

## Product Description

Cyanolit® 241 F is a low viscosity, one part adhesive based on cyanoacrylate with a good bonding on a wide range of materials including plastics, metals and elastomers. Cyanolit® 241 F cures rapidly with atmospheric moisture. Low viscosity makes it ideal for applications where wicking of the adhesive into pre-assembled parts is required.

Cyanolit® 241 F has met the requirements for USP Class VI and is suitable for use in the assembly of disposable medical devices.

## Curing Properties

The curing process of Cyanolit® 241 F is initiated by atmospheric moisture. The rate of cure depends upon the bondline gap and the ambient relative humidity. The speed of cure will be improved by high ambient relative humidity and small bondline gaps.

Although full functional strength is developed in a relatively short time, curing continues for at least 24 hours before full environmental resistance is developed.

The table below shows the setting time for different substrates.

Material	(sec)
PVC	5
PMMA	10
ABS	15
PC	20
NR	5
Steel/Stahl	15

## Technical Data

Base	Ethyl 2- Cyanoacrylate
Curing	one part, humidity
Appearance	transparent

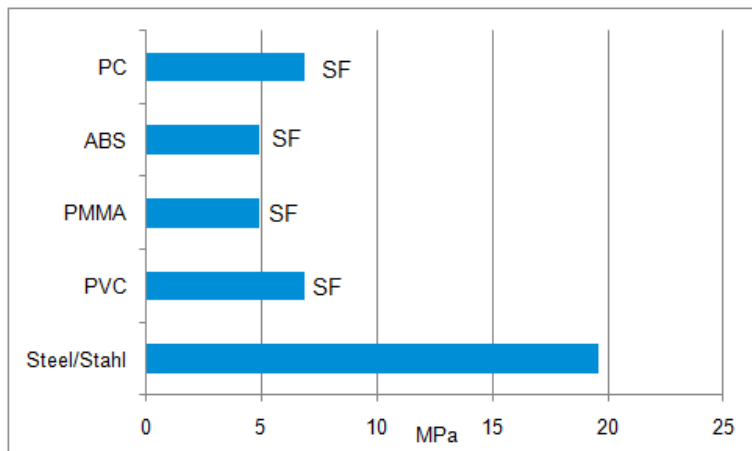
### Uncured Material

Viscosity [mPas] (Brookfield LVT, 25 °C, CP52/60 rpm) PE-Norm 001	30 - 50
Density [g/cm³] PE-Norm 004	1.05
Flash Point [°C]	83

### Cured Material

Hardness Rockwell M	70 - 85
Recommended Service Temperature [°C]	-80 - 80

Tensile Shear Strength [MPa]  
ASTM D 3104, D1002



SF = Substrate Failure

## Storage and Shelf life

The product can be stored for 6 month at 5 °C to 25 °C in unopened containers. Store under dry and dark conditions only.

## Packaging Unit

Standard packaging units of 20 g and 500 g are available.

## Instructions for Use

### Surface Preparation

The surfaces to be bonded should be clean and free from oil and grease. Lightly soiled surfaces can be cleaned with our cleaner IP®. Substrates with low surface energy (such as polyethylene and polypropylene) need to be pretreated.

### Application

Our products are supplied ready for use. Dispense the adhesive on one substrate surface. Use the substrate with smallest bonding surface, the longest setting time or the upwardly directed surface. Assembly both surfaces directly after dispensing.

Dispensing in excess potentially damages the surface in the way of chlorosis and/or solvent cracks. Dispensing not enough may cause the monomer to harden before bonding starts and this will reduce the bond strength to a great extend. We recommend testing the product for your application.

The product is eye and skin irritant and bonds skin instantly. For safe handling information, consult the MSDS before using.

## Note

Our data sheets have been compiled to the best of our knowledge. The enclosed information describes characteristic properties, with no declaration of commitment. We recommend trials in order to confirm that our products satisfy the particular application requirements. For an additional technical consultation, please contact our R&D department. In general, for warranty claims, please refer to our standard terms and conditions.