

LOCTITE[®] 4851[™]

September 2007

PRODUCT DESCRIPTION

LOCTITE[®] 4851[™] provides the following product characteristics:

Technology	Cyanoacrylate
Chemical Type	Ethyl / butyl cyanoacrylate
Appearance (uncured)	Clear colorless liquid ^{LMS}
Components	One part - requires no mixing
Viscosity	Medium
Cure	Humidity
Application	Bonding
Key Substrates	Steel, Polycarbonate and ABS

LOCTITE[®] 4851[™] is designed for the assembly of difficult to bond materials and is specifically formulated to provide flexible bondlines. The product provides rapid bonding of a wide range of materials, including metals, plastics and elastomers. When used to bond rubbers, for example, this product maintains the full compressibility of the joint. LOCTITE[®] 4851[™] is particularly suited for bonding porous or absorbent materials such as paper, leather and fabrics. Suitable for use in the assembly of **disposable medical devices**.

ISO-10993

An ISO 10993 Test Protocol is an integral part of the Quality Program for LOCTITE[®] 4851[™]. LOCTITE[®] 4851[™] has been qualified to Henkel's ISO 10993 Protocol as a means to assist in the selection of products for use in the medical device industry. Certificates of Compliance are available on Henkel's website or through the Henkel Quality Department.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25 °C	1.1
Viscosity, Cone & Plate, mPa·s (cP):	
Temperature: 25 °C, Shear Rate: 100 s ⁻¹	250 to 500 ^{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 (grit blasted)	5 to 15

Steel (degreased)	5 to 30
Aluminum (grit blasted)	5 to 20
Aluminum (degreased)	5 to 15
Zinc dichromate	5 to 20
Rubber, nitrile	5 to 15
ABS	3 to 5
PVC	3 to 10
Polycarbonate	3 to 10
Epoxy FR4	<3
Leather	5 to 20
Paper	1 to 3
Wood (teak)	30 to 75

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. 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	100×10 ⁻⁶
Glass Transition Temperature, ASTM E 228, °C	60
Shore Hardness, ISO 868, Durometer A	80 to 90
Tensile Modulus, ISO 527-3	N/mm ² 515 to 675 (psi) (75,000 to 98,000)

Electrical Properties:

Dielectric Constant / Dissipation Factor, IEC 60250:	
0.1 kHz	1.09 / <0.05
100 kHz	1.03 / <0.05
1,000 kHz	0.1 / <0.05

Volume Resistivity, IEC 60093, Ω·cm	332×10 ¹²
Surface Resistivity, IEC 60093, Ω	>1×10 ¹⁵
Dielectric Breakdown Strength, IEC 60243-1, kV/mm	25

TYPICAL PERFORMANCE OF CURED MATERIAL

Adhesive Properties

Cured for 7 days @ 22 °C	
Lap Shear Strength, ISO 4587:	
Steel (grit blasted)	N/mm ² 11 to 15 (psi) (1,600 to 2,200)

Aluminum (grit blasted)	N/mm ²	10 to 14
	(psi)	(1,500 to 2,000)
Zinc dichromate	N/mm ²	6 to 12
	(psi)	(900 to 1,700)
ABS	N/mm ²	7 to 9
	(psi)	(1,000 to 1,300)
PVC	N/mm ²	3 to 7
	(psi)	(400 to 1,000)
Polycarbonate	N/mm ²	6 to 10
	(psi)	(900 to 1,500)
Epoxy FR4	N/mm ²	12 to 16
	(psi)	(1,700 to 2,300)
Wood (teak)	N/mm ²	5 to 9
	(psi)	(700 to 1,300)

Cured for 30 seconds @ 22 °C

Tensile Strength, ISO 6922:

Buna-N	N/mm ²	≥5 ^{LMS}
	(psi)	(≥725)

TYPICAL ENVIRONMENTAL RESISTANCE

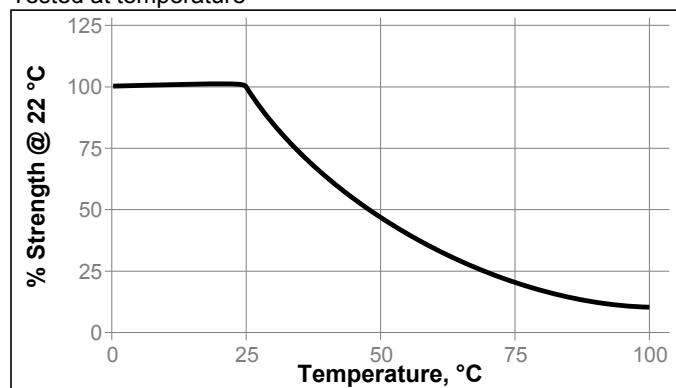
After 1 week @ 22 °C

Lap Shear Strength, ISO 4587:

Mild steel (grit blasted)

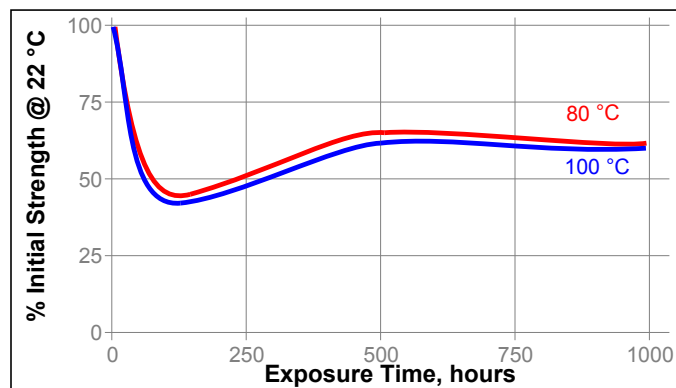
Hot Strength

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	70	80	60
Gasoline	22	90	90	85
Ethanol	22	95	80	45
Isopropanol	22	105	105	90
Heat/humidity 95% RH	40	50	45	40
Heat/humidity 95% RH on polycarbonate	40	100	100	100

Effects of Sterilization

In general, products similar in composition to LOCTITE® 4851™ subjected to standard sterilization methods, such as EtO and Gamma Radiation (25 to 50 kiloGrays cumulative) show excellent bond strength retention. LOCTITE® 4851™ 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 28, 2004. 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 Technical Service Center or Customer Service Representative.

Conversions

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$
 $\text{kV/mm} \times 25.4 = \text{V/mil}$
 $\text{mm} / 25.4 = \text{inches}$
 $\mu\text{m} / 25.4 = \text{mil}$
 $\text{N} \times 0.225 = \text{lb}$
 $\text{N/mm} \times 5.71 = \text{lb/in}$
 $\text{N/mm}^2 \times 145 = \text{psi}$
 $\text{MPa} \times 145 = \text{psi}$
 $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$
 $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$
 $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$
 $\text{mPa}\cdot\text{s} = \text{cP}$

Note:

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.

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Reference 2.2