








## Features & Benefits

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

## Description

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

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.

## Physical Properties

Colour	Blue Green
Flashpoint	-7°C (-20°F)
Specific Gravity	0.73
Evaporation Rate	4.3*

\*Butyl acetate = 1

## 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 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 activator application.
-  Permabond ACS10 should be applied either by wiping (using a clean cloth or brush), spraying or dipping one component.
-  Allow the ASC10 to evaporate then apply the anaerobic adhesive to the untreated second component.
-  Handling time and cure speed will depend on the substrates and adhesive selected. (Handling time is the time from when the joint is assembled to the time when enough strength has developed for the joint to be handled.)
-  For maximum bond strength, allow adhesive to cure for 24 hours at 23°C.

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

**Do not mix Permabond ASC10 directly with anaerobic adhesives**

## Video Link

ASC10 directions for use:  
<https://youtu.be/ujSYyPLEJBY>



**This Technical Datasheet (TDS) offers guideline information and does not constitute a specification**