HOW TO APPLY ARON ALPHA® ADHESIVES

1. Remove oil, grease, rust, release agents, and other residue from the surface to be bonded. Degrease with a suitable solvent. Remove rust or paint with sandpaper.

2. Protective eyewear and polyethylene gloves should be worn to protect against accidental bonding of fingers or spraying adhesive into eyes. The substrates should be dry and at or above 68°F (20°C). Keep area well ventilated to remove fumes and prevent chlorosis.

3. Use as little adhesive as possible on the smallest surface to be bonded. Press two surfaces together to ensure a close fit. The setting time will vary with the materials and the adhesive used. The bond will set within a few seconds...up to a few minutes at most. Maximum strength is achieved in 24 hours.

ACHIEVING OPTIMUM BOND STRENGTH

PROPER BONDING SURFACES: Close fitting, non-porous surfaces provide the best bond. A clearance of up to .001 to .003 inches between the bonding surface is ideal. A slightly rough surface produces the best bond. For porous surfaces or wider gaps consider a higher viscosity Aron Alpha® adhesive.

PLASTIC CRACKING OR DISSOLVING: Plastics such as PS, ABS, AS, acrylics, cellulose or polycarbonate resins can swell, crack or dissolve when exposed to cyanoacrylate liquids. Avoid this by applying a very thin layer of the fastest setting formula, or use an accelerator to speed curing.

HIGH TEMPERATURES: Temperatures above 176°F (80°C) will cause failure of most cyanoacrylates. Aron Alpha® offers special high temperature resistant adhesives (400X or 400T Series) that retain bond strength up to 248°F (120°C).

IMPACT STRENGTH: Cyanoacrylates provide high tensile strength but comparatively poor resistance to peeling or impact loads. Proper design of the adhesive joint—tongue and groove or sleeve joints, and rubber inserts—will improve bond performance. Aron Alpha® 400X and 400T Series provide significantly higher impact resistance.

CHLOROSIS (BLOOMING): Cyanoacrylates can produce a white powder resin when applied in very humid conditions or when the bonded materials are immediately placed in a closed space. The cyanoacrylate liquid will volatilize from the bonded area, polymerize in the adjacent air, and attach itself to the immediate area. There are a number of ways to avoid chlorosis:

- Do not use excessive amounts of the adhesive
- Keep the environment dry and temperatures at 68°F (20°C) or higher.
- Disperse the volatilized monomer with a fan or ventilator
- Use an accelerator to speed curing.
- Use Aron Alpha® 800 series, specially formulated to minimize chlorosis
- If chlorosis occurs, remove the deposit with a dry cloth, or use a solvent that will not dissolve the substrate.

Please refer to the Aron Alpha® Cyanoacrylate Selection Guide on the previous pages to aid in the selection of the right Aron Alpha® product type for your application.

Our Technical Service Representatives are available to help determine the best Aron Alpha® product type for your process and environment, and Materials Safety Data Sheets (MSDS) on each of the Aron Alpha product types are available by calling 1-800-338-5192.
CARE AND HANDLING OF ARON ALPHA®

1. Avoid moist or humid conditions. Replace cap tightly. Store in airtight conditions with a desiccant for best results. NEVER store Aron Alpha® adhesives with an accelerator.

2. Ultraviolet rays (sunshine) will reduce the shelf life of cyanoacrylates. High temperatures can deteriorate the original bonding strength of the adhesive. Store in a cool dark location. Refrigeration at 40-50°F (5-10°C) is recommended for extended storage.

3. Aron Alpha® may instantly bond fingers and skin. Caution should be exercised and protective clothing and eyewear worn when using the adhesives. DO NOT try to pull bonded skin apart. Skin can be debonded with warm soapy water (and gentle manipulation of the bonded area to break the bond); a releasing agent, acetone, or other solvents, including Aron Alpha® debonder.

4. If Aron Alpha® comes in contact with the eye, immediately wash thoroughly with water and seek medical attention. NEVER use solvents or rub the eye. Aron Alpha® is a powerful adhesive. Keep away from infants and young children.

5. In a liquid state the adhesive may have a slightly irritating odor, so provide adequate ventilation when using it for a longer period of time. Contact our Technical Assistance Team at 1-800-338-5192 for detailed Technical Information and Materials Safety Data Sheets (MSDS).

6. Aron Alpha® will produce an exothermic reaction when it is polymerized (resinified). The exothermic reaction is particularly strong when large amounts of Aron Alpha® monomer permeates a porous material, such as a woven cloth or urethane rubber, and quickly solidifies. If an accelerator such as caustic soda or amine is contained in such materials, the exothermic reaction will take place and can give off sufficient heat to cause burns.

Disclaimer: “Seller makes no warranty, express or implied, concerning the product or merchantability or fitness thereof for any purpose except that the product shall conform to contracted specifications, and that the product does not infringe any valid United States patents. “The Buyer assumes the sole responsibility of determining the suitability of the product for the uses and application contemplated by Buyer and others. Furthermore, the Buyer assumes all risk and liabilities for results obtained by the use of the product, whether used singly or in combination with other material, except those relating solely to the use product not conforming to the contracted specifications, which non-conformity is not known to Buyer and is not discoverable by the Buyer, by testing or otherwise, prior to the use thereof by Buyer or others. Any suggestions or recommendations made by Seller concerning uses or applications of the product are believed to be reliable, but Seller makes no warranty or guarantee of results obtained since the conditions of the use and application by Buyer and others are beyond the Seller’s control.”