

PERMABOND[®] ASC 10

Anaerobic Surface Conditioner



Ref #: 022908ASC10

TYPICAL APPLICATIONS

Plated Screws
Plated Weld Nuts
Aluminum Parts-Where
Faster Cure is required

FEATURES & BENEFITS

- ◆ Contains no ozone depleting agent
- ◆ Rapid drying
- ◆ Faster cure on a variety of surfaces
- ◆ Helps remove contaminants from surfaces
- ◆ Improves cure speed at low temperatures
- ◆ Enables cure to take place on painted surfaces
- ◆ Improves cure on poorly mated parts

GENERAL DESCRIPTION

PERMABOND ASC10 Anaerobic Conditioner is a rapid drying accelerator for use with **PERMABOND** Anaerobic Adhesive/Sealants. It is designed to be used primarily on inactive surfaces such as zinc plating, cadmium plating, passivated stainless steel, gold, glass, plastic and painted surfaces. It improves the cure of anaerobic adhesives on poorly mated parts. It can also be used to increase the cure rate on less active substrates such as aluminum.

This product contains a non-halogenated solvent that is not ozone depleting. Evaporation leaves a thin deposit of initiator on the surface to be bonded. Parts can be activated up to 30 days before bonding.

Non-Warranty: 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.

No representative of ours has any authority to waive or change the foregoing provisions but, subject to such provisions, our engineers are available to assist purchasers in adapting our products to their needs and to the circumstances prevailing in their business. Nothing contained herein shall be construed to imply the non-existence of any relevant patents or to constitute a permission, inducement or recommendation to practice any invention covered by any patent, without authority from the owner of this patent. We also expect purchasers to use our products in accordance with the guiding principles of the Chemical Manufacturers Association's Responsible Care[®] program.

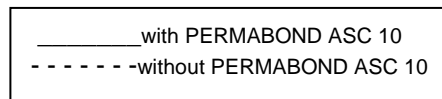
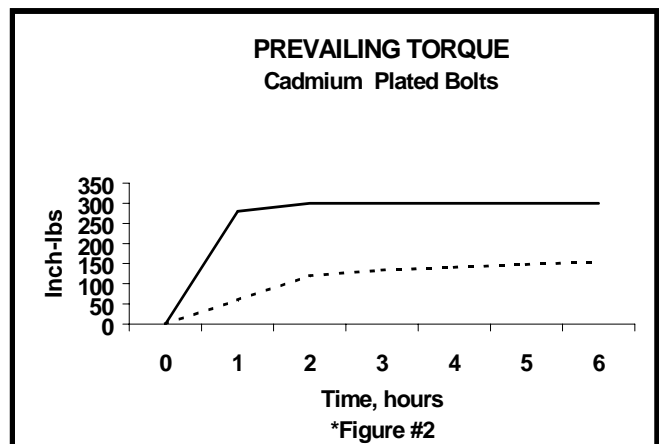
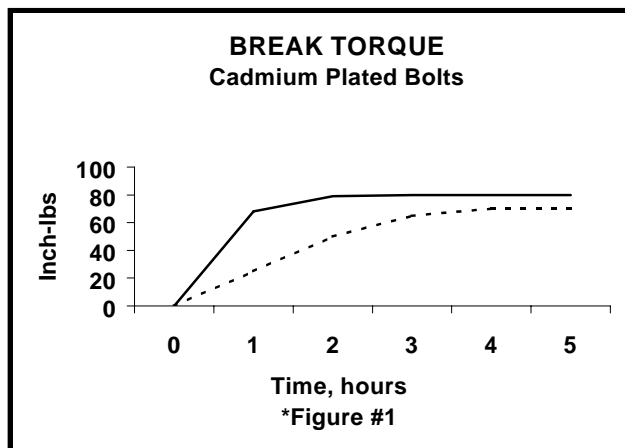
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PHYSICAL PROPERTIES OF THE CONDITIONER

Color	Blue Green
Flash Point, °C (°F)	-7 (20)
Specific Gravity	0.73
Shelf Life stored at or below 27°C (80°F), months	12

PERFORMANCE PROPERTIES

Figures #1 and #2 show the relative locking torque developed on cadmium plated bolts with and without **PERMABOND ASC10** Anaerobic Surface Conditioner. As can be seen, those bolts treated with **PERMABOND ASC10** Anaerobic Surface Conditioner developed their locking strength much faster than those which were untreated. Eventually, both the treated and untreated surfaces will develop about the same amount of strength.



*Tests conducted using **PERMABOND HM128** on 3/8-16 UNC Cadmium Grade 5 bolts with a class 2 fit at 25° (77°F) cadmium plating meets QQ-P-416.

APPLICATION PROCEDURE

A thin film of Anaerobic Surface Conditioner 10 is applied to the parts to be locked, sealed or bonded. After the solvent has evaporated, a controlled amount of initiator is left behind. **PERMABOND** Anaerobic Adhesive/Sealant is then applied and the parts are quickly mated.

PERMABOND ASC10 Anaerobic Surface Conditioner can be used with all anaerobic locking, retaining, or sealing compounds. Specifically, it can be used with **PERMABOND** Anaerobic Adhesive/Sealants for locking screws and studs, for retaining bearings and shafts, for sealing threaded pipe, and for making form-in-place gaskets.

STORAGE & HANDLING

Caution: **PERMABOND ASC10** Anaerobic Surface Conditioner is extremely flammable. Keep container tightly closed. Isolate from heat, electrical equipment, sparks, open flame and other sources of ignition. Ground and bond all transfer equipment. Use non-sparking tools and equipment.

PERMABOND ASC10 Anaerobic Surface Conditioner has a shelf life of one year when stored at or below 27°C (80°F). Do not freeze. Avoid breathing vapor. Store and use only in a well ventilated area with appropriate grounding of ventilation equipment. Prevent contact with skin or eyes. If contact occurs, flush with water. For eyes, seek medical attention. Prolonged or repeated contact with the skin may cause irritation. Harmful if swallowed.

***Do not add directly to an anaerobic product as this can lead to a vigorous reaction producing excessive heat and vapors.**

FOR INDUSTRIAL USE ONLY. KEEP OUT OF REACH OF CHILDREN.