Laboratory Data Sheet

Product A-241

(Formerly Permabond F241)

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PRODUCT DESCRIPTION

LOCTITE® Product A-241 is toughened two-step acrylic designed for applications requiring high impact or peel loads. Once mated, the two-step acrylic cures at room temperature.

TYPICAL APPLICATIONS

- High peel and impact applications
- Applications with chemical exposure

PROPERTIES OF UNCURED MATERIAL

Resin

	Typical Value
Chemical Type	Acrylic
Appearance	Off white
Viscosity @ 25°C, mPa.s (cP)	30,000
Specific Gravity, 25°C	1.00
Maximum Gap Fill, mm	0.75
Service Temperature, ºC	-60 to 120
On-part Life, minutes	5

Cure Speed

	Initiator No. 1	Initiator No. 5
Handling Strength	2-5 min	30-60 sec
Full Strength	24 hrs	24 hrs

Values are typical for steel surfaces. Other materials can increase or decrease the cure speed.

TYPICAL PROPERTIES OF CURED MATERIAL

Physical Properties

Description of curing parameters

Property	Typical Value
Shear Strength, psi (N/mm^2)	5,075 (35)
180º Peel Strength pli, (N/mm)	34 (6)

USE AND APPLICATION

Apply initiator to one surface sparingly. If bonding a porous surface, apply the initiator to the porous surface. Apply the A-241 to the second surface in a bead ensuring there is sufficient adhesive to completely fill the bond joint. Apply clamping pressure until the adhesive achieves handling strength. A-241 must be applied as a bead. Do not smooth the bead because reduced bond strength will occur.

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 Material Safety Data Sheet (MSDS).

Storage

Store product in cool, dry location, in unopened containers at a temperature between 5°C and 25°C (41°F to 75°F) unless otherwise labeled. Optimal storage is at the lower half of this temperature range. To prevent contamination of unused product, do not return any material to its original container. For further specific shelf life information, contact Application Engineering at (860) 571-5100.

Data Ranges

The data contained herein may be reported as a typical value and/or range.

Note

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