

LEGEND:

- Excellent
- ▲ Fair
- ⊗ Poor
- ★★★ Superior
- ★★ Very Good
- ★ Good

SERIES 100

Superior tensile and shear strengths, well suited for metal bonding.

SERIES 200

General purpose adhesive for a variety of applications. Various viscosities and gap filling properties available.

SERIES 200E

For clean, fast applications. Best for high speed automated assembly.

PRODUCT TYPE	101	102	201	202	203	241	212E	241E	252E
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GENERAL PROPERTIES

Color	Clear	Clear	Clear	Clear	Clear	Clear	Clear	Clear	Clear
Viscosity (cps)	2	100	2	100	1500	40	100	40	500
Gap Fill	Low	Med	Low	Med	High	Low	Med	Low	High
Base Monomer	Methyl	Methyl	Ethyl	Ethyl	Ethyl	Ethyl	Ethyl	Ethyl	Ethyl

USE ON THESE SUBSTRATES

Rubber/Plastic	■	■	■	■	■	■	■	■	■
Metal	■	■	▲	▲	▲	▲	▲	▲	▲
Porous	⊗	⊗	⊗	⊗	⊗	⊗	■	■	■

UNIQUE RESISTANCE PROPERTIES (APPLICABLE ONLY TO CERTAIN PRODUCT TYPES AND/OR SERIES)

Impact									
Peel									
Thermal Shock									
No Run									
No Odor									

MILITARY SPECS MIL-A-46050C

Type / Class	1 / 1	1 / 2	2 / 1	2 / 2	2 / 3	2 / 1	2 / 2	2 / 1	2 / 3
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METALS

Steel									
Set Time (sec)	15	50	15	50	100	40	15	15	15
Tensile Strength (psi)	6100	6100	4600	4600	4100	4600	4600	4600	4600
Stainless Steel (SUS)									
Set Time (sec)	15	50	15	50	100	40	15	15	20
Tensile Strength (psi)	5700	5700	4100	4100	3700	4100	4100	4100	4100
Aluminum									
Set Time (sec)	15	60	15	60	130	60	60	60	60
Tensile Strength (psi)	4000	4000	2800	2800	2600	2800	2800	2800	2800

PLASTICS

Rigid PVC									
Set Time (sec)	5	10	5	10	25	10	3	3	3
Tensile Strength (psi)	5000	5000	5000	5000	5000	5000	5000	5000	5000
Acrylics (PMMA)									
Set Time (sec)	10	30	10	30	80	20	5	5	5
Tensile Strength (psi)	5000*	5000*	5000*	5000*	5000*	5000*	5000*	5000*	5000*
ABS									
Set Time (sec)	15	60	15	60	120	50	3	3	3
Tensile Strength (psi)	3600*	3600*	3600*	3600*	3600*	3600*	3600*	3600*	3600*
Polycarbonate									
Set Time (sec)	20	60	20	60	100	60	10	10	10
Tensile Strength (psi)	5000	5000	5000	5000	5000	5000	5000	5000	5000

ELASTOMERS

Neoprene Chloroprene (CR)									
Set Time (sec)	5	10	5	10	25	10	5	5	5
Tensile Strength (psi)	360*	360*	360*	360*	360*	360*	360*	360*	360*
Natural Rubber									
Set Time (sec)	5	10	5	10	25	10	5	5	5
Tensile Strength (psi)	360*	360*	360*	360*	360*	360*	360*	360*	360*

HARD-TO-BOND MATERIALS

Polyethylene	<div style="border: 1px solid black; padding: 10px; display: inline-block;"> <p style="margin: 0;">Requires Use of Primer to Achieve Bond!</p> <p style="margin: 0;">See Page 8</p> </div>								
Polypropylene									
Polyacetal									
Polyethylene-terphthalate (PET)									
Nylon									
Soft PVC									
Silicone Rubber									
Glass									

* indicates material failure.

This is a partial listing of the performance of Aron Alpha[®] cyanoacrylate adhesives on various substrates. Detailed technical information is available upon request. The setting time and bond strength test results were prepared at the Aron Alpha lab. Actual results may vary under application conditions.

PRODUCT GUIDE

SERIES 200F

Surface insensitive adhesives, ultra-fast setting for porous, soft or tough-to-bond substrates.
Series 200TX & Gel: No run, no stringing, excellent gap filling characteristics with good strength on a variety of materials.

SERIES 400X

Engineered for high temperature and high impact resistance.

221 232 202F 221F 231F 241F 252F 282F 253TX GEL 10 401X 402X 403X

Clear	Clear	Clear	Clear	Clear	Clear	Clear	Clear	Clear	Clear	Clear	Clear	Clear	Clear
2	300	85	2	30	40	500	800	5000	170000	2	100	1500	
Low	High	Med	Low	Low	Low	High	High	High	High	Low	Med	High	
Ethyl	Ethyl	Ethyl	Ethyl	Ethyl	Ethyl	Ethyl	Ethyl	Ethyl	Ethyl	Ethyl	Ethyl	Ethyl	

■	■	■	■	■	■	■	■	■	■	■	■	■	■
▲	▲	▲	▲	▲	▲	▲	▲	▲	▲	▲	▲	▲	▲
▲	■	■	■	■	■	■	■	■	■	■	■	■	■

										★★	★★	★★	
										★	★	★	
								★★★	★★★				

2 / 1 2 / 2 2 / 2 2 / 1 2 / 1 2 / 1 2 / 3 2 / 3 2 / N/A 2 / 1 2 / 2 2 / 3

10	15	5	3	3	15	10	15	1520	15	50	100		
4600	4600	4600	4600	4600	4600	4600	4600	4600	4300	5800	5800	5800	
10	15	5	3	5	15	15	15	1520	15	30	60		
4100	4100	4100	4100	4100	4100	4100	4100	4100	3600	6400	6400	6400	
10	15	5	3	5	15	10	15	1530	15	60	130		
2800	2800	2800	2800	2800	2800	2800	2800	2800	2800	5800	5800	5800	

3	5	3	1	1	5	5	5	5 5	5	10	25		
5000	5000	5000	5000	5000	5000	5000	5000	5000	3800	5000	5000	5000	
5	10	3	1	1	10	5	10	1010	10	30	80		
5000*	5000*	5000*	5000*	5000*	5000*	5000*	5000*	5000*	2800	5000*	5000*	5000*	
3	15	5	1	3	15	5	15	1515	15	60	120		
3600*	3600*	3600*	3600*	3600*	3600*	3600*	3600*	3600*	3000	3600*	3600*	3600*	
10	20	5	1	3	20	10	15	1530	20	60	100		
5000	5000	5000	5000	5000	5000	5000	5000	5000	3600	5000	5000	5000	

3	5	3	1	1	5	3	5	5 5	5	10	25		
360*	360*	360*	360*	360*	360*	360*	360*	360*	360*	360*	360*	360*	
3	5	3	1	1	5	3	5	5 5	5	10	25		
360*	360*	360*	360*	360*	360*	360*	360*	360*	360*	360*	360*	360*	

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