

# TECHNICAL DATA SHEET

## Drei Bond 4041

Revision: 13.05.2020  
Version: 1.005



### PRODUCT PROPERTIES

The product Drei Bond 4041 is a fast-curing one-component, low-viscosity, ethyl-based cyanoacrylate adhesive. It is designed for bonding materials with tightly adherent surfaces, plastics, rubber, elastomers. Very good capillary properties. With the use of DB 4007 activator, it is suitable for bonding difficult-to-bond material pairs, e.g. PE, PP, silicone rubber, Teflon.

### PHYSICAL PROPERTIES

Appearance	liquid
Colour	colorless
Viscosity at 25°C	5 – 10 mPa·s Brookfield
Specific weight at 25°C	1.05 g/cm <sup>3</sup>
Gap to fill	10 – 40 µm

### CURING PROPERTIES

Fixture time in seconds:

#### Material

plastics		metal			wood							other materials				
PVC	phenolic resin	ABS	steel	Alu	zinc	fir	balsa	teak	laurel	pine	oak	chipboard	neoprene / NBR	fabric	leather	paper
2 – 10*	2 - 10	2 - 10	5 - 20	2 - 10	10 - 20	30 - 60	2 - 5	5 - 20	10 - 30	5 - 20	30 - 60	30 - 60	< 2	2 - 20	5 - 10	5 - 10

\* Time given in seconds to reach functional strength at 40%±60% relative humidity.  
The joint reaches full chemical resistance after 24 hours.

### PROPERTIES IN THE CURED STATE

Temperature resistance	-50°C/+80°C
Tensile strength ISO 6922, steel	18 – 25 N/mm <sup>2</sup>
Shear strength ISO 4587	13 – 18 N/mm <sup>2</sup>
Softening range	+160°C/+170°C
Refractive index n <sup>20</sup> D	similar to glass
Electrical resistivity DIN 53482	> 10 <sup>15</sup> Ω mm
Dielectric strength	25 Kv/mm
Dielectric constant DIN 53483 (1MHz)	5,2

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### CURING RATE AND THE STRENGTH OF THE JOINT DEPENDS ON:

- air humidity,
- pressing force,
- temperature,
- material surfaces. For bonding difficult-to-glue materials, we recommend Drei Bond 4007 activator.
- surface preparation before bonding,
- gap.

### DIRECTIONS FOR USE

- Clean, dry and grease-free surfaces ensure the maximum strength. Clean soiled surfaces with DB Cleaner 3200 or DB Cleaner Plastic (recommended for plastics).
- Apply the adhesive on one side to the prepared surface and press the parts to be joined together.
- Bonding of inactive surfaces with activator DB 4007:
  - the activator should **only** be applied to the inactive surface,
  - wait 60÷90 s (until the activator evaporates completely),
  - apply the adhesive on one side to the prepared surface and press the parts.
- The activator allows excess glue to be cured. To do this, the activator must be applied to the adhesive.
- Activator DB 4009 is a product designed to speed up the curing time of CA glue.

### STORAGE

- 12 months in unopened packaging.
- The optimal storage temperature for cyanoacrylate adhesives is +4°C to +8°C.
- After opening for the first time, make sure to tighten the bottle thoroughly. Avoid contact with humidity.

### PACKAGE UNITS

- For manual application                      20 g, 50 g
- For industrial use                              500 g

**For automatic processing we recommend to use Drei Bond application systems from stand-by equipments to full automatic CNC-controlled dosing machines.**

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