

LOCTITE[®] 4014[™]

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PRODUCT DESCRIPTION

LOCTITE[®] 4014[™] provides the following product characteristics:

Technology	Cyanoacrylate
Appearance (uncured)	Transparent, colorless to slightly yellow liquid ^{LMS}
Components	One part - requires no mixing
Viscosity	Very low
Cure	Humidity
Application	Bonding
Key Substrates	Plastics and Metals

LOCTITE[®] 4014[™] is designed to provide fast room temperature fixturing and is also suitable for applications where heat resistance is required. 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[®] 4014[™]. LOCTITE[®] 4014[™] 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
Flash Point - See SDS	
Viscosity, Cone & Plate, mPa·s (cP):	
Temperature: 25 °C, Shear Rate: 100 s ⁻¹	1 to 4 ^{LMS}
Viscosity, Brookfield - LVF, 25 °C, mPa·s (cP):	
Spindle 1, speed 30 rpm,	1 to 5

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.

Fixture Time, seconds:

PVC to PVC	60 to 80
ABS to ABS	5 to 10
Polycarbonate to Polycarbonate	20 to 25
Polyurethane to Polyurethane	8 to 10
G-10 Epoxy to G-10 Epoxy	25 to 30
Stainless steel to PVC	5 to 10
Stainless steel to ABS	5 to 10
Stainless steel to Polycarbonate	5 to 8
Stainless steel to Polyurethane	20 to 25
Stainless steel to G-10 Epoxy	6 to 10

Cure Speed vs. Bond Gap & Humidity

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. The rate of cure is also influenced by the ambient relative humidity; the higher the relative humidity, the greater the cure speed.

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

Cured for 24 hours @ 22 °C

Physical Properties:

Shore Hardness, ISO 868	65
Elongation, ISO 527-2, %	2
Tensile Strength, ISO 527-3	28
	(4,000)

TYPICAL PERFORMANCE OF CURED MATERIAL

Adhesive Properties

Cured for 10 seconds @ 22 °C

Tensile Strength, ISO 6922:

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

Cured for 24 hours @ 22 °C

Lap Shear Strength, ISO 4587:

PVC to PVC	N/mm ²	>7.5
	(psi)	(>1,100)
ABS to ABS	N/mm ²	>4
	(psi)	(>580)
Polycarbonate to Polycarbonate	N/mm ²	>7.5
	(psi)	(>1,100)

Stainless steel to ABS	N/mm ²	>5.5
	(psi)	(>800)
Stainless steel to PVC	N/mm ²	>4
	(psi)	(>580)
Stainless steel to Polycarbonate	N/mm ²	>4
	(psi)	(>580)
Stainless steel to Polyurethane	N/mm ²	1.5
	(psi)	(220)

Cured for 24 hours @ 22 °C, followed by 24 hours @ 121 °C, tested @ 22 °C

Lap Shear Strength, ISO 4587:

Steel (grit blasted)	N/mm ²	≥12 ^{LMS}
	(psi)	(≥1,740)

TYPICAL ENVIRONMENTAL RESISTANCE

Humidity Resistance

38°C - 85% Relative Humidity

Adhesive Properties

Lap Shear Strength, ISO 4587, N/mm² :

Substrates	1*	2*	3*	4*
PVC to PVC	>8	>5	>5	>5
ABS to ABS	>4	>3.5	>3	>2.5
Polycarbonate to polycarbonate	>8	>6.5	>6	>5.5
Stainless Steel to PVC	>6	>6	>5.5	>5.5
Stainless Steel to ABS	>4	>4	>5	>4
Stainless Steel to Polycarbonate	>4	>4	>4	>2
Stainless Steel to Polyurethane	1.5	1.4	2.2	2.0

* 1 - Control

* 2 - Aged 1 Week

* 3 - Aged 4 weeks

* 4 - Aged 8 weeks

Effects of Sterilization

In general, products similar in composition to LOCTITE® 4014™ subjected to standard sterilization methods, such as EtO and Gamma Radiation (25 to 50 kiloGrays cumulative) show excellent bond strength retention. LOCTITE® 4014™ 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 October 11, 2002. 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

(°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

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 1.3