

Permabond®

Engineering Adhesives

TECH TIPS

Permabond Anaerobic Surface Conditioner - ASC10 -FAQs

What is ASC10?

Permabond Anaerobic Surface Conditioner 10 is a fast drying activator for Permabond anaerobic adhesives and sealants. Permabond ASC 10 contains a solvent that is not ozone depleting. Evaporation of this non-halogenated solvent leaves a thin deposit of surface conditioner on the surface to be bonded. It is used to activate inactive surfaces and to speed cure or increase the gap through which anaerobic adhesives and sealants cure.

What surfaces are active? - Why does it matter?

Anaerobic adhesives and sealants cure only in the presence of metal ions. The more active the metal - the faster the cure rate. Examples are listed below.

Metal Reactivity as Related to Anaerobic Cure Speed			
Super Active	Active	Less Active	Passive
Brass Copper	Steel, Nickel, Iron, Aluminum, Zinc	Anodized aluminum, Cadmium finishes, Chrome finishes, Passivated metals, Stainless steel, Titanium	Ceramics, Glass, Painted finishes, Lacquered finishes
Very Fast Cure	Fast Cure	Slow Cure	ASC10 Needed

What is the best way to apply ASC10?

WARNING: DO NOT mix ASC10 with the anaerobic adhesive.

Apply ASC10 to clean dry surfaces by wiping, dipping or spraying. Allow the ASC10 to evaporate and apply the anaerobic adhesive to the other surface. If activating both surfaces be certain to assemble immediately after applying the adhesive. ASC10 can be applied up to 30 days prior to bonding or sealing with anaerobic adhesives.

Can I increase the maximum gap fill of anaerobic adhesive with ASC10?

ASC10 will increase the maximum gap the anaerobic adhesive will cure through. Test to ensure complete cure.

Will ASC10 increase the bond strength?

1. ASC10 will increase bond strength if low bond strength is due to incomplete cure.
2. ASC10 will not increase bond strength if complete cure is being achieved. Strength may reduce by 10%

TECH TIPS are designed to provide Permabond Distributors an efficient means of learning new information as well as a refresher on questions our lab receives frequently.
Please email laurie.gibbons@permabond.com with feedback or topics for TECH TIPS!