



Henkel Loctite offers the most comprehensive line of adhesives and sealants available to the medical device industry. These USP Class VI and/or ISO-10993 compliant products are designed specifically for the assembly of medical devices where toxicity testing and sterilization resistance are required.

# BONDING

## MEDICAL DEVICE ADHESIVES

### LIGHT CURE ACRYLIC ADHESIVES

#### **3011 Light Cure Acrylic Adhesive**

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A low viscosity, wicking, UV adhesive that bonds clear plastics, metals, and glass. Designed specifically for needle bonding applications.

#### **3051 Light Cure Acrylic Adhesive**

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A tough UV adhesive. Excellent for glass and optical applications.

#### **3091 Light Cure Acrylic Adhesive**

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A high viscosity, fluorescing, UV adhesive that is ideal for bonding rigid assemblies.

#### **3201 Light Cure Acrylic Adhesive**

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A high viscosity, UV/visible adhesive that forms very flexible joints with minimal stress cracking. Ideal for bonding polycarbonate and other thermoplastics.

#### **3311 Light Cure Acrylic Adhesive**

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A low viscosity, slightly flexible, UV/visible adhesive. Excellent for bonding thermoplastics and plasticized PVC.

#### **3341 Light Cure Acrylic Adhesive**

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A rapid cure, UV/visible, fluorescing adhesive that bonds highly plasticized PVC and other difficult-to-bond substrates.

#### **3345 Light Cure Acrylic Adhesive**

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A medium viscosity, UV adhesive with superior steam sterilization resistance. Excellent for bonding glass, metal, and select plastics.

#### **3381 Light Cure Acrylic Adhesive**

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A highly resilient, extremely flexible, thermal-cycling-resistant UV adhesive that bonds most plastics.

**EPOXY ADHESIVES**

**M-21HP HYSOL®**

An off-white, toughened epoxy that provides high peel resistance and high shear strength on a wide variety of plastics and metals.

**M-31CL HYSOL®**

A low viscosity epoxy that bonds glass, ceramic, metal, and many rigid plastics. Ideal for applications where optical clarity and excellent structural and mechanical properties are required.

**M-121HP HYSOL®**

A high viscosity, non-sagging epoxy for applications that require high impact resistance and high peel strength. Bonds dissimilar materials including aluminum, steel, and other metals, as well as a variety of plastics and ceramics.

**CYANOACRYLATE ADHESIVES**

**4011 PRISM®**

A low viscosity, instant adhesive ideally suited for dry environments, as well as for bonding acidic and porous surfaces.

**LIGHT CURE CYANOACRYLATE ADHESIVES**

**4304/4305 FLASHCURE® Adhesives**

Low or high viscosity adhesives achieve tack-free cures in less than 5 seconds. Surface versatile with shadow cure capability.

**SILICONE ADHESIVES**

**5248 Silicone Adhesive**

A self-leveling, UV silicone ideal for sealing and bonding extruded and moldable silicones, glass, and metals.

**URETHANE ADHESIVES**

**M-06FL HYSOL®**

A urethane adhesive that forms highly flexible joints. An off-white, medium viscosity urethane ideal for use on metals, plastics, glass, and other substrates.

**M-11FL HYSOL®**

A low viscosity urethane that bonds polycarbonate and a variety of other plastics, glass, and metal. When fully set, product forms an ultra-clear bond line and provides excellent peel strength.

*View our selector guide on-line, visit us on the web at:*



### LIGHT CURE ACRYLIC ADHESIVES PROPERTIES CHART

PRODUCT	Item Number	Container	Appearance Clarity/Color	Cure Type	Key Substrates	Viscosity, cP Brookfield, 25°C	Temperature Range
3011	18011	1 liter bottle	Clear/ light amber	Ultraviolet	Glass, metal, thermoplastic	100	-65°F to 250°F
3051	18679*	1 liter bottle	Clear/ pale straw	Ultraviolet	Glass, metal	1,100	-65°F to 300°F
3091	18659	1 liter bottle	Clear/ colorless/ fluorescent	Ultraviolet	Glass, metal, thermoplastic	6,000	-65°F to 250°F
3201	19727 19728	25 ml syringe 1 liter bottle	Clear/ pale straw	Ultraviolet, visible	Glass, metal, thermoplastic, polycarbonate	4,000	-65°F to 300°F
3211	19730 19731*	25 ml syringe 1 liter bottle	Clear/ pale straw	Ultraviolet, visible	Glass, metal, thermoplastic, polycarbonate	10,000 Thixotropic	-65°F to 300°F
3301	19733 19734	25 ml syringe 1 liter bottle	Clear/ pale straw	Ultraviolet, visible	Glass, metal, thermoplastic, polycarbonate, polyvinylchloride	150	-65°F to 300°F
3311	19736 19737	25 ml syringe 1 liter bottle	Clear/ pale straw	Ultraviolet, visible	Glass, metal, thermoplastic, polycarbonate, polyvinylchloride	300	-65°F to 300°F
3321	19739 19740	25 ml syringe 1 liter bottle	Clear/ pale straw	Ultraviolet, visible	Glass, metal, thermoplastic, polycarbonate, polyvinylchloride	5,000	-65°F to 300°F
3341	23792 23440	25 ml syringe 1 liter bottle	Clear/ straw/ fluorescent	Ultraviolet, visible	Thermoplastics, polyvinylchloride	450	-65°F to 300°F
3345	33417 30688	25 ml syringe 1 liter bottle	Clear/ pale straw	Ultraviolet	Glass, metal	1,500	-65°F to 300°F
3381	25785 24690*	25 ml syringe 1 liter bottle	Translucent/ colorless	Ultraviolet	Thermoplastic, thermoset plastic	5,000	-65°F to 300°F

\* Made to order item.

### HYSOL® EPOXY ADHESIVES PROPERTIES CHART

PRODUCT	Item Number	Container	Appearance Clarity/Color	Cure Type	Key Substrates	Viscosity, cP Mixed Brookfield, 25°C	Temperature Range
M-21HP	30671 30672	50 ml dual cartdg. 200 ml dual cartdg.	Off white	Room temperature	Thermoplastic, thermoset plastic, elastomer, metal, glass, ceramic	37,000	-65°F to 250°F
M-31CL	30673 30674	50 ml dual cartdg. 200 ml dual cartdg.	Ultra clear	Room temperature	Thermoplastic, thermoset plastic, polycarbonate, metal, glass, ceramic	6,000	-65°F to 275°F
M-121HP	30680 30682	50 ml dual cartdg. 200 ml dual cartdg.	Amber	Room temperature	Thermoplastic, polycarbonate, polyvinylchloride, metal, glass, ceramic	11,000	-65°F to 265°F

### LIGHT CURE CYANOACRYLATE ADHESIVES PROPERTIES CHART

PRODUCT	Item Number	Container	Appearance Clarity/Color	Cure Type	Key Substrates	Viscosity, cP Mixed Brookfield, 25°C	Temperature Range
4304	32254 32407	1 oz. bottle 1 lb. bottle	Clear/ pale green	Ultraviolet, visible, moisture	Thermoplastic, polycarbonate, elastomer, metal	20	-65°F to 180°F
4305	32268 32409	1 oz. bottle 1 lb. bottle	Clear/ pale green	Ultraviolet, visible, moisture	Thermoplastic, polycarbonate, elastomer, metal	900	-65°F to 180°F

**CYANOACRYLATE ADHESIVES  
PROPERTIES CHART**

PRODUCT	Item Number	Container	Appearance Clarity/Color	Cure Type	Key Substrates	Viscosity, cP Brookfield, 25°C	Temperature Range
4011	18680 18681	20 gm bottle 1 lb. bottle	Clear	Moisture	Thermoplastic, thermoset plastic, metal, elastomer, including rubber	100	-65°F to 180°F
4013	20268 18013	20 gm bottle 1 lb. bottle	Clear	Moisture	Thermoplastic, thermoset plastic, metal	500	-65°F to 180°F
4014	20269 18014	20 gm bottle 1 lb. bottle	Clear	Moisture	Thermoplastic, thermoset plastic, metal	3	-65°F to 220°F
4031	18682 18683	20 gm bottle 1 lb. bottle	Clear	Moisture	Thermoplastic, thermoset plastic, metal	1,300	-65°F to 160°F
4061	18686 18687	20 gm bottle 1 lb. bottle	Clear	Moisture	Thermoplastic, thermoset plastic, metal, elastomer, including rubber	20	-65°F to 180°F
4081	18688 18689	20 gm bottle 1 lb. bottle	Clear	Moisture	Thermoplastic, thermoset plastic, metal	5	-65°F to 160°F
4206	28628 28629	20 gm bottle 1 lb. bottle	Clear	Moisture	Thermoplastic, thermoset plastic, metal, elastomer, including rubber	375	-65°F to 250°F
4541	18690 18691	20 gm bottle 200 gm bottle	Clear	Moisture	Thermoplastic, thermoset plastic, metal, elastomer, including rubber	Gel	-65°F to 180°F
4601	18692 18693	20 gm bottle 1 lb. bottle	Clear	Moisture	Thermoplastic, thermoset plastic, metal	50	-65°F to 160°F
4981	18694 18695	20 gm bottle 1 lb. bottle	Clear	Moisture	Thermoplastic, thermoset plastic, metal, elastomer, including rubber	500	-65°F to 220°F

**SILICONES ADHESIVES  
PROPERTIES CHART**

PRODUCT	Item Number	Container	Appearance Clarity/Color	Cure Type	Key Substrates	Viscosity, cP Brookfield, 25°C	Temperature Range
5248	19987	300 ml cartridge	Translucent/ straw	UV, Moisture	Elastomer, metal, glass	50,000	-65°F to 400°F

**HYSOL® URETHANE ADHESIVES  
PROPERTIES CHART**

PRODUCT	Item Number	Container	Appearance Clarity/Color	Cure Type	Key Substrates	Viscosity, cP Mixed Brookfield, 25°C	Temperature Range
M-06FL	30676 30677	50 ml dual cartdg. 200 ml dual cartdg.	Off white	Room temperature	Thermoplastic, thermoset plastic, polycarbonate, elastomer, metal, glass, ceramic	38,000	-65°F to 250°F
M-11FL	30678 30679	50 ml dual cartdg. 200 ml dual cartdg.	Ultra clear	Room temperature	Thermoplastic, thermoset plastic, polycarbonate, elastomer, metal, glass, ceramic	3,800	-65°F to 250°F

**ACCELERATOR & PRIMER  
PROPERTIES CHART**

PRODUCT	Item Number	Container	Appearance Clarity/Color	Cure Type	Key Features	Viscosity, cP Brookfield, 25°C	Temperature Range
713 Accelerator	19889	1.75 oz.	Clear	–	Accelerator for cyanoacrylates	1	–
7701 Prism® Primer	19886 19887	1.75 oz. 16 oz.	Clear	–	Adhesion promoter for low energy surface plastics	3	–