

LOCTITE[®] AA 3554

Known as LOCTITE[®] 3554[™]
September 2020

PRODUCT DESCRIPTION

LOCTITE[®] AA 3554 provides the following product characteristics:

Technology	Acrylic
Chemical Type	Acrylated urethane
Appearance (uncured)	Transparent yellow liquid with green tint ^{LMS}
Fluorescence	Positive ^{LMS}
Components	One component - requires no mixing
Viscosity	Medium
Cure	Visible light
Application	Bonding and Potting

LOCTITE[®] AA 3554 cures rapidly when exposed to UV / visible light of sufficient intensity. The rapid cure characteristics of this product make it ideal for potting applications which require a fast and large depth of cure. The ability of this product to fluoresce under black light facilitates inspection of bonded assemblies for adhesive presence. LOCTITE[®] AA 3554 is suitable for a wide variety of applications that require bonding polycarbonate to itself and a variety of other substrates, while not inducing stress cracking under typical molded stress levels. Suitable for use in the assembly of **disposable medical devices**.

ISO-10993

An ISO 10993 Test Protocol is an integral part of the Quality Program for LOCTITE[®] AA 3554. LOCTITE[®] AA 3554 has been qualified to Henkel's ISO 10993 Protocol as a means to assist in the selection of products for use in the medical device industry. Certificates of Compliance are available on Henkel's website or through the Henkel Quality Department.

TYPICAL PROPERTIES OF UNCURED MATERIAL

Specific Gravity @ 25 °C	1.11
Flash Point - See SDS	
Viscosity, Cone & Plate, 25 °C, mPa·s (cP):	
Shear rate 50 s ⁻¹	200 to 400 ^{LMS}

TYPICAL CURING PERFORMANCE

LOCTITE[®] AA 3554 can be cured by irradiation with visible light greater than 400 nm wavelength of sufficient intensity. Cure rate and ultimate depth of cure depend on light intensity, spectral distribution of the light source, exposure time and light transmittance of the substrate through which the light must pass.

Stress Cracking

Liquid adhesive is applied to a medical grade polycarbonate bar 6.4 cm by 13 mm by 3 mm which is then flexed to induce a known stress level. The time until stress cracking is observed.

Stress Cracking, ASTM D 3929, minutes:	
13.8 N/mm ² stress on bar	>15
17.2 N/mm ² stress on bar	5 to 15

Fixture Time

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

UV Fixture Time, Polycarbonate, seconds:	
500 mW/cm ² , measured @ >400 nm using a Indigo [™] Cure Jet	<5
500 mW/cm ² , using a Loctite [®] 7720 [™] Visible Wand System	<5
225 mW/cm ² , measured @ >400 nm using a LOCTITE [®] Indigo [™] 7418 Visible Flood Source	<5

Tack Free Time

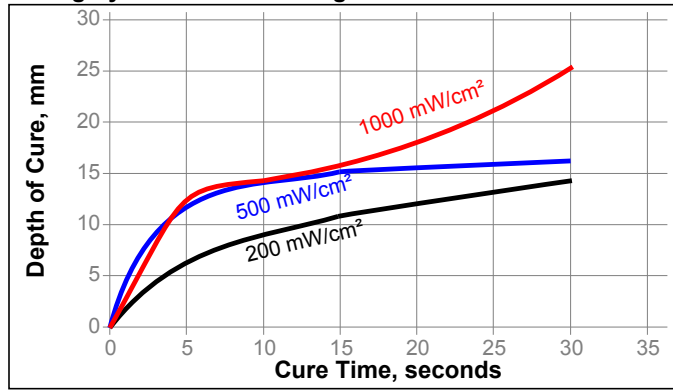
Tack Free Time is the time required to achieve a tack free surface
Tack Free Time, seconds:

280 mW/cm ² , measured @ >400 nm using a LOCTITE [®] Indigo [™] 7418 Visible Flood Source	<10 ^{LMS}
500 mW/cm ² , measured @ >400 nm using a Loctite [®] 7720 [™] Visible Wand System	<5

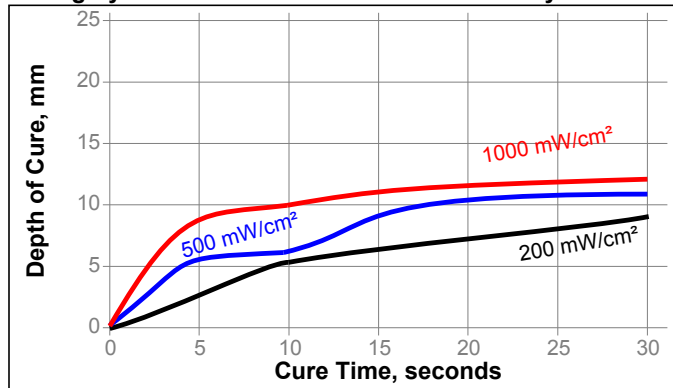
Depth of Cure vs. Irradiance

The graphs below show the increase in depth of cure with time at various irradiances as measured from the thickness of the cured product formed in a 25 mm diameter Delrin block.

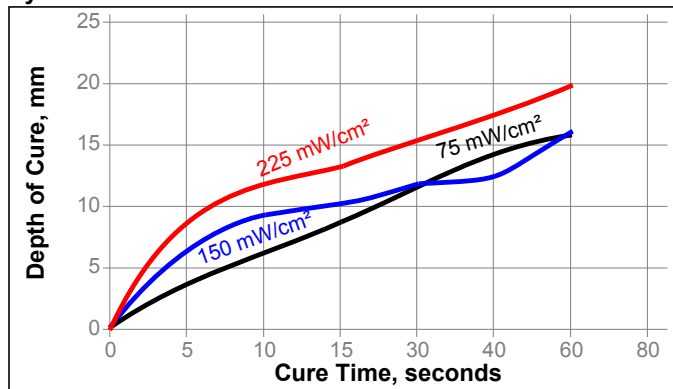
Curing System: Loctite® Indigo™ Cure Jet



Curing System: Loctite® 7720™ Visible Wand System



Curing System: Loctite® Indigo™ 7418 Visible Flood System



TYPICAL PROPERTIES OF CURED MATERIAL

Cured @ 225 mW/cm², for 30 seconds per side. using a LOCTITE® Indigo™ 7418 Visible Flood Source with a spectral output of > 400 nm.

Physical Properties

Linear Shrinkage, in/in ASTM D 792,	4.4
Volume Shrinkage, ASTM D 792, %	12.7
Shore Hardness, ISO 868, Durometer D	75
Refractive Index	1.51

Water Absorption, ISO 62, %:	
2 hours in boiling water	7.8
Elongation, at break, ISO 527-3, %	6.3
Glass Transition Temperature(Tg) , ISO 11359-2, °C	49
Coefficient of Thermal Expansion, ISO 11359-2, K ⁻¹ :	
Pre Tg	81×10 ⁻⁶
Post Tg	209×10 ⁻⁶
Tensile Strength, at break, ISO 527-3	N/mm ² 42 (psi) (6,150)
Tensile Modulus, ISO 527-3	N/mm ² 1,520 (psi) (220,000)

Electrical Properties

Surface Resistivity, IEC 60093, Ω	1.4×10 ¹⁵
Volume Resistivity, IEC 60093, Ω·cm	3.7×10 ¹⁵
Dielectric Breakdown Strength, IEC 60093, kV/mm	32.4
Dielectric Constant / Dissipation Factor, IEC 60250:	
1 Kz	3.5 / 0.02
100 kHz	3.3 / 0.02
1 MHz	3.2 / 0.03

TYPICAL PERFORMANCE OF CURED MATERIAL

Adhesive Properties

Cured @ 225 mW/cm², for 30 seconds using a LOCTITE® Indigo™ 7418 Visible Flood Source with a spectral output of > 400 nm

Lap Shear Strength, :

Polycarbonate (UV absorbing) to Stainless steel	N/mm ² 5 (psi) (725)
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Block Shear Strength, ISO 13445:

Polycarbonate (UV absorbing) to Polycarbonate (UV absorbing)	N/mm ² 40 (psi) (5,770)
Nylon to Polycarbonate (UV absorbing)	N/mm ² 4 (psi) (580)
ABS to Polycarbonate (UV absorbing)	N/mm ² 28 (psi) (4,010)
PVC to Polycarbonate (UV absorbing)	N/mm ² 39 (psi) (5,600)

Cured @ 280 mW/cm², measured @ >400 nm for 10 seconds using a LOCTITE® Indigo™ 7418 Visible Flood Source .

Block Shear Strength, ISO 13445:

Polycarbonate (UV absorbing)	N/mm ² ≥20.68 ^{LMS} (psi) (≥2,999)
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Cured @ 500 mW/cm², measured @ >400 nm for 10 seconds using a Indigo™ Cure Jet

Needle Pullout Strength:

Material	22 Gauge Cannula	27 Gauge Cannula
ABS	N 142	N 102
	(lb) (32)	(lb) (23)
Polycarbonate	N 75	N 53
	(lb) (17)	(lb) (12)
Polystyrene	N 53	N 44
	(lb) (12)	(lb) (10)

TYPICAL ENVIRONMENTAL RESISTANCE

Cured @ 400 mW/cm², for 30 seconds using a Visible Arc Light Source with a spectral output of > 400 nm.

Block Shear Strength, ISO 13445, % of initial strength:

Polycarbonate (UV absorbing)

Chemical/Solvent Resistance

Aged under conditions indicated and tested @ 23 °C.

Environment	°C	% of initial strength			
		2 h	170 h	500 h	1000 h
Air	70	-----	97	95	46
Air	95	-----	98	98	13
Water	100	23	-----	-----	-----
Water immersion	50	-----	26	6	4
Isopropanol immersion	22	-----	81	78	92
Heat/humidity 95% RH	38	-----	81	40	19

Effects of Sterilization

In general, products similar in composition to LOCTITE® AA 3554 subjected to standard sterilization methods, such as EtO and Gamma Radiation (25 to 50 kiloGrays cumulative) show excellent bond strength retention. LOCTITE® AA 3554 maintains bond strength after 1 cycle of steam autoclave. It is recommended that customers test specific parts after subjecting them to the preferred sterilization method. Consult with Loctite® for a product recommendation if your device will see more than 3 sterilization cycles.

Sterilization Resistance of Needle Assemblies

Sterilized as indicated and tested @ 22 °C

Needle Pullout Strength, % of initial strength:

	Gamma 30kGy	ETO 1 Cycle	Autoclave 1 Cycle
Polycarbonate:			
22 Gauge Cannula	223	240	176
27 Gauge Cannula	116	200	183

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 visible 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 applicators 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 transmittance 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.

Loctite Material Specification^{LMS}

LMS dated August 15, 2007. Test reports for each batch are available for the indicated properties. LMS test reports include selected QC test parameters considered appropriate to specifications for customer use. Additionally, comprehensive controls are in place to assure product quality and consistency. Special customer specification requirements may be coordinated through Henkel Quality.

Storage

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

Optimal Storage: 20 to 30 °C. Storage below 20°C or above 30°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.

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

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Reference 0.3