

**Product Name: Aron Alpha PP Primer Series**

**FEATURES**

PP primer is specially formulated for Aron Alpha adhesive to achieve effective bond to difficult bonding plastics.  
 PP primer S has an accelerating property as well. Use with Cyanoacrylate adhesives to promote bonding speed in seconds.

Primers are effective on the following materials:

- Polyacetal (POM)
- Nylon
- Silicone Rubber
- Polypropylene
- Polyethylene

**PROPERTIES**

Property	PP Primer	PP Primer S
Appearance	Colorless Liquid	
Solvent	Heptanes	
Boiling Point	195°F/91°C	
Specific Gravity	0.68	
Flash Point	15°F/-9°C	

**Directions**

Wipe the bonding surface(s) with a primer-soaked-cloth lightly one or two times and air dry. Apply adhesive and bond.

**\*\*Caution\*\*** Too much coating of the primers on the bonding surface(s) weakens the bonding strength.

Setting Times for various materials (sec)

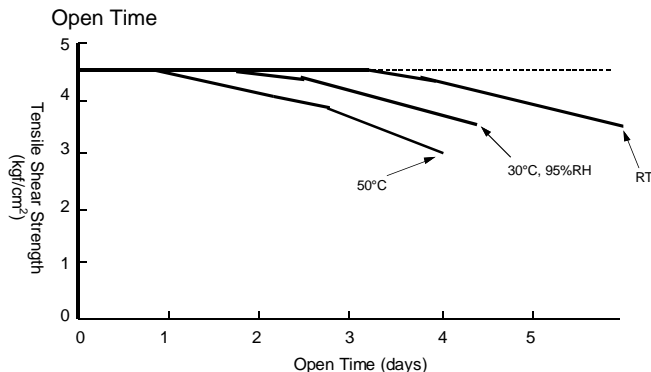
Material	PP Primer	PP Primer S	No Primer
Polypropylene	5	1	>60
Polyethylene	5	1	>60

Bonding Strengths (Shear measured in kgf/cm<sup>2</sup> for various materials)

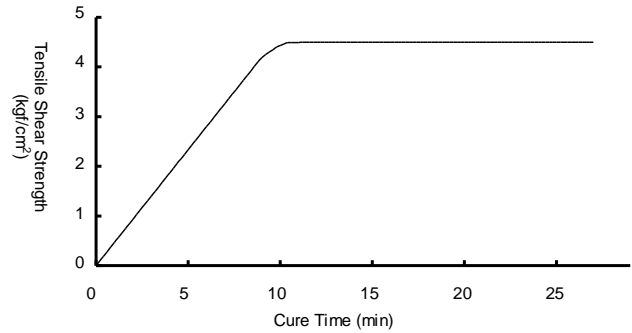
Material	PP Primer	PP Primer S	No Primer
Polypropylene	4.5*	4.5*	0.0
Polyethylene	3.2	3.0	0.0
EPT Rubber	0.9*	0.9*	0.5
PVC (soft)	1.2*	1.1*	0.6
PMMA	3.0*	3.0*	3.5*
PC	6.8*	6.7*	6.8*
ABS	6.6*	6.6*	6.5*

**Open Time and Cure Time for PP Primer S**

\*Bonding Material: Polypropylene; Adhesive: Aron Alpha 201



**Cure Time**



Test conditions—Test specimen

Tensile strength: 0.5 x 0.5 x 1.5 inch; bonded area 0.25 sq. inch

Tensile shear strength:  
 for plastic and rubber 0.1 x 1.0 x 4.0 inch; bonded area 0.5 sq. inch

for metal 0.064 x 1.0 x 4.0 inch; bonded area 0.5 sq. inch

Impact Strength: 1.0 x 1.0 x 0.375 inch and 1.0 x 1.75 x 0.75; inch

T-Peeling Strength: 12.0 x 1.0 x 0.1 inch; bonded area 9.0 sq inch

Bonding atmosphere: 72-75°F (22-24°C), 58-62% relative humidity

Testing Methods: ASTM D2095, D3164, D1002, D950, and D1876

**Handling Precautions**

Volatile liquid, vapor. Use in well ventilated area. Avoid contact with skin. If swallowed, call a doctor. Use protective mask and gloves if necessary. After use wash hands thoroughly with soap and water. KEEP OUT OF REACH OF CHILDREN.

**Storage**

Keep in a dark and cool place.  
 Never store with Aron Alpha adhesives

**Disclaimer:**

Please be advised that test results are those which were prepared at Toagosei America's laboratory. The results may vary under actual application conditions.