

## Features & Benefits

- Contains no ozone depleting agent
- Accelerate cure rate of cyanoacrylates
- Faster cure through gaps
- Enables cyanoacrylates to bond to porous surfaces
- Reduces frosting or fogging of the adhesive
- Allows cyanoacrylates to cure on strongly passivated metals, aged PVC or acidic surfaces such as wood

## Description

**Permabond<sup>®</sup> QFS10** accelerates cyanoacrylate adhesive cure rate to provide a shorter set time. It can be used in a variety of applications but is particularly suited for porous parts or poorly mated parts. Permabond QFS10 cures the adhesive before it soaks into a porous surface or runs out from between parts with sizable gaps.

It can be used to accelerate cure on sensitive plastic surfaces such as polycarbonate without causing stress cracking. No discoloration of the part surface is observed when using Permabond QFS10. The activator can be sprayed on the surface or the cyanoacrylate to accelerate curing in wire tacking or similar bonding applications.

## Physical Properties

Colour	Water-white
Flashpoint	-4.4°C (24°F)
Set time 23°C (with 100cP ethyl-2-cyanoacrylate)	Steel (no gap): 5 seconds Steel (5mil gap): 40-60 seconds Steel (no gap, no QFS10): 10-15 seconds Buna-N (no gap): 10 seconds Phenolic (no gap): 5 seconds

## Storage & Handling

Storage Temperature	5 to 25°C (41 to 77°F)
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## Additional Information

Users are reminded that all materials, whether innocuous or not, should be handled in accordance with the principles of good industrial hygiene. Full information can be obtained from the Material Safety Data Sheet.

The information given and the recommendations made herein are based on our research and are believed to be accurate but no guarantee of their accuracy is made. In every case we urge and recommend that purchasers before using any product in full-scale production make their own tests to determine to their own satisfaction whether the product is of acceptable quality and is suitable for their particular purpose under their own operating conditions. THE PRODUCTS DISCLOSED HEREIN ARE SOLD WITHOUT ANY WARRANTY AS TO MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE OR ANY OTHER WARRANTY, EXPRESS OR IMPLIED.

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## Directions for Use

- Surfaces should be clean, dry and grease-free prior to primer application.
- Permabond QFS10 should be applied either by wiping (using a clean cloth or brush), spraying or dipping one component.
- Allow QFS10 to fully evaporate before bonding to make sure there isn't any solvent entrapment in the joint.
- Permabond cyanoacrylate adhesive is then applied to the untreated surface; the two parts should be quickly mated.
- Do not put the adhesive on the treated surface as the adhesive could cure before the parts can be properly mated. Only if the gap is extremely large (>20 mil) activator may be applied to both surfaces.
- For maximum bond strength, allow adhesive to cure for 24 hours at 23°C.
- Permabond QFS10 is formulated to minimize attack and maximize performance on certain plastics. However, it is recommended that the product is tested for compatibility prior to use in production.

For post-applying (e.g. for curing excess adhesive fillets or for wire tacking):

- Lightly spray or drip activator onto uncured adhesive (do not react large quantities).

**Do not mix Permabond QFS10 directly with cyanoacrylate adhesives.**

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