



# RITE-LOK™ Primer AC77

## Product Data Sheet

Updated : April 2007  
Supersedes : New

**Product Description** RITE-LOK AC77 is a single component primer for use in conjunction with RITE-LOK cyanoacrylates. The heptane solvent carrier has zero Ozone Depletion Potential

**Typical Applications** RITE-LOK AC77 enables the bonding of difficult to bond plastics such as polypropylene, polyethylene and silicone rubber by increasing the surface energy.

### Properties

<b>Chemical Type</b>	Heptane carrier
<b>Appearance</b>	Clear liquid
<b>Specific Gravity (at 25°C)</b>	0.7
<b>Viscosity (cPs)</b>	1
<b>Flash Point (°C)</b>	1 (highly flammable)
<b>On Part Life</b>	Maximum 8 hrs
<b>Drying Time</b>	Approximately 30secs

**Application Techniques** RITE-LOK AC77 should be applied to the area to be bonded by spraying, brushing, wiping or dipping. Wait for the solvent carrier to evaporate (normally 10-30 seconds). Apply the appropriate RITE-LOK cyanoacrylate grade to the part to be bonded and assemble.

RITE-LOK AC77 should be applied to all bond surfaces that are made from difficult to bond plastics. For example if the bond is polypropylene to polypropylene, both surfaces should be primed. However if the bond is polypropylene to ABS, only the polypropylene surfaces needs to be primed.

### Additional Product Information

RITE-LOK AC77 acts as an accelerator with cyanoacrylate adhesives. Cure speeds of under 5 seconds are achieved with most grades.

RITE-LOK activators and primers are formulated for use in conjunction with RITE-LOK adhesives and sealants

### Storage Conditions

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

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<b>Shelf Life</b>	12 months from date of despatch by 3M when stored in the original carton at 21°C
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<b>Precautionary Information</b>	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. <a href="http://www.3M.com">www.3M.com</a>
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<b>For Additional Information</b>	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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<b>Product Use</b>	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 the user's method or application.
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<b>Note</b>	Values presented have been determined by standard test methods and are average values not to be used for specification purposes. Our recommendations on the use of our products are based on tests believed to be reliable but we would ask that you conduct your own tests to determine their suitability for your applications. This is because 3M cannot accept any responsibility or liability direct or consequential for loss or damage caused as a result of our recommendation
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