

LOCTITE® AA F241

August 2025

Product description

LOCTITE® AA F241 provides the following product characteristics:

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|---------------|-----------------------|
| Technology | Acrylate |
| Chemical type | Acrylic |
| Appearance | Off-white |
| Cure | Room temperature cure |
| Application | Bonding |

LOCTITE® AA F241 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

Typical properties of uncured material

| | |
|------------------------------|------------|
| Viscosity @ 25°C, mPa.s (cP) | 30,000 |
| Specific gravity @ 25°C | 1.00 |
| Maximum gap fill (mm) | 0.75 |
| Service temperature, °C | -60 to 120 |
| On part life, minutes | 5 |

Cure speed

| | |
|----------------------------|-------|
| Handling strength, minutes | |
| Initiator SF 737 | 2-5 |
| Initiator No.5 | 0.5-1 |
| Full strength, hours | |
| Initiator SF 737 | 24 |
| Initiator No.5 | 24 |

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

Typical properties of cured material

Physical properties

| | | |
|--------------------|----------------------------|---------------|
| Shear strength | N/mm ² (psi) | 35 (5,076) |
| 180° Peel strength | N/mm (lb/in) | 6 (35) |

Directions for use

1. Apply initiator to one surface sparingly.
2. If bonding a porous surface, apply the initiator to the porous surface.
3. Apply the LOCTITE® AA F241 to the second surface in a bead ensuring there is sufficient adhesive to completely fill the bond joint.
4. Apply clamping pressure until the adhesive achieves handling strength.
5. LOCTITE® AA F241 must be applied as a bead.
6. Do not smooth the bead because reduced bond strength will occur.

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).

Storage

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

Optimal storage: 5°C to 25°C. Storage below 5°C or greater than 25°C can adversely affect product properties.

Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel 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.

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

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

Conversions $(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$ $\text{kV/mm} \times 25.4 = \text{V/mil}$ $\text{mm} / 25.4 = \text{inches}$ $\mu\text{m} / 25.4 = \text{mil}$ $\text{N} \times 0.225 = \text{lb}$ $\text{N/mm} \times 5.71 = \text{lb/in}$ $\text{N/mm}^2 \times 145 = \text{psi}$ $\text{MPa} \times 145 = \text{psi}$ $\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$ $\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$ $\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$ $\text{mPa}\cdot\text{s} = \text{cP}$ **Disclaimer**

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Reference 1