

PRODUCT DESCRIPTION

ARON ALPHA SETTER E25 provides the following product characteristics:

Technology	Cyanoacrylate Activator
Chemical Type	Amine (active ingredient)
Solvent	Ethanol
Active Ingredient Concentration, %	<25
Appearance	Transparent pale yellow liquid
Viscosity	Very low (water-like)
Cure	N/A
Application	CA adhesive cure accelerator

ARON ALPHA SETTER is used where increased cure speed of ARON ALPHA cyanoacrylate (instant) adhesives is required. It can be either pre- or post-applied to exposed cyanoacrylate adhesive. The product is especially suited for post-application on cyanoacrylate adhesive to ensure rapid fixturing.

Typical applications include securing wires or coils to PC Boards, tamper-proofing adjustable components, mounting stand-offs, edge guides and board stiffeners.

TYPICAL PROPERTIES

Specific Gravity:	0.79
Viscosity, cps	< 1
Drying (evaporation) time, seconds	≤ 30
On Part Life, minutes	≤ 1
Flash Point – See SDS	

TYPICAL PERFORMANCE

Fixture time and cure speed achieved as a result of using ARON ALPHA SETTER depends on the cyanoacrylate adhesive used and the substrate bonded.

HANDLING PRECAUTIONS

SETTER must be handled in a manner applicable to highly flammable and volatile materials and in compliance with relevant local regulations.

The solvent can affect certain plastics and coatings. Plastics such as ABS, Polycarbonate, Polystyrene and Acrylic may degenerate when brought in contact with SETTER. The affected surface area may get cloudy or sticky. It is recommended to check all surfaces for compatibility before use.

DIRECTIONS FOR USE

Surface Activation:

1. Apply one coating of SETTER to the area to be bonded by spray, brush, or dipping. Contaminated surfaces may need special cleaning or degreasing prior to activation to remove any soluble contamination
2. Allow the solvent time to flash off until the surfaces are completely dry (approximately 30 seconds)
3. Apply the ARON ALPHA cyanoacrylate product immediately after drying or not more than 45 seconds thereafter.
4. Setter can be re-applied if necessary if there is a delay of more than 45 seconds between original Setter and adhesive application.

Post Activation:

1. Apply ARON ALPHA cyanoacrylate to the parts to be bonded or fixed.
2. Apply Setter over all exposed cyanoacrylate adhesive by drop. Typically use one drop of activator per drop of exposed adhesive.

Indirect Activation:

Vapors of SETTER facilitate the adhesive to cure rapidly. Bonded substrates may pass over a conveyor belt through a closed space (tunnel) where a small amount of SETTER in a tray or open container is placed.

Speed of conveyor belt as well as size of the closed space need to be taken into consideration for proper processing in the vapors.

If the substrates are relatively small, pre-treatment with SETTER can be done by putting them in a closed container or plastic bag, then place a cotton ball soaked with SETTER inside. Substrates may have an invisible coating of SETTER on the surface. When ARON ALPHA cyanoacrylate is applied, rapid bonding may occur.

TOAGOSEI MATERIAL SPECIFICATION

SETTER performance data is available for each batch. Toagosei test reports include selected QC test parameters considered appropriate to specifications for customer use.

STORAGE

This Setter is classified as HIGHLY FLAMMABLE and must be stored in an appropriate manner in compliance with relevant regulations. Do not store near oxidizing agents or combustible materials. The product is light sensitive and accordingly, translucent containers should be kept in a dark place when not in use. Store product in the unopened container in a dry location.

Optimal Storage: 8 °C to 21 °C. Storage below 8 °C or greater than 28 °C can adversely affect product properties. Material removed from containers may be contaminated during use. Do not return product to the original container. Toagosei cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Technical Service Center or Customer Service Representative.