

3M™ Adhesion Promoter AC-137 Clear

Product Description

3M™ Adhesion Promoter AC-137 Clear is an adhesion promoter for 3M™ Polysulfide Sealant AC-251 Class B Gray and Black used on polycarbonate, acrylic, glass, metal and/or solvent-resistant coatings. It contains mixed solvents blended with a surfactant, which produce an effective adhesion promoter.

Typical Physical and Application Properties

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

Color	Clear
Flammability	Flammable, Flash Point 55°F Setaflash closed cup
Drying Time	Less than 1 minute
Overcoat Time	Between 15 minutes and 4 hours
Crazing	
On Annealed Acrylic	None (3000 psi / 30 min / 77°F)
On Polycarbonate	None (5000 psi / 30 min / 77°F)

Surface Preparation

For maximum adhesion, clean surfaces with an appropriate solvent (reclaimed solvents should not be used) to remove dirt, grease and processing oils just prior to application. Use approved cheesecloth, or equivalent, that is free of dirt, oil and soap. Turn cloth frequently to prevent recontamination. Always pour solvent onto the cloth to avoid contaminating the solvent supply.

Clean only a small area at a time, quickly wiping it dry, before the solvent evaporates, with another clean cloth to prevent redeposition of oil, wax or other contaminants.

Application Instructions

3M™ Adhesion Promoter AC-137 Clear may be applied to solvent-cleaned surfaces with a clean brush or gauze. Excess should be wiped off-while still wet-with clean gauze sponges. Wait at least 15 minutes before applying sealant. Surface preparation and adhesion promoter application procedure should be repeated if sealant is not applied within 4 hours.

Health and Safety Precaution

3M™ Adhesion Promoter AC-137 Clear is safe to use and apply when recommended precautions are followed. Before using this product, read and understand the Material Safety Data Sheet (MSDS), which provides information on health, physical and environmental hazards, handling precautions and first aid recommendations. An MSDS is available on request.

Storage

The shelf life of 3M™ Adhesion Promoter AC-137 Clear is 12 months from date of manufacture between 40°F and 90°F in the original unopened bottles. Storage at lower temperatures increases shelf life. 3M AC-137 Clear Promoter is hygroscopic and will become cloudy due to hydrolysis. The product should be disposed of when it becomes cloudy.



3M™ Adhesion Promoter AC-137 Clear

For Additional Information

In the U.S., call toll free 1-800-235-2376, or fax 1-800-435-3082 or 651-737-2171. For U.S. Military, call 1-866-556-5714. If you are outside of the U.S., please contact your nearest 3M office or one of the following branches:

Australia 61-2-498-9711 tel 61-2-498-9710 fax	Austria 01-86686-298 tel 01-86686-229 fax	Brazil 55 19 3838-7876 tel 55 19 3838-6892 fax	Canada 800-410-6880 ext. 6018 tel 800-263-3489 fax
China 86-21-62753535 tel 86-21-62190698 fax	Denmark 45-43-480100 tel 45-43-968596 fax	France 0810-331-300 tel 30-31-6195 fax	Germany 02131-14-2344 tel 02131-14-3647 fax
Italy 02-7035-2177 tel 02-7035-2125 fax	Japan 03-3709-8245 tel 03-3709-8743 fax	Korea 02-3771-4114 tel 02-786-7429 fax	Netherlands 31-71-5-450-272 tel 31-71-5-450-280 fax
South Africa 11-922-9111 tel 11-922-2116 fax	Spain 34-91-321-6000 tel 34-91-321-6002 fax	Switzerland 01-724-9114 tel 01-724-9068 fax	United Kingdom (0) 161-237-6174 tel (0) 161-237-3371 fax

Technical Information

The technical information, recommendations and other statements contained in this document are based upon tests or experience that 3M believes are reliable, but the accuracy or completeness of such information is not guaranteed.

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.

Warranty, Limited Remedy, and Disclaimer

Unless an additional warranty is specifically stated on the applicable 3M product packaging or product literature, 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 OR FITNESS FOR A PARTICULAR PURPOSE OR ANY IMPLIED WARRANTY OR CONDITION ARISING OUT OF A COURSE OF DEALING, CUSTOM OR USAGE OF TRADE. If the 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 where prohibited by law, 3M will not be liable for any loss or damage arising from the 3M product, whether direct, indirect, special, incidental or consequential, regardless of the legal theory asserted, including warranty, contract, negligence or strict liability.

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



Aerospace and Aircraft Maintenance Department

3M Center, Building 223-1N-14
St. Paul, MN 55144-1000
1-800-235-2376
www.3M.com/aerospace

3M is a trademark of 3M Company.
Please recycle. Printed in U.S.A.
©3M 2012 (2/12) All rights reserved.
60-9700-0321-0

