50 % Relative Humidity.
[2] Aged AMS-C-27725 coating was artificially aged by exposure to elevated temperatures and immersion in JRF per AMS3100.
[3] JRF: AMS2629, Type 1, Jet Reference Fluid; Salt Water: 3% aqueous solution of NaCl; Water: ASTM D1193, Type IV reagent grade.
[4] Aged AC-137: Panels stored at 77 °F (25 °C) for 24 hours following application of AC-137 Red, prior to application of sealant.

Surface Preparation

For best results, remove dust, grease, oils, fingerprints, etc., from surfaces to be sealed by solvent wiping prior to the application of adhesion promoter. Use approved solvent that is compatible with the substrate and clean cloths, such as those specified by AMS3819. Dampen the cloth with solvent from a dispensing bottle or secondary container to avoid contaminating the solvent supply. Clean one small area at a time, quickly wiping it dry with another clean cloth before the solvent evaporates. Turn cleaning cloth frequently to prevent redeposition of contaminants.

Application Instructions

3M™ Adhesion Promoter AC-137 Red may be applied to clean, dry surfaces with a gauze, cloth, or brush. AC-137 should be applied sparingly to the surface to produce a transparent and uniform pink tint. Excess adhesion promoter should be wiped off while still wet with a clean cloth or gauze. Allow adhesion promoter to air dry for a minimum of 15 minutes before applying sealant. For best results, apply sealant to the adhesion promoted surface within 2 hours. If sealant is not applied within 24 hours, reclean the surface and reapply the adhesion promoter.

Shelf Life and Storage

The shelf life of 3M™ Adhesion Promoter AC-137 is 12 months from date of batch manufacture, when stored between 40˚F and 90˚F in the original unopened containers.

NOTE: Industry and/or OEM specifications to which the product is qualified may establish different storage requirements. The information shown on the product label and/or the accompanying Certificate of Analysis (COA) takes precedence over the Technical Data Sheet.

Precautionary Information: Refer to Product Label and Safety Data Sheet for health and safety information before using this product. For additional health and safety information, visit www.3m.com/3M/en_US/company-us/SDS-search/

Authorization to Use: Ensure products meet all applicable specifications, standards, and maintenance manual requirements for the platform being worked on and validate all aircraft approvals against current technical documentation.

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

Technical Information: The technical information, guidance, and other statements contained in this document or otherwise provided by 3M are based upon records, tests, or experience that 3M believes to be reliable, but the accuracy, completeness, and representative nature of such information is not guaranteed. Such information is intended for people with knowledge and technical skills sufficient to assess and apply their own informed judgment to the information. No license under any 3M or third party intellectual property rights is granted or implied with this information. **Product Selection and 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. As a result, customer is solely responsible for evaluating the product and determining whether it is appropriate and suitable for customer's application, including conducting a workplace hazard assessment and reviewing all applicable regulations and standards (*e.g.*, OSHA, ANSI, etc.). Failure to properly evaluate, select, and use a 3M product and appropriate safety products, or to meet all applicable safety regulations, may result in injury, sickness, death, and/or harm to property. **Warranty, Limited Remedy, and Disclaimer**: Unless a different warranty is specifically stated on the applicable 3M product packaging or product literature (in which case such warranty governs), 3M warrants that each 3M product meets the applicable 3M product specification at the time 3M ships the product. 3M MAKES NO OTHER WARRANTIES OR CONDITIONS, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OR CONDITION OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE, OR ARISING OUT OF A COURSE OF DEALING, CUSTOM, OR USAGE OF TRADE. If a 3M product does not conform to this warranty, then the sole and exclusive remedy is, at 3M's option, replacement of the 3M product or refund of the purchase price. **Limitation of Liability**: Except for the limited remedy stated above, and except to the extent prohibited by law, 3M will not be liable for any loss or damage arising from or related to the 3M product, whether direct, indirect, special, incidental, or consequential (including, but not limited to, lost profits or business opportunity), regardless of the legal or equitable theory asserted, including, but not limited to, warranty, contract, negligence, or strict liability.

Automotive & Aerospace Solutions Division
3M Center
St. Paul, MN 55144-1000
Phone 1-800-235-2376
Web www.3M.com/aerospace

AC-137 Red
Issue date: 7/2026

3M is a trademark of 3M Company
© 3M 2026. All rights reserved.