



RITE-LOKTM Activator AC64

Product Data Sheet

Updated : April 2007
Supersedes : New

Product Description RITE-LOK AC64 is a solvent- based activator for RITE-LOK anaerobic adhesives and sealants.

Typical Applications RITE-LOK AC64 is used to accelerate the cure of anaerobic adhesives and sealants. This may be necessary in applications involving inert or 'passive' metals or substrates where cure would otherwise be slow or inhibited. Activation is also required when large bond gaps are required to be filled. RITE-LOK AC64 is also recommended when bonding applications are carried out at lower temperatures (<10°C)

Properties

Chemical Type	Hydrocarbon solvent base, copper salt
Appearance	Pale green, clear liquid
Specific Gravity (at 25°C)	~0.71
Viscosity (cPs)	~0.5
Flash Point (°C)	-5 (highly flammable)
On Part Life	≤ 30days
Drying Time	~15secs

Application Techniques RITE-LOK AC64 should be applied by spraying, brushing or dipping. AC64 should be applied to both surfaces for large gaps or lower temperature applications. Small gaps may only need one surface to be coated. More than one coating may be required for porous surfaces.

After the solvent has evaporated, apply RITE-LOK anaerobic adhesive to one or both parts and assemble immediately, moving the parts slightly to ensure mixing of the adhesive with the activated surface(s).

Additional Product Information

Never mix liquid activator with anaerobic adhesive as an exothermic reaction may occur.

Fixture times of one minute and upwards can be achieved using RITE-LOK AC64, depending on the adhesive/sealant used and the substrates and applications involved.

Due to the solvent content, RITE-LOK AC64 may attack certain plastics or coatings. Substrates should be tested for compatibility.

Storage Conditions

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

Exposure to temperatures in excess of 25°C will decrease the shelf life of the product.

Shelf Life	12 months from date of despatch by 3M when stored in the original carton at 21°C
Precautionary Information	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. www.3M.com
For Additional Information	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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Note	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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