Technical Data Sheet

LOCTITE® 4310™

September 2020

PRODUCT DESCRIPTION

LOCTITE® 4310™ provides the following product characteristics:

Technology	Cyanoacrylate/UV
Chemical Type	Ethyl cyanoacrylate with photoinitiator
Appearance	Transparent, light yellow-green to dark blue-green liquid
Fluorescence	Positive under UV light
Components	One part - requires no mixing
Cure	Ultraviolet (UV) / Visible light
Secondary Cure	Humidity
Application	Bonding
Key substrates	Plastics, rubbers and metals

LOCTITE® 4310™ is designed for bonding applications that require very rapid fixturing, fillet cure or surface cure. The UV light cure properties facilitate rapid curing of exposed surface areas thereby minimizing blooming and providing an alternative to solvent borne accelerators. Suitable for use in the assembly of **disposable medical devices**.

ISO-10993

LOCTITE® 4310™ 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

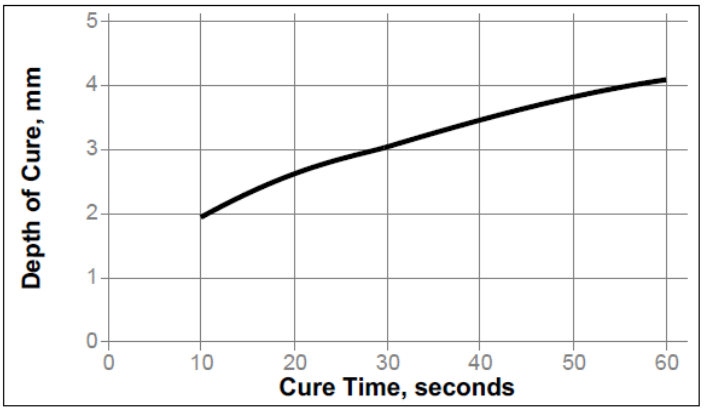
Specific Gravity @ 25°C	1.06
Flash Point - See SDS	
Viscosity, Cone & Plate, mPa·s (cP):	
Physica MC100, Cone MK 22, shear rate 100 s^{-1}	100 to 250

TYPICAL CURING PERFORMANCE

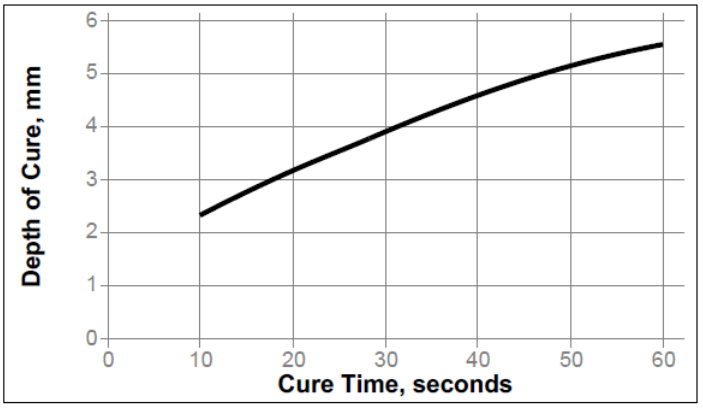
Primary Cure Mechanism, UV

Depth of Cure

Electrodeless, D bulb, 100 mW/cm², measured @ 365 nm



LED Flood Array 405nm, 100 mW/cm², measured @ 405nm



Tack Free Time / Surface Cure

Tack Free Time is the time in seconds required to achieve a tack free surface

UV/Visible light sources	
Electrodeless, H bulb	
30 mW/cm², measured @ 365 nm	≤10
Zeta® 7411-S	
30 mW/cm², measured @ 365 nm	≤5
CUREJET 405 LED	
65 mW/cm², measured @ 365 nm	≤5
LED Flood Array 405nm	
65 mW/cm², measured @ 365 nm	≤5

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 measurements relate to non-UV cure.

Fixture time, seconds	
ABS	<5
Aluminum (grit blasted)	5 to 15
Neoprene	15 to 25
Phenolic	250 to 290
Polycarbonate	10 to 20
Polyethylene	>300
Polyethylene (Primer 770)	5 to 10
Polypropylene	>300
Polypropylene (plasma treated)	270 to 300
PVC	90 to 105
Steel (degreased)	20 to 30

TYPICAL PROPERTIES OF CURED MATERIAL

Cured @ 100 mW/cm², measured @ 365nm, for 30 seconds per side using an Electrodless system, D bulb.

Physical Properties

Coefficient of Thermal Expansion, ISO 11359-2, K^{-1}		
Pre Tg		56×10^{-6}
Glass Transition Temperature, ASTM E 228, °C		102
Shore Hardness, ISO 868, Durometer D		84
Linear Shrinkage, in/in		6
Water Absorption, ISO 62, %		
2 hours in boiling water		2.2
7 days in water @ 22 °C		1.3
Elongation, at break, ISO 527-3, %		7.3
Tensile Strength, ISO 527-3	N/mm^2 (psi)	50 (7,250)
Tensile Modulus, ISO 527-3	N/mm^2 (psi)	1,950 (282,900)

TYPICAL PERFORMANCE OF CURED MATERIAL

Adhesive Properties

Cured @ 30 mW/cm², measured @ 365 nm, for 10 seconds using a Zeta® 7400 light source

Block Shear Strength, ISO 13445:

Polycarbonate	N/mm^2 (psi)	≥9.0 (≥1,305)

Cured @ 100 mW/cm², measured @ 365 nm, for 30 seconds using a Zeta® 7411-S light source

Block Shear Strength, ISO 13445:

Acrylic to Acrylic	N/mm^2 (psi)	14.4 (2,090)
Polycarbonate to Polycarbonate	N/mm^2 (psi)	22 (3,190)
Polycarbonate to Steel (grit blasted)	N/mm^2 (psi)	12 (1,740)

Cured @ 100 mW/cm², measured @ 405 nm, for 30 seconds using a LED Flood Array 405nm

Block Shear Strength, ISO 13445:

Acrylic to Acrylic	N/mm^2 (psi)	10.6 (1,540)
Polycarbonate to Polycarbonate	N/mm^2 (psi)	16.4 (2,380)
Polycarbonate to Steel (grit blasted)	N/mm^2 (psi)	12.6 (1,830)

Cured @ 1,000 mW/cm², for 10 seconds using an Electrodeless system, D bulb

Needle Pullout Strength:

Material	22 Gauge cannula	27 Gauge cannula
Polycarbonate	N (lb) 139 (31)	N (lb) 38 (9)
Polyethylene	N (lb) 11 (2)	N (lb) 24 (6)
Polyethylene (plasma treated)	N (lb) 128 (27)	N (lb) 53 (12)
Polypropylene	N (lb) 24 (5)	N (lb) 18 (4)
Polypropylene (plasma treated)	N (lb) 87 (20)	N (lb) 41 (9)

Cured for 24 hours @ 22°C (non-UV cure)

Lap Shear Strength, :

Steel (grit blasted)	N/mm^2 (lb/in)	20.4 (2,950)

Block Shear Strength, ISO 13445:

Acrylic to Acrylic	N/mm^2 (psi)	8 (1,160)
Polycarbonate to Polycarbonate	N/mm^2 (psi)	6 (870)
Polycarbonate to Steel (grit blasted)	N/mm^2 (psi)	10.4 (1,510)

Cured for 48 hours @ 22°C (non-UV cure)

180° Peel Strength, ISO 8510-2:

Steel (grit blasted)	N/mm^2 (lb/in)	3 (17)

TYPICAL ENVIRONMENTAL RESISTANCE

Cured @ 30 mW/cm², measured @ 365 nm, for 10 seconds.

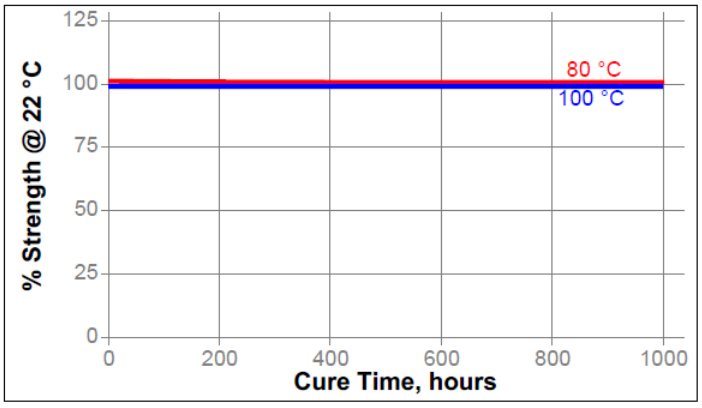
Block Shear Strength, ISO 13445:

Polycarbonate

Heat Aging

Aged at temperature indicated and tested @ 22 °C.

* **Note:** Substrate failure for all test specimens*



Chemical/Solvent Resistance

Aged under conditions indicated and tested @ 22 °C.

* **Note:** Substrate failure for all test specimens*

		% of initial strength			
Environment	**°C**	**24 h**	**100 h**	**500 h**	**1000 h**
Water	22	100	100	100	100
95% RH	40	100	100	100	100
Heptane	22	100	100	100	100
Isopropanol	22	100	100	100	100

Thermal Stability of Needle Assemblies

Aged @ 60°C and tested @ 22 °C

Needle pullout strength, % of initial strength	**4 weeks**	**8 weeks**
Polycarbonate		
22 Gauge Cannula	65	50
27 Gauge Cannula	90	90
Polypropylene (plasma treated)		
22 Gauge Cannula	70	80
27 Gauge Cannula	75	70

Sterilization Resistance of Needle Assemblies

Sterilized as indicated and tested @ 22 °C

Needle Pullout Strength, % of initial strength:

	Gamma	**ETO**	**Autoclave**	
	30 kGy	1 Cycle	1 Cycle	5 Cycles
Polypropylene (plasma treated)				
22 Gauge Cannula	50	55	40	45
27 Gauge Cannula	65	60	70	70

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. This product is light sensitive; exposure to daylight, UV light and artificial lighting should be kept to a minimum during storage and handling.
2. For best performance bond surfaces should be clean and free from grease.
3. Excess adhesive can be dissolved with Loctite cleanup solvents, nitromethane or acetone.

Product specification:

The technical data contained herein are intended as reference only and are not considered specifications for the product. Product specifications are located on the Certificate of Analysis or please contact Henkel representative.

Data ranges

The data contained herein may be reported as a typical value. Values are based on actual test data and are verified on a periodic basis.

Temperature/Humidity Ranges: 23°C / 50% RH = 23±2°C / 50±5% RH

Approval and certificate

Please contact Henkel representative for related approval or certificate of this product.

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

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.

Disclaimer
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Reference 0.4

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