TECHNICAL DATASHEET
CYANOLIT® 241 F

PRODUCT DESCRIPTION

Modified cyanoacrylate | 1 part | solvent-free | room temperature curing

- Medical device assembly
- Adhesion to plastics and metal
- Capillary flowing
- Certified according to USP Class VI

CURING PROPERTIES

Curing takes place without heat supply or pressure. The classical one-component cyanoacrylates react with moisture, which is absorbed as a moisture film on the material surfaces, in a few seconds.

The curing speed depends on the gap width and the humidity level. A small gap width and a high humidity accelerate the setting process.

Cyanolit® attains high strength after a short period of curing. Full strength and reliability is obtained after 24h. Only after this time is the optimum media resistance achieved.

The following table describes the setting times on different substrates.

Substrate	Fixture time [s]
PVC	5
PMMA	10
ABS	15
PC	20
NR	5
Steel	10

Substrate failure

TECHNICAL DATASHEET
CYANOLIT® 241 F

TECHNICAL DATA

Resin	Ethyl-2-cyanoacrylate
Appearance	Transparent
Max. gap size [mm]	0.15

Uncured Material	
Viscosity [mPas]	30 – 50
Density [g/cm³] *Test instruction P004*	1.1

Cured Material	
Typical operating temperature [°C]	-80 – 80

TRANSPORT/STORAGE/SHELF LIFE

Package type	Transport	Storage	Shelf life*
Bottles	At room temperature max. 25°C	0°C – 10°C	At delivery min. 4.5 months max. 9 months

Store in original, unopened containers!

INSTRUCTIONS FOR USE

Surface preparation

The surfaces to be bonded should be free of dust, oil, grease, mold release, or other contaminants in order to obtain an optimal and reproducible bond. For cleaning we recommend the cleaner IP® from Hoenle, or a solution of Isopropyl Alcohol at 90% or higher concentration. Substrates with low surface energy (e.g. polyethylene, polypropylene) must be pretreated in order to achieve sufficient adhesion.

Application

Our products are supplied ready to use. Depending on packaging they can be applied by hand directly from the container or by using compatible dispensing systems and automation.

Cyanoacrylate adhesives react very quickly with humidity (20% - 80%) or the moisture film on the materials. It is therefore advisable to wear gloves and goggles when handling larger quantities. Cyanolit® is applied punctiform - one or more drops, depending on the size of the surface, onto one of the joining parts. The second joining part is fixed with slight pressure, whereby the adhesive is distributed into a thin film. Acid surfaces prevent or retard the curing, while basic surfaces (pH>7) accelerate curing.

The application can take place directly from the tip of the dosing bottle, but also with dosing devices. Since the achievable strength depends on the application quantity, an even dosage must be considered.
For assistance with dispensing and curing questions, please contact our Applications Engineering department. To obtain best results, the adhesive and substrates to be bonded may not be cold and should be allowed to warm to room temperature prior to processing.

Storage

Store uncured product in its original, closed container in a dry location. Any material removed from the original container must not be returned to the container as it could be contaminated. Hoenle cannot assume responsibility for products that were improperly stored, contaminated, or repackaged into other containers.

Handling and Clean-up

For safe handling information, consult this product's Material Safety Data Sheet (MSDS) prior to use. Uncured material may be wiped away from surfaces with organic solvents. Do not use solvents to remove material from eyes or skin!

DISCLAIMER

The product is free of heavy metals, PFOS and Phthalates and is conform to the current EU-Directive RoHS.

THE VALUES NOTED IN THIS TECHNICAL DATA SHEET ARE TYPICAL PROPERTIES AND ARE NOT MEANT TO BE USED AS PRODUCT SPECIFICATIONS.

The information contained in this data sheet is believed to be accurate and is provided for information only. Hoenle makes no representation or warranties of any kind concerning this information. It is the user's responsibility to determine the suitability of this product for any intended use. Hoenle does not assume responsibility for test or performance results obtained by the user. The user assumes all risk and liability connected with the use of this product.

The user should adopt such precautions and use guidelines as may be advisable for the protection of property and persons against any hazards that may be involved in this product's handling or use. Hoenle specifically disclaims any liability for consequential or incidental damages of any kind arising from the handling or use of this product. The information contained in this Technical Data Sheet offers no assurance that the product use, application, or process will not infringe on existing patents or licenses of others. Nothing in this Technical Data Sheet transfers or grants license for the use of any patents, trade secrets, intellectual property, or confidential information that is the property of Hoenle.

Except as otherwise noted, all trademarks in this document (identified as ®) are the property of Hoenle.

CONTACT

Hoenle Adhesives GmbH | Stierstädter Straße 4 | 61449 Steinbach | Germany
T: +49 6171 6202-0 | adhesivesystems@hoenle.com

For regional sales and technical support, please refer to our global contact directory https://www.hoenle.com/contact.