

# PERMABOND<sup>®</sup> QFS10

## Cyanoacrylate Activator



Ref ,#: 010104PBQFS10

### TYPICAL APPLICATIONS

Porous Parts  
Poorly Mated Parts  
Wire Tacking  
Reduction of Stress Cracking on Plastic Parts

### FEATURES & BENEFITS

- ◆ Contains no ozone depleting agent
- ◆ Rapid setting on closely mated parts
- ◆ 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 on wood

### GENERAL DESCRIPTION

The PERMABOND QFS 10 accelerates the cure of cyanoacrylate adhesives to provide a shorter set time. It can be used in a variety of applications but is especially useful when bonding porous 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 QFS 10. The activator can be sprayed on the surface of the cyanoacrylate to accelerate curing in wire tacking or similar bonding applications.

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PERMABOND QFS 10 contains a specially chosen initiator in a non-halogenated solvent that is not ozone depleting. This solvent evaporates quickly to leave a thin film of the initiator on the surface to be bonded.

### PHYSICAL PROPERTIES OF THE UNCURED ACTIVATOR

Color Flash Point, °C (°F) Shelf Life stored at or below 27°C (80°F), months	Water-white -4.4 (24) 12
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#### SET TIMES, seconds (no induced gap)<sup>1</sup>

Steel <sup>2</sup> Buna-N Phenolic	5 (5 mil gap: 40-60 seconds) 10 5
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Lap Shear Strength at 25°C, (77°F) psi (no induced gap) <sup>1</sup>	
Steel, 5 minutes 24 hours	1400 1600

<sup>1</sup>Tests conducted with a 100 cP ethyl-2-cyanoacrylate adhesive. PERMABOND QFS10 was applied to a single surface.

<sup>2</sup>Without PERMABOND QFS10, set time was 10-15 seconds.

### APPLICATION & DISPENSING

A thin film of PERMABOND QFS10 is applied to one of the surfaces to be bonded. PERMABOND cyanoacrylate adhesive is then applied to the untreated surface, and the two parts are 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) should activator be put on both surfaces.

### STORAGE & HANDLING

**Caution:** PERMABOND QFS10 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.

Store and use only in a well ventilated area with appropriate grounding of ventilation equipment. QFS10 has a shelf life of one year when stored at or below 27°C (80°F). Do not freeze. Avoid breathing vapor. 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.

**Caution:** Do not add directly to any cyanoacrylate adhesive as this can lead to a vigorous reaction producing excessive amount of heat and vapors.

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