



Rite-Lok™

Cyanoacrylate Activators, Primers, and Debonder

AC12 • AC68 • AC77 • AC78 • AC79 • AC113 • AC452

Technical Data

December, 2007

Product Description

Rite-Lok™ Cyanoacrylate Activators, Primers, and Debonder are liquid chemical products used in conjunction with Rite-Lok™ Cyanoacrylate Adhesives. Rite-Lok™ Cyanoacrylate Activators AC12, 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. They primarily differ in their solvent base. Rite-Lok™ AC77 is a cyanoacrylate primer that aids bonding to low surface energy plastic substrates. Rite-Lok™ AC78 and AC79 are cyanoacrylate primers for elastomeric substrates. Rite-Lok™ AC68 is a cyanoacrylate debonder/cleaner.

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.

Specific Features

- Rite-Lok™ Cyanoacrylate Activator AC12 is isopropyl alcohol based.
- Rite-Lok™ Cyanoacrylate Debonder AC68 attacks and dissolves cured cyanoacrylates. It is formulated to have a relatively low evaporation rate and can be used to debond misaligned parts, clean up excess cyanoacrylate adhesive, and remove spilled cyanoacrylate from work areas.
- Rite-Lok™ Cyanoacrylate Primer AC77 is designed for difficult-to-bond, low surface energy plastics such as polypropylene, polyethylene, and PTFE. This primer needs to be applied to each low surface energy substrate surface.
- Rite-Lok™ Cyanoacrylate Primer AC78 helps to bind elastomeric materials including silicone.
- Rite-Lok™ Cyanoacrylate Primer AC79 is a California compliant version of Rite-Lok cyanoacrylate primer AC78.
- Rite-Lok™ Cyanoacrylate Activator AC113 is heptane based. Generally this activator will not attack plastics.
- Rite-Lok™ Cyanoacrylate Activator AC452 is acetone based and will attack some plastics.

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Typical Uncured Physical Properties

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

	Rite-Lok™ Cyanoacrylate Activators, Primers, and Debonder						
	AC12	AC68	AC77	AC78	AC79	AC113	AC452
Color	Colorless	Colorless to Pale Yellow	Colorless	Colorless	Colorless	Colorless Pale Yellow	Colorless to
Solvent	Isopropyl Alcohol	Acetone	Heptane	Heptane	Acetone	Heptane	Acetone
Appearance	Liquid	Liquid	Liquid	Liquid	Liquid	Liquid	Liquid
Specific Gravity	0.79	0.95	0.80	0.68	0.79	0.68	0.79
Viscosity (cP)	1	<5	3	<5	<5	<1	<1

Handling Information

Surface Preparation

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

Directions for Use

Rite-Lok™ Activators (AC12, AC113, AC452):

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.

Rite-Lok™ Primers (AC77, AC78, AC79):

1. Apply primer to all difficult-to-bond plastic surfaces.
2. Allow solvent to dry completely.
3. Promptly bond with a Rite-Lok™ cyanoacrylate for plastic bonding.

Rite-Lok™ Debonder (AC68):

1. For best results, apply debonder in small amounts with repeated applications rather than one excessively large application.
2. Apply debonder and allow it to dissolve the hardened cyanoacrylate.
3. Wipe away.
4. Repeat as necessary. Results will vary depending on the thickness of the adhesive film and the substrate to which it is bonded. With patience Rite-Lok™ AC68 will remove the adhesive entirely.

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Storage	Store product in cool, dry area out of direct sunlight.
Shelf Life	Twelve months when stored at 60° to 80°F (16° to 27°C) in the original unopened container.
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 or (651) 737-6501.
Product Use	All statements, technical information and recommendations contained in this document are based upon tests or experience that 3M believes are reliable. However, many factors beyond 3M's control can affect the use and performance of a 3M product in a particular application, including the conditions under which the product is used and the time and environmental conditions in which the product is expected to perform. Since these factors are uniquely within the user's knowledge and control, it is essential that the user evaluate the 3M product to determine whether it is fit for a particular purpose and suitable for the user's method of application.
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ISO 9001:2000

This product was manufactured under a quality system registered to ISO 9001:2000 standards.



Industrial Adhesives and Tapes Division

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Printed in U.S.A.
©3M 2007 78-9236-7174-3 (12/07)