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AA超能胶

Aron Alpha®

瞬间强力黏合剂

QUICK-SET HIGH-STRENGTH ADHESIVE



阿隆发®

瞬间强力黏合剂

Aron Alpha (AA超能胶)由液态“Cyanoacrylate 氰基丙烯酸酯”单体(Monomer)组成,适用于几乎所有材料瞬间永久性的黏合。黏合剂薄薄的扩散在物体表面,以物体表面的水分作为固化剂,单体快速的发生固化聚合反应从而黏合材料。

AA超能胶的独有性能

Unique Properties of Aron Alpha

瞬间粘合

Instantaneous Adhesion

- 数秒内牢固的黏合材料
- 大量生产时使用的最佳黏合剂
- 多种固化时间配合你的应用
- Strongly bonds materials in seconds
- Optimum adhesives for mass production
- Various setting times available to suit your application

强大的黏合力

Strong Bonding Power

- 特别适用于小面积黏合
- 可以黏合绝大部分的材料
- 专用的表面处理剂可以黏合惰性塑胶 (PP, PE等)
- Uniquely suited for bonding small areas
- An adhesive available for almost any material
- Special primers allow bonding of difficult-to-bond materials (PP, PE etc.)

单组份

One Component

- 不需加固化剂
- 不用计量两种组分
- No curing agent needed
- No metering of two-components

广泛的黏度范围

Wide viscosity range

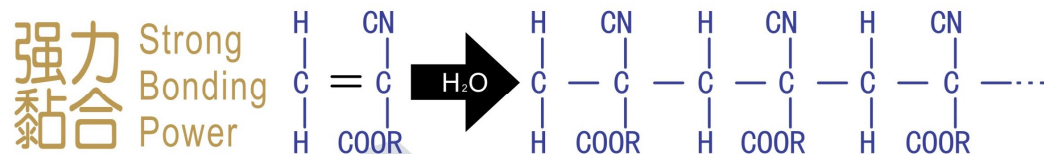
- 低黏度适用于快速渗透性黏合
- 中等黏度可防止胶水流失
- 高黏度适用于疏孔性材料和填补小的缝隙
- Low viscosity suitable for rapid and/ or penetration bonding
- Moderate viscosity to retard running of adhesive
- High viscosity for bonding porous materials and filling small gaps

其它特性

Other properties

- 无色透明的性能, 适用于珠宝和饰品的加工
- 优良的耐化学腐蚀性
- 独特安全的包装及详细的说明, 使客户安心使用
- 对于很多药品, 有较高的耐久性
- 不含溶剂, 毒性较低
- Colorless and transparent adhesive is ideal for jewelry & decorative products
- Excellent chemical resistance
- Safety Package and detailed specification for safe application
- Resistance to many kinds of chemical reagents
- No solvent, low toxic

氰基丙烯酸酯(液体)与空气中或被着体表面的水分发生反应, 以秒单位硬化。
Cyanoacrylate monomers (liquid state) react to the moisture in the air or on the surface of the material, and cure in seconds.



AA超能胶使用时的注意事项

Care in Handling

• 皮肤 Skin

必须戴安全手套(聚乙烯手套)。AA超能胶也可即时将皮肤黏合得很紧。万一不慎把手指黏合起来时,不可猛力硬拉,而要用温热水或丙酮等溶剂一点点地搓揉开来。

Use protective gloves (Polyethylene gloves). Aron Alpha may instantaneously bond your skin. If your fingers have been bonded with Aron Alpha, do not try to pull them apart vigorously, but rub the fingers in warm water, a releasing agent, acetone or other solvents. The fingers can also be pulled apart gradually.

• 眼睛 Eyes

必须戴护目镜。万一AA超能胶喷到眼睛时,应立即用大量清水洗眼, 並找医生诊治。(切勿用溶剂来洗眼, 也不可搓眼睛。)

Use eye glasses or Goggles. If Aron Alpha contacts your eyes, immediately wash the eye with lots of water and seek medical care. (Never use solvents nor rub the eye with your finger.)

• 婴儿和小孩 Babies and Children

AA超能胶具有非常强的黏合力, 为了安全, 请远离婴幼儿。
Aron Alpha has a very strong bonding power. Keep away from babies and children.

• 空气流通 Ventilating

AA超能胶为液态时, 会带点刺鼻的气味。大量使用时, 注意空气要流通。

Aron Alpha in the liquid state has a slightly irritating odor. When a large quantity of Aron Alpha is used, it is desirable to keep the room well ventilated.

• 发热反应 Exothermic reaction

AA超能胶聚合(固化)时, 会起发热反应。大量渗入于织布或发泡聚氨酯橡胶等多孔物质内的液体急剧固化时, 会产生相当大的热量, 如果其中存有苛性钠或胺等反应促进剂时, 发热反应会发生并能够释放足够的热量导致燃烧。

Aron Alpha will produce exothermic reaction when it is polymerized (resinified). The exothermic reaction is particularly strong when a lot of Aron Alpha monomer permeates a porous material such as a woven cloth or urethane rubber and then 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.

AA超能胶
Aron Alpha®

AA超能胶存放时的注意事项

How to Store Aron Alpha

• 湿度 Humidity

AA超能胶会为空气中少量水份所树脂化, 因此要特别注意湿气。要把盖子盖好, 放进装有防潮片的密封箱内, 以免接触到外面的空气。

Aron Alpha turns into a resin when it comes into contact with even a very small quantity of moisture and therefore care should be taken to avoid storing Aron Alpha in a moist or humid environment. Be sure to fasten the cap to the container tightly. Store Aron Alpha with a desiccant in an airtight box. It is not desirable to arbitrarily expose Aron Alpha to the open air.

• 阳光 Sun rays

AA超能胶暴露于紫外线里会转变为树脂。

避免阳光直射。

Aron Alpha turns into a resin when exposed to ultraviolet rays. Do not expose Aron Alpha to direct sunlight.

• 温度 Temperature

当AA超能胶存放高温地方, 其原本黏接强度便会开始降低。因此尽可能存放于低温的地方。(如须储存较长时间, 最好放进冰箱内, 调节温度约 5°C~10°C。)

When stored at high temperatures, Aron Alpha begins to lose its original bonding strength. It is advisable to store Aron Alpha at as low temperature as possible. (When storing Aron Alpha for an extended period, it is recommended to keep it refrigerated between 5°C and 10°C.)

• 其他 禁止与AA Setter一起储存

Other Never store Aron Alpha with AA Setter

禁止将AA超能胶与AA Setter一起储存。以免导致因AA Setter的挥发而引起的AA超能胶固化。

Never store Aron Alpha with AA Setter for refraining from curing with the atmosphere of AA Setter.

★ 温馨提示 (有关本目录中的数据)

Notice (Regarding the data on this catalogue)

所有数据均为东亚合成测试数据, 仅供参考, 而非保证值。实际结果在应用条件下可能会有所不同, 因此希望自行测试并判定可行性。

All data are tested result by Toagosei for reference, not warranted one.

Actual data may vary under each application condition, so test and judge the usefulness by yourself.

选用及使用AA超能胶的特殊事项

Factors to Consider in Choosing & Applying Aron Alpha Adhesives

• 黏合表面 Bonding Surfaces

吻合的接合面上, AA超能胶能提供最佳的黏合效果, 尽量避免不吻合的接合面及较大虚位。标准黏合面虚位为0.02-0.03mm, 微粗表面能提供之黏合力更佳。高黏度的AA超能胶适用于疏孔表面或者轻微的裂缝。酸性表面如电镀面, 应铲除电镀物后再进行黏合。

Close fitting, non-porous surfaces give the best bond. Avoid loose fitting surfaces and wide gaps. A clearance of 0.02 - 0.03mm between the bonded surfaces is ideal. A slightly rough (fine to medium file) surface produces the strongest bond. Porous surfaces or slight gaps consider a high viscosity Aron Alpha adhesives. Acidic surfaces such as chrome plating must be neutralized for proper adhesive curing.

• 塑胶的龟裂和分解 Plastic Cracking and/or Dissolution

一些塑胶长时间暴露于氰基丙烯酸酯单体下, 会膨胀龟裂或分解。为避免这些问题, 尽可能使用固化最快的型号, 涂很薄的黏合剂(涂厚了, 会减缓固化时间), 必要的话, 使用AA Setter。

Some plastics swell and crack, or dissolve when exposed to cyanoacrylate monomers for an extended period. Avoid this by using the fastest setting type of Aron Alpha adhesive as possible, applying only a thin layer of the adhesive (a thick layer slows down the setting time), and applying an AA Setter, if necessary.

★ 对应各种材质的溶解性 Dissolving to the materials

材料 Material	AA超能胶 Aron Alpha	催固剂 AA Setter (乙醇)	溶解液 Debonding (丙酮)	材料 Material	AA超能胶 Aron Alpha	催固剂 AA Setter (乙醇)	溶解液 Debonding (丙酮)
硬质聚氯乙烯 Hard PVC	○	○	○	硬质聚氯乙烯 Hard PVC	△	○	X
软质聚氯乙烯 Soft PVC	○	○	○	软质聚氯乙烯 Soft PVC	△	○	X
丙烯酸酯树脂 Acrylic	△	○	X	丙烯酸酯树脂 Acrylic	○	○	○
聚碳酸酯树脂 PC	△	○	X	聚碳酸酯树脂 PC	○	○	○
聚苯乙烯 PS	△	○	X	聚苯乙烯 PS	○	○	○
尼龙 Nylon	○	○	○	尼龙 Nylon	○	○	○
聚酯塑胶 Polyester	○	○	○	聚酯塑胶 Polyester	○	○	○

室温下浸渍10分钟后的状态 After 10 minutes under room temperature
△: 无变化 No change ○: 表面有轻微变化 Little change on surface X: 表面粘着 Sticky on surface

• 黏合小面积 Bond Small Areas

凝固速度高的AA超能胶, 不宜使用于宽大的接合面, 因固定接合物件所需的时间会比凝固时间还要长(参照不同的固化时间表决定哪种黏合剂适合你的用途), 使黏合效果不能产生。为了达到更佳的经济效益, 遇到接合范围过大的表面, 在受力局部地方上使用AA超能胶, 而在其它地方, 可使用慢干胶或接合力较差的胶水, 从而达到最牢固, 最经济及最省时的效果。

Fast setting Aron Alpha adhesives are not suited for application on large areas. The adhesive may set before the parts are joined. Consult the Setting Time chart to determine which adhesives are usable for your application. Spot bonding with Aron Alpha adhesives may be used to supplement slower drying and weaker adhesives applied to large areas, providing stronger bonds at critical points and for reducing clamping times.

• 高温操作 High Temperatures

大部份的AA超能胶在80°C的温度上便会失去其黏合力。特别研发的400系列的AA超能胶可在接受高达120°C的温度下保持黏合力量。
At temperatures above 80°C, most Aron Alpha adhesives will lose bonding strength. 400 series is designed to retain bonding strength at temperatures up to 120°C.

系列 Series	耐热性能标准 Standard of heat resistance
400	120°C
其他Other	80°C

• 冲击性能 Impact Strength

AA超能胶具有很高的抗拉强度, 可是在抗冲击性能及抗撕裂性能方面则表现较差。而400系列之AA超能胶则比其他系列产品高出3倍之抗冲击性能, 如需考虑到撞击性能时应使用此系列产品。

Aron Alpha adhesives have high tensile strength, but comparatively poor resistance to peeling or impact loads. Design areas of adhesion to minimize peeling or impact loads (tongue and groove joints, rubber inserts, sleeve joints, etc.). 400 series adhesives have up to 3 times the impact resistance of other Aron Alpha adhesives and should be considered where impact resistance is a factor.

材质: 铁
Material: Steel

系列 Series	冲击剥离黏合强度 (mJ/mm2) Test of resistance to peeling and impact
200	16
400	48

• 白化 Chlorosis

AA超能胶液体单体从黏合区域挥发, 与附近空气聚合黏附于紧靠区域产生白色的极细粉末树脂。在空气潮湿黏合或是黏合后的材料在固化后立刻包装入容器内易发生这种现象。可采取以下方法避免此情况:

- 适量使用AA超能胶
- 在较干爽的环境及室温约 20°C 使用
- 在黏合的周围地方使用风扇或抽气扇
- 使用AA Setter
- 800系列是无白化无气味的专门配方(参照下图)

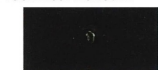
如白化情况出现, 再用干布及溶剂抹掉白化地方。
(选用不会对黏合材料造成影响的溶剂, 请参考说明书。)

A white impalpable powder resin is generated when part of the Aron Alpha liquid (monomer) volatilizes from the bonded areas, polymerizes in the adjacent air and attaches to the immediate area. This phenomenon is apt to take place when materials are bonded in a very humid atmosphere or the bonded materials are packed in containers immediately after bonding.

To prevent chlorosis:

- Do not use excessive amounts of the adhesive.
- Keep the environment dry and temperatures at 20°C or higher.
- Disperse the volatilized monomer with a fan or ventilator.
- Use an AA Setter to speed curing.
- Use Aron Alpha 800 series, specially formulated to minimize chlorosis. (refer to below image)

If chlorosis occurs, remove the deposit with a dry cloth, or use a solvent that will not dissolve the substrate (plastic). See Technical Bulletin.



AA超能胶
801效果
Effect of Aron Alpha 801



一般快干胶
产品效果
Effect of normal
instant glue

Quick-Set High-Strength Adhesives

There is an Aron Alpha adhesive suitable for instantaneous and permanent bonds to almost all materials. Aron Alpha adhesives are composed of alpha cyanoacrylate monomers (liquid state). When this adhesive is spread thinly on the surfaces to be bonded, the small quantity of moisture on the surface acts as a curing agent, rapidly turning the monomer into a solid polymer and bonding the materials.

AA超能胶
Aron Alpha®

AA超能胶系列产品有不同的黏度和特性满足各样的应用需求

All of the Aron Alpha products are available in a complete range of viscosities and characteristics to meet your specific application requirements.

系列 Series	类型 Type	特性 Characteristics	型号 Item	黏度 Viscosity (mPa.s 25℃)	特性 Characteristics (◎优良Excellent: ○良好Good: ▲不建议使用not recommended)			
					金属 Metal	电镀 Electroplating	橡胶 Rubber	塑胶 Plastics
200系列 Series	普遍通用 General use	广泛性能和实用性 Well balanced performance and usability	201	2	○	○	◎	◎
			241	40	○	○	◎	◎
			202	100	○	○	◎	◎
			203	1500	○	○	◎	◎
	快速固化 Fast curing	很短的固化时间 Fast setting time	200 (221)	2	○	○	◎	◎
			202F	100	○	○	◎	◎
			732F (232)	300	○	○	◎	◎
	特快固化 Very fast curing	特快的固化速度 Very fast setting time	200F (221F)	2	○	○	◎	◎
			适用难黏材料 Good performance for "Hard to bond material"	适用于EPDM等 Good performance with EPDM	201FC	2	○	○
	201ZC	2			○	○	◎	◎
适用于POM、TPR等 Good performance with POM、TPR、etc	221EXC	2		○	○	◎	◎	
	212EXC	100		○	○	◎	◎	
400系列 Series	触变性 Thixotropic	高浓度、无线状、防止滴漏 High viscosity; No stringness; Eliminates dripping and running	203TX	1500	○	○	○	○
			GEL-10	Gel (啫喱)	○	○	○	○
	能耐受高温及高冲击力(详见P10) High temperature and high impact resistance (Refer to P10)	适用于金属材料 Good performance with metallic materials	401XZ	2	◎	○	○	○
			412XZ	100	◎	○	○	○
			403TB	1000	◎	○	○	○
500系列 Series	低气味、低白化 Low odor, Low chlorosis	减低气味及白化程度 Reduce chlorosis and odor	501F	2	○	○	○	○
600系列 Series	耐水、耐湿 Water and moisture resistance	耐湿性能(※) 适用于电镀材料 Good performance for moisture resistance and electrofacing	601	2	○	◎	○	○
			(※)632PF	300	○	◎	○	○
800系列 Series	无气味、无白化 (详见P10) No odor, No chlorosis (Refer to P10)	无气味、无白化 No odor, No chlorosis	801	10	○	○	▲	○
			802	100	○	○	▲	○
			802F	100	○	○	▲	○
			803	1500	○	○	▲	○
900系列 Series	与橡胶黏合后, 有柔性、耐热 Flexible, Heat resistance with rubber	良好的耐高温、耐热性能、柔性 Good moisture and heat resistance, flexible	901H3	7	○	○	○	○
			911P3	10	○	○	○	○
带色品 Colored items			如需将产品染成红色、请与我们联系 When needed products can be colored red. Please contact us.					
Debondor (专用溶解液) Remover			用于去除已黏合物质及黏合剂剥落的部分 For use in removing cured substance and peeled off parts of adhesives.					

* 按照JISK6861-1995进行测试(氰基丙烯酸酯黏合剂系统测试)

* The testing method is carried out in accordance with the JISK6861-1995(a testing method of Cyanoacrylate adhesives system)

AA超能胶展示图 Image of Aron Alpha



201



带色品
Colored items



403TB



Gel-10

瞬间强力黏合剂 QUICK-SET HIGH-STRENGTH ADHESIVES

AA超能胶的凝固时间及黏合力量

Setting Time and Bonding Strength of Aron Alpha Adhesives



系列 Series	型号 Item	黏度 Viscosity (mPa s 25)	固化时间(秒) Set Time(sec)				
			聚氯乙烯树脂 PVC	丙烯酸-苯乙烯- 丁二烯 共聚物塑胶 ABS	聚碳酸酯 Polycarbonate PC	氯丁二烯 Chloroprene	三元乙丙橡胶 EPDM
200系列 Series	201	2	5	15	10	1	1
	241	40	5	60	30	1	1
	202	100	10	60	30	1	1
	203	1500	25	120	90	1	1
	200(221)	2	3	3	10	—	—
	200F(221F)	2	1	1	1	1	1
	202F	100	5	5	5	1	1
	732F(232)	300	5	5	10	1	1
	201FC	2	1	1	—	—	—
	201ZC	2	—	—	—	—	1
	221EXC	2	1	1	1	—	1
	212EXC	100	1	1	1	—	1
	203TX	1500	10	30	45	1	1
	GEL-10	Gel (啫喱)	5	15	30	15	3
400系列 Series	401XZ	2	10	—	—	—	—
	412XZ	100	10	—	—	—	—
	403TB	1000	30	10	90	—	—
500系列 Series	501F	2	10	20	30	1	1
600系列 Series	601	2	5	15	20	1	1
	632PF	300	5	15	—	5	—
800系列 Series	801	10	10	20	20	—	—
	802	100	20	45	60	—	—
	802F	100	10	15	20	—	—
	803	1500	30	60	90	—	—
900系列 Series	901H3	7	5	10	—	5	—
	911P3	10	10	20	—	5	—
带色品 Colored items	201-10R	2	5	15	10	1	1
	232-10R	300	5	5	10	1	1

* 测量至黏合材料破坏时的强度 indicates material failure.

** 铝质容器 AL tube



(100ml)

PP Primer(表面处理剂)

溶剂 (Solvent) : 庚烷 (Heptane)

使用PP Primer, 使AA超能胶可以黏合PP、PE这类难黏材料。用AA超能胶之前将PP Primer涂到PP、PE上, 可获得强大, 持久的黏合力。

Polyolefin plastics such as polyethylene and polypropylene are generally considered difficult-to-bond materials, PP Primer has been specifically developed to allow these materials to be bonded with Aron Alpha adhesives. Applying PP Primer to polyethylene, polypropylene and EPT (ethylene-propylene-terpolymer) rubber before use of Aron Alpha cyanoacrylate will result in a strong, long lasting bond.

详见P7 (Refer to page 7)



(200ml)

AA Setter(催固剂)

溶剂 (Solvent) : 乙醇 (Ethanol)

AA Setter加速AA超能胶的黏合反应, 缩短固化时间, 适用于疏孔性材料填补空隙或者防止起霜或白化。

AA Setter accelerates the bonding reaction of Aron Alpha cyanoacrylate adhesive. Use AA Setter to shorten the setting time, to bond porous materials, to fill gaps, or to prevent blooming or chrololisis.

详见P8 (Refer to page 8)

在黏合PP、PE、PU、PET、缩聚醛、尼龙、烯烃类树脂弹性体和硅胶材料时使用本公司提供的PP Primer。
For the bonding of inert plastics polypropylene, polyacetals, nylon, PET, and silicone rubber, special primers are available.

AA超能胶涂布方法

How to Apply Aron Alpha Adhesives

1. 黏合时表面去油, 油脂, 锈, 脱模剂或者其他的残渣。去油脂用合适的溶剂(看说明书), 去锈和其他固体残渣用砂纸(表面的黏合强度受限于底材的强度)。

Remove oil, grease, rust, release agents, or other residues on the surface to be bonded. Degrease with a suitable solvent (See Technical Bulletin). Remove rust and other solid residues with sandpaper (Strength of bonds on painted surfaces are limited by the bonding strength of a paint to the substrates).

2. 使用AA超能胶的工人, 应戴护眼罩及PE手套以防意外地将胶水弄入眼或黏合手指。黏合的表面应该是干透, 在室温约20℃或以上, 湿度约50%为佳, 并应有抽气扇将气味抽离。

Personnel applying adhesive should wear goggles and polyethylene gloves to prevent accidental bonding of fingers and spraying of adhesives into eyes. The surfaces to be bonded should be dry and at or above 20°C. Relative humidity below 50% gives best results. Ventilation to remove fumes is desirable.



应戴护眼罩
Should wear goggles



应戴PE手套
Should wear gloves

3. 打开盖子, 用手指把积留于容器尖端的液体弹掉(目的为疏通管道), 然后用针穿个小孔。(穿孔时液体会喷出来, 所以避免穿孔时对准。)

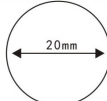
Detach cap. Flick tip of bottle to remove adhesive from puncture area. Make a small hole in the nozzle.

4. 涂抹AA超能胶只需滴在黏合的一个表面, 一般选择面积小的表面或固化慢的表面, 尽可能是方向朝上的表面, 将表面吻合贴近使黏合剂扩散在两个表面上。由于固化时间太短很难调整位置时, 考虑使用渗透性黏合(贴合表面后滴胶到裂缝中, 利用毛细原理去扩散黏合剂), 或者选择固化时间缓慢些的AA超能胶。

Apply Aron Alpha adhesives as drops or a ribbon on only one of the surfaces to be bonded. Normally choose the smaller surface, or the surface on which the time set is longer, and if possible, the upward facing surface. Closely fit the two surfaces to be bonded so that the adhesive spreads between the surfaces. When it is difficult to position the two surfaces because of the short set time, consider using penetration bonding (mate surfaces and apply drop of adhesive to crack, allowing capillary action to spread adhesive) or choose a slower setting type of Aron Alpha adhesive.

5. 小小份量便可达到理想效果, 若涂得厚, 黏接速度会相对减慢。在不疏孔的表面, 最适当份量约为5-6mg/cm², 约人民币伍角硬币大小。

Use as little Aron Alpha adhesive as possible. Surface moisture catalyzes the curing of these adhesives, so only a thin film between the surfaces to be bonded is desirable. The optimum application quantity on non-porous surfaces is 5-6mg/cm², as same size of RMB 5 Jiao.



如左图人民币伍角直径20mm
Diameter of 20mm as same size of RMB 5 Jiao at left size.

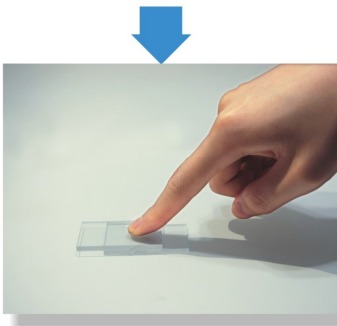
6. 与材料黏合的时间因为表面情况, 温度和湿度不同而变化。快至数秒慢至数分钟就会固化。(固化后12-24小时达到最大强度。)

The setting time varies with the materials to be bonded, the surface conditions, temperature and humidity. However, bonding will be completed from within a few seconds to a few minutes at the longest. (Maximum strength will be attained in 12 to 24 hours.)

一般接合 > How to apply



滴一滴
Apply one drop



轻按下使胶水散开
Press lightly to let glue spread

渗透式接合 > Penetration Bonding



专用小滴管 > Attachment nozzle



细小部位
专用小滴管
Attachment nozzle is useful to apply to the small position.

AA超能胶系列的基本特性
General Properties of Aron Alpha® Adhesives



基本单体 (液体状态) Monomer (Liquid State)		200系列 400系列 Series	500系列 Series	600系列 Series	800系列 Series	900系列 Series	GEL-10
	外观 Appearance (*)	无色或淡黄色液体 A colorless or pale yellow liquid					
	比重 Specific gravity (d%)	1.050	0.978	1.004	1.069	1.090	1.090
	沸点 Boiling point (°C/ 667Pa)	60 - 62	78 - 80	68	200	-	60 - 62
	闪点 Flash point (°C) (tag closed type)	83	95	77	112	83	83
	燃点 Ignition point (°C)	485	410	463	330	330	485
聚合物 (固体状态) Polymer (Solid State)	凝固点 Freezing point (°C)	-29.6	-2.1	-18.7	≤-20	≤-20	≤-20
	外观 Appearance (*)	无色或淡黄色液体 A colorless or pale yellow liquid					
	比重 Specific gravity (d%)	1.248	1.125	1.156	1.168	1.200	1.290
	硬度 Hardness (Shore D, 23 °C)	90	80	80	60	30	90
	线性膨胀系数 Rate of line expansion(x 10 ⁻⁴)	1.1	1.3	1.5	1.0	1.1	1.1
	热变形温度 Softening temperature (°C-Vicat method)	145	110	110	60	-	145
	玻璃转变温度 Glass transition point (°C)	140	125	115	80	80	140
	电介损耗角正切 Dielectric tangent (10MC, 10°C)	0.07	0.07	0.07	0.07	0.07	0.07
	介电常数 Dielectric constant (10MC, 10°C)	3.5	3.5	3.5	3.5	3.5	3.5
	击穿电压 Dielectric breakdown voltage (KV/0. 1mm, 23°C)	14	14	14	14	14	14
	体积绝缘电阻 Volume dielectric resistivity (Ωcm, 30°C)	10 ¹⁴	10 ¹⁴	10 ¹⁴	10 ¹⁴	10 ¹⁴	10 ¹⁴
	溶剂 Solvent	丙酮, 二甲基甲酰胺, 甲基亚砜 Acetone, Dimethyl formamide, Dimethyl sulfoxide					

(*) 关于颜色类型, 详情请与我们联系。Regarding colored type, please contact us.

AA Setter (专用固化促进剂) Accelerator of Aron Alpha

AA Setter 是AA超能胶的固化促进剂。具有缩短贴合时间的效果。
AA Setter is the accelerator of Aron Alpha. It is effective to shorten the bonding time.

以下情况时请使用
Please use it in below situation

- 使AA超能胶更快固化
Curing instantly
- 充填缝隙多的场所或加厚贴合
Filling gaps and potting
- 防止白化现象(粘合剂的周边发白)
Preventing the chlorosis

加厚贴合
Potting

充填贴合
Filling gap

木材贴合
Bonding woods

★ AA Setter 使用方式: Usage of AA setter (关于储存, 请参照P11. Regarding the storage, refer to P11.)

贴合前处理的方式 Before bonding

AA Setter 渗透到脱脂棉或海绵等后, 在点胶的相反面擦上一到两次。干燥后, 贴合。
Put the gauze or cotton into AA Setter, apply it to the surface of material 1 or 2 times. After made it dried, bond it with Aron Alpha.

贴合后处理的方式 After bonding

将AA Setter滴下或者以喷淋喷出去。
Apply one drop of AA Setter or spray it.

将已贴合的基材放置在AA Setter的气体里。
Put the bonded material into the package with the atmosphere of AA Setter

		拉伸强度 Tensile strength (N/mm²)				剪切强度 Tensile shear strength (N/mm²)		
铁 Iron	铝 Aluminum	聚氯乙烯 树脂 PVC	丙烯酸-苯乙烯- 丁二烯 共聚物塑胶 ABS	铁 Iron	铝 Aluminum	聚碳酸酯 PC	氯丁二烯 Chloroprene	三元乙丙橡胶 EPDM
15	15	35*	25*	32	25	7*	0.6*	0.6
45	45	35*	25*	32	25	7*	0.6*	0.6
60	60	35*	25*	32	25	7*	0.6*	0.6
90	120	35*	25*	29	23	6	0.6*	0.6
10	—	35*	25*	32	—	7*	—	—
3	3	35*	25*	32	25	7*	0.6*	0.6
30	15	35*	25*	32	25	7*	0.6*	0.6
10	10	35*	25*	32	25	7*	0.6*	0.6
3	5	35	25*	32	20	—	—	—
—	—	—	—	—	—	—	—	0.6
5	5	35	25*	43	28	7*	—	0.6
5	5	35	25*	43	28	7*	—	0.6
30	120	35*	25*	32	25	6	0.6*	0.6
20	30	27	21	30	20	6	0.6*	0.6
10	10	35	—	35	32	—	—	—
10	10	35	—	35	32	—	—	—
180	180	32	21	39	38	4	—	—
20	30	25	20	25	20	3	0.6*	0.6
15	15	30	25*	30	23	5	0.6*	0.6
15	30	30	25	28	—	—	—	—
20	20	32	18	31	27	5	—	—
45	45	32	18	31	27	5	—	—
15	15	32	18	31	27	4	—	—
60	60	32	18	31	27	4	—	—
—	—	25	—	—	—	—	0.8*	—
—	—	13	—	—	—	—	0.8*	—
15	15	35*	25*	32	25	7*	0.6*	0.6
10	10	35*	25*	32	25	7*	0.6*	0.6

测试标准
Test Standard

按照JISK6861-1995进行测试
(氰基丙烯酸酯黏合剂系统测试)

The testing method is carried out in accordance with the JISK6861-1995 (a testing method of Cyanoacrylate adhesives system)

测试环境
Measuring Conditions

23 ± 1°C ; 60 ± 2% RH

包装 Package

20g

50g

500g

20g (Gel-10)

2gx6pcs

小箱 (small box)

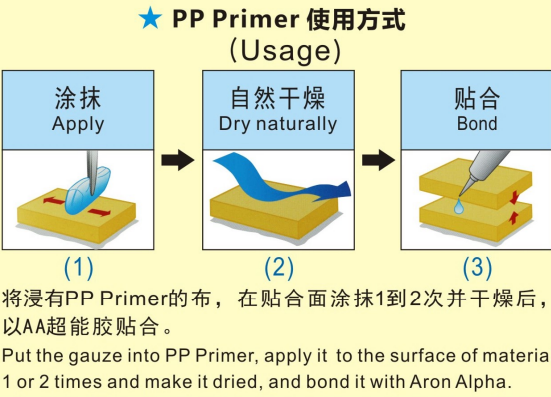
		多孔性物质 Porous			无机材料 Inorganic		橡胶 Rubber				树脂 Plastic												金属 Metal	
		皮革 Leather	纸 Paper	木材 Wood	陶瓷 Ceramic	石 Stone	乙丙二烯三元共聚物 EPDM	丁腈橡胶 Nitrile rubber / 氯丁二烯橡胶 Chloroprene Rubber	矽橡胶 Silicon Rubber	烯烃类树脂弹性体 Olefin Elastomer	聚丙烯酰胺 聚乙烯醇 PP/PE	尼龙树脂 Nylon	聚酯树脂 Polyester	硬质聚氯乙烯 Hard PVC	环氧树脂 Epoxy	聚酰胺树脂 Polyacetal	聚碳酸酯树脂 PC	丙烯酸类树脂 Acrylic	丙烯酸-苯乙烯-丁二烯三元共聚物 ABS	聚对苯二甲酸乙二醇酯 PET	电镀表面处理 Electroplating Treatment	铁 Steel / 铝 Aluminum / 不锈钢 Stainless steel		
金属 Metal	铁 Steel / 铝 Aluminum / 不锈钢 Stainless steel	202F 732F	202F 732F	732F GEL-10	202F 732F	200F 401XZ	201ZC 201FC	200 401XZ	221EXC 200F(*)	221EXC (*)	221EXC 200F(*)	200F (*)	200 401XZ	200 401XZ	200 401XZ	221EXC 200F(*)	200 401XZ	200 401XZ	200 401XZ	200F 200(*)	401XZ 632PF	401XZ		
	电镀表面处理 Electroplating Treatment	732F 632PF	202F 732F	632PF GEL-10	632PF GEL-10	401XZ 632PF	201FC 632PF	200F 632PF	221EXC 200F(*)	221EXC (*)	221EXC 200F(*)	632PF (*)	200 401XZ	200 632PF	200 632PF	221EXC 200F(*)	200F 632PF	200F 632PF	200F 632PF	200F 632PF(*)	401XZ 632PF			
树脂 Plastic	聚对苯二甲酸乙二醇酯 PET	202F (*)	202F (*)	732F (*)	732F (*)	202F (*)	201ZC 200F (*)	200 200F (*)	221EXC 200F(*)	221EXC (*)	221EXC 200F(*)	200F (*)	200F (*)	200F (*)	200F (*)	221EXC 200F(*)	200F (*)	200F 200(*)	200F 200(*)	200F 200(*)	200F 200(*)			
	丙烯酸-苯乙烯-丁二烯三元共聚物 ABS	732F	202F 732F	202F 732F	732F GEL-10	200 200F	201ZC 201FC	200F 201ZC	221EXC 200F(*)	221EXC (*)	221EXC 200F(*)	200F (*)	200 200F	200 200F	200 200F	221EXC 200F(*)	201 200	201 200	201 200	201 200	★金属表面较特殊，如下系列发挥更好的粘合作用。 The surface of metal is specific, below series may give brilliant effect for bonding.			
	丙烯酸树脂 Acrylic	732F	202F 732F	202F 732F	732F GEL-10	200 200F	201ZC 201FC	200F 201ZC	221EXC 200F(*)	221EXC (*)	221EXC 200F(*)	200F (*)	200 200F	200 200F	200 200F	221EXC 200F(*)	201 200	201 200						
	聚碳酸酯树脂 PC	732F	202F 732F	202F 732F	732F GEL-10	200 200F	201ZC 201FC	200F 201ZC	221EXC 200F(*)	221EXC (*)	221EXC 200F(*)	200F (*)	200 200F	200 200F	200 200F	221EXC 200F(*)	201 200							
	聚酰胺树脂 POM (Polyacetal)	212EXC 202F (*)	212EXC 202F (*)	212EXC 202F (*)	212EXC 202F (*)	212EXC 202F (*)	221EXC 201FC (*)	221EXC 200F(*)	221EXC 200F(*)	221EXC (*)	221EXC 200F(*)	221EXC 200F(*)	221EXC 200F(*)	221EXC 200F(*)	221EXC 200F(*)	221EXC 200F(*)								
	环氧树脂 Epoxy	732F	202F 732F	202F 732F	732F GEL-10	200 200F	201ZC 201FC	200 200F	221EXC 200F(*)	221EXC (*)	221EXC 200F(*)	200F (*)	200 200F	200 200F	200 200F									
	硬质聚氯乙烯 Hard PVC	732F	202F 732F	202F 732F	732F GEL-10	200 200F	201ZC 201FC	200 200F	221EXC 200F(*)	221EXC (*)	221EXC 200F(*)	200F (*)	200 200F	200 200F										
	聚酯树脂 Polyester	732F	202F 732F	202F 732F	732F GEL-10	200 200F	201ZC 201FC	200 200F	221EXC 200F(*)	221EXC (*)	221EXC 200F(*)	200F (*)	200 200F											
	尼龙树脂 Nylon	732F (*)	202F (*)	732F (*)	732F (*)	200 (*)	201ZC (*)	200 (*)	221EXC 200F(*)	221EXC (*)	221EXC 200F(*)	200F (*)												
	聚丙烯酰胺 聚乙烯醇 PP/ 聚乙烯醇 PE	212EXC 202F (*)	212EXC 202F (*)	212EXC 202F (*)	212EXC 202F (*)	212EXC 202F (*)	212EXC 200F (*)	212EXC 200F (*)	221EXC 200F(*)	221EXC (*)	221EXC 200F(*)													
橡胶 Rubber	烯烃类树脂弹性体 Olefin Elastomer	212EXC 202F (*)	212EXC 202F (*)	212EXC 202F (*)	212EXC 202F (*)	212EXC 202F (*)	212EXC 201FC (*)	212EXC 200F (*)	221EXC 200F(*)	221EXC (*)														
	矽橡胶 Silicon Rubber	202F 732F (*)	202F 732F (*)	202F 732F (*)	212EXC 202F (*)	212EXC 202F (*)	212EXC 201FC (*)	212EXC 200F (*)	221EXC 200F(*)															
	丁腈橡胶 Nitrile rubber / 氯丁二烯橡胶 Chloroprene Rubber	202F 732F	202F 732F	732F GEL-10	732F GEL-10	200 200F	201FC 201ZC	200 200F																
	乙丙二烯三元共聚物 EPDM	732F 201ZC	732F 201ZC	732F 201ZC	202F 201FC	202F 201FC																		
无机材料 Inorganic	石 Stone	202F 732F	202F 732F	732F GEL-10	202F 732F	200 200F	★GEL-10 适合于“木材和皮革”！ GEL-10 is suitable for "wood and leather"!																	
	陶瓷 Ceramic	732F GEL-10	202F 732F	732F GEL-10	202F 732F																			
多孔性物质 Porous	木材 Wood	732F GEL-10	202F 732F	732F GEL-10	高粘度品适合于多孔性物质的表面。 High viscosity type is suitable for the surface of porous material.																			
	纸 Paper	202F 732F	202F 732F																					
	皮革 Leather	732F GEL-10																						

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此图表为选择AA超能胶的参考，请根据各种因素选择。
This chart is to be published as a reference only for choosing the Aron Alpha. Please take into consideration various factors.



“难贴合材料”如何贴合？
(*)建议以下材料可预先将PP Primer 涂于贴合表面，再贴合。
-PP (聚丙烯树脂)
-PE (聚乙烯树脂)
-PU (聚氨酯树脂)
-PET (聚对苯二甲酸乙二醇酯)
-Nylon (尼龙)
-Silicon (硅胶材料)
How to bond the “difficult to bond material”?
(*)PP Primer is recommended to bond the above materials for pre-coating.



★ PP Primer 技术参数 (Technical data)

材料 (Material)	固化时间 Set time (秒, sec)	剪切强度 Tensile shear strength (kg f/cm ²)
PP (聚丙烯树脂)	3	破坏材料 (material failure)
PE (聚乙烯树脂)	3	30
EPDM (三元乙丙橡胶)	2	破坏材料 (material failure)
Soft PVC (软质PVC)	3	破坏材料 (material failure)
PU (聚氨酯树脂)	3	破坏材料 (material failure)