

PERMABOND[®] QFS16

Cyanoacrylate Activator



Ref #: 041808PBQFS16

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
- ◆ Will not stress crack plastic surfaces
- ◆ No discoloration of part surfaces
- ◆ Reduces frosting or fogging of the adhesive
- ◆ Allows cyanoacrylates to cure on strongly passivated metals, aged PVC or acidic surfaces such as wood

GENERAL DESCRIPTION

The **PERMABOND QFS 16** 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 QFS 16** 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 16**. 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 16 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	Colorless
Flash Point	-7 (20)
Specific Gravity	0.73
Shelf Life stored at or below 27°C (80°F), months	12

SET TIMES, seconds (no induced gap)¹

Steel ²	5 (5 mil gap: 40-60 seconds)
Buna-N	10
Phenolic	5

Lap Shear Strength at 25°C, (77°F) psi (no induced gap) ¹	
Steel, 5 minutes	1400
24 hours	2400

¹⁾ Tests conducted with a 100 cP ethyl-2-cyanoacrylate adhesive. **QFS 16** was applied to a single surface.

²⁾ Without **QFS 16**, set time was 10-15 seconds.

APPLICATION & DISPENSING

A thin film of **QFS 16** 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: **QFS 16** is extremely flammable. Keep container tightly closed. Isolate from heat, electrical equipment, sparks, open flame and other sources of ignition. Ground all transfer equipment. Use non-sparking tools and equipment.

Store and use only in a well ventilated area with appropriate grounding of ventilation equipment. **QFS 16** has a shelf life of one year from date of shipment from Permabond 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 QFS 16 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.