

LOCTITE® 4541™

December 2020

PRODUCT DESCRIPTION

LOCTITE® 4541™ provides the following product characteristics:

Technology	Cyanoacrylate
Chemical Type	Ethyl cyanoacrylate
Appearance (uncured)	Transparent to slightly cloudy gel ^{LMS}
Components	One part - requires no mixing
Viscosity	High
Cure	Humidity
Application	Bonding
Key Substrates	Wood, Paper, Leather and Fabric

LOCTITE® 4541™ is designed for the assembly of difficult-to-bond materials which require uniform stress distribution and strong tension and/or shear strength. The product provides rapid bonding of a wide range of materials, including metals, plastics and elastomers. LOCTITE® 4541™ is particularly suited for bonding porous or absorbent materials such as wood, paper, leather and fabric. The gel consistency prevents adhesive flow even on vertical surfaces. Suitable for use in the assembly of **disposable medical devices**.

ISO-10993

LOCTITE® 4541™ has been tested to Henkel's test protocols based on ISO 10993 biocompatibility standards, as a means to assist in the selection of products for use in the medical device industry.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25 °C	1.1
Viscosity, Brookfield - RVT, 25 °C, mPa·s (cP):	
Spindle TC, speed 20 rpm, Helifast	18,000 to 40,000 ^{LMS}
Flash Point - See SDS	

TYPICAL CURING PERFORMANCE

Under normal conditions, the atmospheric moisture initiates the curing process. Although full functional strength is developed in a relatively short time, curing continues for at least 24 hours before full chemical/solvent resistance is developed.

Cure Speed vs. Substrate

The rate of cure will depend on the substrate used. The table below shows the fixture time achieved on different materials at 22 °C / 50 % relative humidity. This is defined as the time to develop a shear strength of 0.1 N/mm².

Fixture Time, seconds:

Steel (degreased)	5 to 20
Aluminum	2 to 10
Zinc dichromate	10 to 20

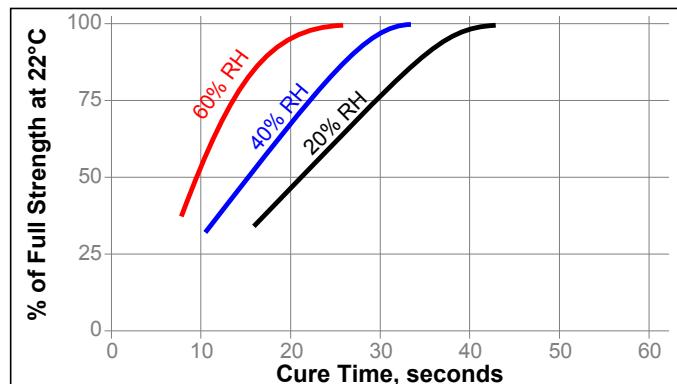
Neoprene	<5
Rubber, nitrile	<5
ABS	2 to 10
PVC	2 to 10
Polycarbonate	10 to 40
Phenolic	2 to 10

Cure Speed vs. Bond Gap

The rate of cure will depend on the bondline gap. Thin bond lines result in high cure speeds, increasing the bond gap will decrease the rate of cure.

Cure Speed vs. Humidity

The rate of cure will depend on the ambient relative humidity. The following graph shows the tensile strength developed with time on Buna N rubber at different levels of humidity.

**Cure Speed vs. Activator**

Where cure speed is unacceptably long due to large gaps, applying activator to the surface will improve cure speed. However, this can reduce ultimate strength of the bond and therefore testing is recommended to confirm effect.

TYPICAL PROPERTIES OF CURED MATERIAL

After 24 hours @ 22 °C

Physical Properties:

Coefficient of Thermal Expansion, ISO 11359-2, K ⁻¹	80×10 ⁻⁶
Coefficient of Thermal Conductivity, ISO 8302, W/(m·K)	0.1
Glass Transition Temperature, ASTM E 228, °C	120



Electrical Properties:

Dielectric Constant / Dissipation Factor, IEC 60250:	
0.1 kHz	2.65 / <0.02
1 kHz	2.75 / <0.02
10 kHz	2.65 / <0.02
Volume Resistivity, IEC 60093, Ω·cm	10×10 ¹⁵
Surface Resistivity, IEC 60093, Ω	10×10 ¹⁵
Dielectric Breakdown Strength, IEC 60243-1, kV/mm	25

TYPICAL PERFORMANCE OF CURED MATERIAL**Adhesive Properties**

After 24 hours @ 22 °C

Lap Shear Strength, ISO 4587:

Steel (grit blasted)	N/mm ² (psi)	18 to 26 (2,610 to 3,770)
Aluminum (etched)	N/mm ² (psi)	11 to 19 (1,595 to 2,755)
Zinc dichromate	N/mm ² (psi)	4 to 10 (580 to 1,450)
ABS	N/mm ² (psi)	6 to 20 (870 to 2,900)
PVC	N/mm ² (psi)	6 to 20 (870 to 2,900)
Polycarbonate	N/mm ² (psi)	5 to 20 (725 to 2,900)
Phenolic	N/mm ² (psi)	5 to 15 (725 to 2,900)
Neoprene	N/mm ² (psi)	5 to 15 (725 to 2,175)
Nitrile	N/mm ² (psi)	5 to 15 (725 to 2,175)

Tensile Strength, ISO 6922:

Steel (grit blasted)	N/mm ² (psi)	12 to 25 (1,740 to 3,625)
Buna-N	N/mm ² (psi)	5 to 15 (725 to 2,175)

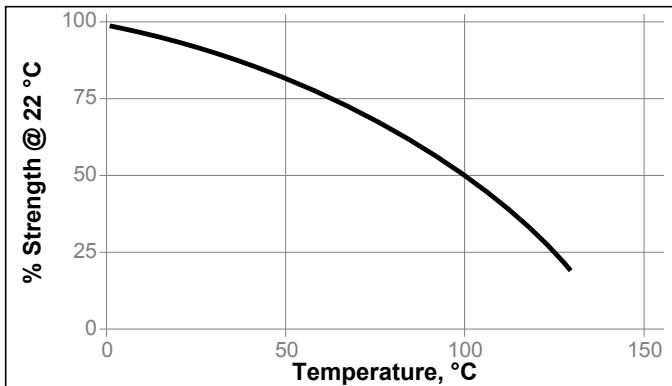
After 30 seconds @ 22 °C

Tensile Strength, ISO 6922:

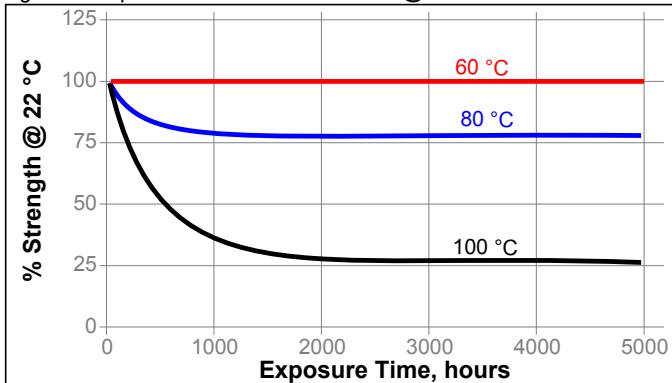
Buna-N	N/mm ² (psi)	≥6.9 ^{LMS} (≥1,000)
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Hot Strength

Tested at temperature

**Heat Aging**

Aged at temperature indicated and tested @ 22 °C

**Chemical/Solvent Resistance**

Aged under conditions indicated and tested @ 22 °C

Environment	°C	% of initial strength		
		100 h	500 h	1000 h
Motor oil (MIL-L-46152)	40	85	85	75
Gasoline	22	100	100	100
Ethanol	22	100	100	100
Isopropanol	22	100	100	100
Freon TA	22	100	100	100
Heat/humidity 95% RH	40	65	55	50
Heat/humidity 95% RH on polycarbonate	40	100	100	100

Effects of Sterilization

In general, products similar in composition to LOCTITE® 4541™ subjected to standard sterilization methods, such as ETO and Gamma Radiation (25 to 50 kiloGrays cumulative) show excellent bond strength retention. LOCTITE® 4541™ maintains bond strength after 1 cycle of steam autoclave. It is recommended that customers test specific parts after subjecting them to the preferred sterilization method. Consult with Loctite® for a product recommendation if your device will see more than 3 sterilization cycles.

GENERAL INFORMATION

This product is not recommended for use in pure oxygen and/or oxygen rich systems and should not be selected as a sealant for chlorine or other strong oxidizing materials.

For safe handling information on this product, consult the Safety Data Sheet (SDS).

Directions For Use:

1. For best performance bond surfaces should be clean and free from grease.
2. This product performs best in thin bond gaps (0.05 mm).
3. Excess adhesive can be dissolved with Loctite cleanup solvents, nitromethane or acetone.

Loctite Material Specification^{LMS}

LMS dated January 29, 2003. Test reports for each batch are available for the indicated properties. LMS test reports include selected QC test parameters considered appropriate to specifications for customer use. Additionally, comprehensive controls are in place to assure product quality and consistency. Special customer specification requirements may be coordinated through Henkel Quality.

Storage

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

Optimal Storage: 2 °C to 8 °C. Storage below 2 °C or greater than 8 °C can adversely affect product properties.
 Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel Corporation 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 Henkel Representative.

Conversions

(°C x 1.8) + 32 = °F
 kV/mm x 25.4 = V/mil
 mm / 25.4 = inches
 µm / 25.4 = mil
 N x 0.225 = lb
 N/mm x 5.71 = lb/in
 N/mm² x 145 = psi
 MPa x 145 = psi
 N·m x 8.851 = lb·in
 N·m x 0.738 = lb·ft
 N·mm x 0.142 = oz·in
 mPa·s = cP

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Reference 1.5