Technical Data Sheet

LOCTITE® AA 3924™

September 2020

PRODUCT DESCRIPTION

LOCTITE® AA 3924™ provides the following product characteristics:

Technology	Acrylic
Chemical Type	UV Acrylic
Appearance (uncured)	Transparent to hazy liquid and Free of undissolved solids
Fluorescence	Positive under UV light
Components	One component – requires no mixing
Cure	Ultraviolet (UV) / visible light
Cure benefit	Production - high speed curing
Application	Bonding
Viscosity	Medium

LOCTITE® AA 3924™ is suitable for a wide variety of applications that require fast cure, flexibility, high adhesion and autoclave resistance. LOCTITE® AA 3924™ cures in seconds when exposed to light of the proper wavelength and intensity and achieves excellent adhesion to glass, plastics and metal. The ability of this product to fluoresce under black light facilitates inspection of bonded assemblies for adhesive presence. LOCTITE® AA 3924™ was specifically designed for bonding stainless steel cannulae into hubs, syringes and lancets for needle assemblies. Suitable for use in the assembly of **disposable medical devices**.

ISO-10993

LOCTITE® AA 3924™ 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, Brookfield	
RVT, @25°C, mPa·s (cP)	800 to
Spindle 2, Speed 20 rpm	1,400[LMS]

TYPICAL CURING PERFORMANCE

Fixture Time

Fixture time is defined as the time to develop a shear strength of 0.1 N/mm².

UV Fixture time, Glass microscope slides, seconds:	
Black light:	
6 mW/cm², measured @ 365 nm,	≤ 5[LMS]
Zeta® 7410 light source:	
30 mW/cm², measured @ 365 nm,	<5
Electrodeless, D bulb:	
100 mW/cm², measured @ 365 nm,	<5

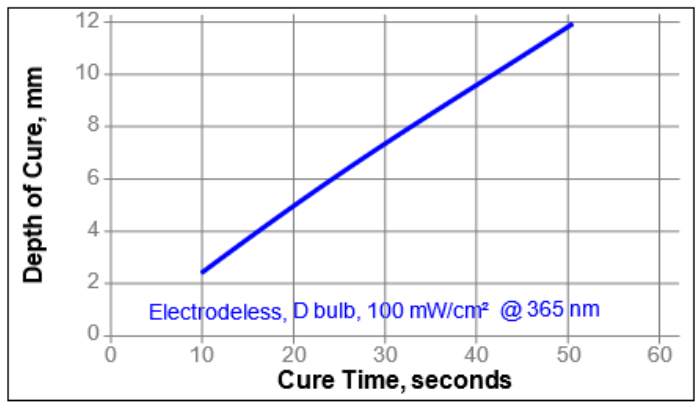
Tack Free Time

Tack free time is the time required to achieve a tack free surface.

Tack Free Time, seconds:	
Zeta® 7410 light source:	
30 mW/cm², measured @ 365 nm,	>60
Electrodeless, D bulb:	
100 mW/cm², measured @ 365 nm,	>60

Depth of cure

The graph below shows the increase in depth of cure with time at 100 mW/cm² as measured from the thickness of the cured product formed in an aluminum weighing dish.



TYPICAL PERFORMANCE OF CURED MATERIAL

Cured @ 100 mW/cm², measured @ 365 nm, for 30 seconds using an Electrodeless system, D bulb

Physical Properties:

Coefficient of Thermal Expansion, ISO 11359-2, K^{-1}:		
Pre Tg		135×10^{-06}
Post Tg		215×10^{-06}
Glass Transition Temperature, ISO 11359-2, °C		61
Water absorption, ISO 62, %:		
2 hours in water @ 100°C		5.5
7 days in water @ 22 °C		6.4
Linear Shrinkage, in/in		1.9
Shore hardness, ISO 868, Durometer D		60
Elongation, at break, ISO 527-3, %		280
Tensile strength, ISO 527-3	N/mm^2 (psi)	18 (2,600)
Tensile modulus, ISO 527-3	N/mm^2 (psi)	283 (41,100)

UV Depth of Cure, mm:
Cured @ 100 mW/cm², measured @ 365 nm, for 10 seconds, using an Electrodeless system, D bulb: ≥2.2[LMS]

Adhesive properties

Cured @ 1,000 mW/cm², measured @ 365 nm, for 10 seconds using an Electrodeless system, D bulb

Needle Pullout Strength:

Material	22 Gauge Cannula		27 Gauge Cannula	
ABS	N (lb)	142 (32)	N (lb)	71 (16)
Acrylic	N (lb)	142 (32)	N (lb)	80 (18)
Polycarbonate	N (lb)	120 (27)	N (lb)	49 (11)
Polyethylene	N (lb)	13 (3)	N (lb)	13 (3)
Polyethylene (plasma treated)	N (lb)	98 (22)	N (lb)	98 (22)
Polypropylene	N (lb)	22 (5)	N (lb)	22 (5)
Polypropylene (plasma treated)	N (lb)	120 (27)	N (lb)	98 (22)
Polystyrene	N (lb)	93 (21)	N (lb)	49 (11)
Polyurethane	N (lb)	125 (28)	N (lb)	58 (13)

Block Shear Strength, ISO 13445:
Cured @ 100 mW/cm², measured @ 365 nm, for 30 seconds.

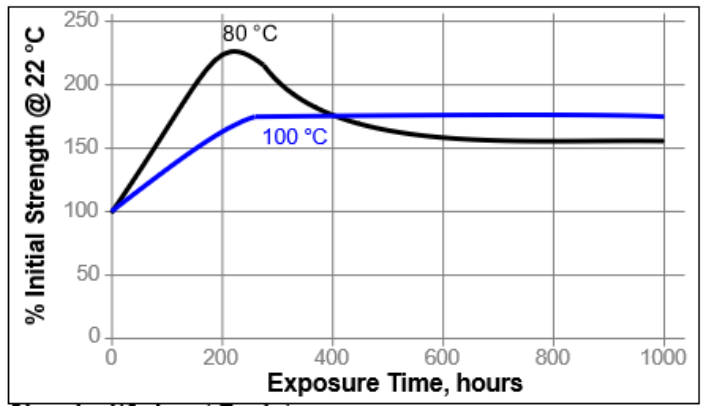
Acrylic to Glass:	N/mm^2 (psi)	4.2 (610)
Acrylic to Acrylic	N/mm^2 (psi)	7.7 (1,120)
G-10 Epoxy glass to Glass	N/mm^2 (psi)	8.6 (1,240)
Nylon to Glass	N/mm^2 (psi)	3.8 (550)
Polybutylene Terephthalate to Glass	N/mm^2 (psi)	6.7 (970)
Polycarbonate to polycarbonate	N/mm^2 (psi)	16.2 (2,350)
Polyvinylchloride to Glass	N/mm^2 (psi)	4.9 (710)
Aluminum (grit blasted) to Glass	N/mm^2 (psi)	10.0 (1,450)
Steel (grit blasted) to Glass	N/mm^2 (psi)	10.1 (1,460)

TYPICAL ENVIRONMENTAL RESISTANCE

Cured @ 100 mW/cm², measured @ 365 nm, for 30 seconds.
Block Shear Strength, ISO 13445:
Polycarbonate to polycarbonate

Heat Aging

Aged at temperature indicated and tested @ 22 °C.



Chemical/Solvent Resistance
Aged under conditions indicated and tested @ 23°C.

		% of initial strength			
Environment	°C	24 h	100 h	500 h	1000 h
95% RH	40	--	140	100	110
Water Immersion	22	--	90	90	140
Isopropanol	22	75	--	--	--
Heptane	22	90	--	--	--

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	165	110
27 Gauge Cannula	115	115
Polypropylene (plasma treated):		
22 Gauge Cannula	130	80
27 Gauge Cannula	115	100
Polystyrene:		
22 Gauge Cannula	180	165
27 Gauge Cannula	170	140

Sterilization Resistance of Needle Assemblies
Sterilized as indicated and tested @ 22 °C
Needle Pullout Strength, % of initial strength:

	Gamma	ETO	Autoclave	
Polycarbonate				
22 Gauge Cannula	155	150	110	130
27 Gauge Cannula	150	135	105	115
Polypropylene (plasma treated)				
22 Gauge Cannula	130	125	115	110
27 Gauge Cannula	110	110	95	80
Polystyrene				
22 Gauge Cannula	130	130	----	----
27 Gauge Cannula	130	120	----	----

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. The product should be dispensed from application with black feedlines.
3. For best performance bond surfaces should be clean and free from grease.
4. Cure rate is dependent on lamp intensity, distance from light source, depth of cure needed or bondline gap and light transmission of the substrate through which the radiation must pass.
5. Cooling should be provided for temperature sensitive substrates such as thermoplastics.
6. Plastic grades should be checked for risk of stress cracking when exposed to liquid adhesive.
7. Excess uncured adhesive can be wiped away with organic solvent (e.g. Acetone).
8. Bonds should be allowed to cool before subjecting to any service loads.

Storage
Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.
Optimal Storage: 8°C to 21°C. Storage below 8°C or greater than 28°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.

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.

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

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

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

Disclaimer
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