LOCTITE®

LOCTITE® 3D IND402™

Elastomer
Black

LOCTITE®
Henkel Corporation
loctite3d@henkel.com

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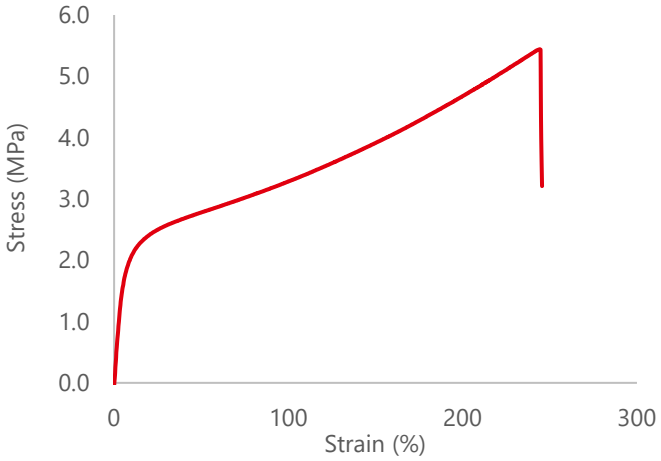
LOCTITE 3D IND402™

LOCTITE 3D IND402 is a single component elastomer material with high elongation and high resilience, excellent tensile strength and high energy return while also not requiring thermal post processing.

Parts can be printed with various DLP platforms.



Benefits:

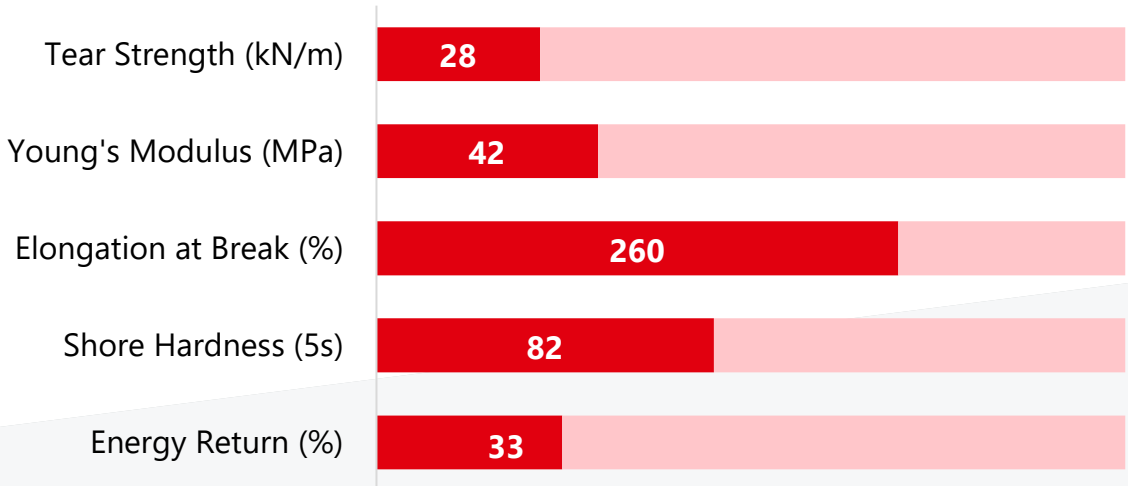
- True elastomeric behavior
- Excellent interlayer adhesion
- Good rebound performance

Ideal for:

- Consumer products
- Lattice structures for sportswear

Markets:

Industry | Automotive | Consumer Goods



**Values shown are linked to LOCTITE IND402 Black as reference, please refer to the specific mechanical properties for each of the colors shown in this document*

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PROPERTIES

Mechanical Properties	Measure	Method	Green	Post Processed
Young's Modulus	MPa	ASTM D638	15 ± 2 [7]	42 ± 5 [1]
Tensile Stress at Break	MPa	ASTM D638	2.3 ± 0.31 [7]	5.5 ± 0.2 [1]
Elongation at Break	%	ASTM D638	176 ± 44 [7]	230 ± 10 [1]
Poisson's Ratio	-	ASTM D638	-	0.49 ± 0.04 [14]
Stress at 50% Strain	MPa	ASTM D412	-	3.0-3.5 [8]
Stress at 100% Strain	MPa	ASTM D412	-	3.4-4.0 [8]
Stress at 150% Strain	MPa	ASTM D412	-	4.0-4.6 [8]
Strain at Break	%	ASTM D412	-	260 - 295 [8]
Stress at Break	MPa	ASTM D412	-	6.1 - 7.0 [8]
Tear Strength	kN/m	ASTM D624	-	28 ±1 [4]
Energy Return	%	Internal	-	30 – 35 [2]
Compression Set (22hr)	%	ASTM D395	-	57.1 [11]
Shore Hardness (5s)	A	ASTM D2240	-	82 [5]
Other Properties				
Water Absorption (24hr)	%	ASTM D570	-	3.62 [3]
Water Absorption (48hr)	%	ASTM D570	-	4.94 [3]
Solid Density	g/cm^3	ASTM D1475	-	1.1 [6]
Thermal Conductivity	W/(m·K)	ASTM D5930	-	0.16 [13]
Heat Capacity	J/(g·K)	ASTM D5930	-	2.0 ± 0.2 [13]
CTE (-40°C to 40°C)	µm/(m·K)	ISO 11359-2	-	187.1 [9]
Glass Transition (T_G)	°C	ASTM E1356	-	-66 [10]
Biocompatibility				
Irritation		ISO 10993-23*		Comply[12]

All specimen are printed unless otherwise specified. ASTM Methods: D638 Type IV, 50mm/min, 2mm/min, D624, D570-98 24-hour water immersion, specimen 50.8mm diameter, 3.2mm thick, D412 Type C 500mm/min, D638 Type I for Poisson's Ratio, 5 mm/min

The biological assessment has been performed based on the in vitro method according to ISO10993-23

Internal Data Sources:
[1]FOR18387, [2]FOR18388, [3]FOR22826, [4]FOR18664, [5]FOR464255, [6]FOR20028, [7]FOR18709, [8]GEN1526, [9]FOR94747, [10]FOR99382, [11]FOR146871, [12]FOR52817
[13]FOR574325, [14] FOR663210

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PROPERTIES

Liquid Properties	Measure	Method	Value
Viscosity at 25°C (77°F)	cP	ASTM D7867	10800 - 15400 [1]
Viscosity at 35°C (95°F)	cP	ASTM D7867	8000 - 9000 [2]
Viscosity at 40°C (104°F)	cP	ASTM D7867	6000 - 7000 [2]
Liquid Density	g/cm³	ASTM D1475	1.0439 [3]
Flow Characteristic	-		Self-leveling
Appearance Color	-		Black

Electrical Properties	Measure	Method	Green	Post Processed
Volume Resistivity	Ω·cm	ASTM D257	-	$2.0 \cdot 10^{11}$ [4]
Surface Resistivity	Ω	ASTM D257	-	$4.7 \cdot 10^{12}$ [4]
Dielectric Strength	kV/mm	ASTM D149	-	21.3 [4]
AC Relative Permittivity (Dielectric Constant)				
at 50 Hz (XY)	none	ASTM D150	-	5.1 [5]
at 1 kHz (XY)	none	ASTM D150	-	4.8 [5]
at 1 MHz (XY)	none	ASTM D150	-	4.5 [5]
AC Loss Characteristic (Dissipation Factor)				
at 50 Hz (XY)	none	ASTM D150	-	0.24 [5]
at 1 kHz (XY)	none	ASTM D150	-	0.02 [5]
at 1 MHz (XY)	none	ASTM D150	-	0.03 [5]

Internal Data Sources:
[1] GEN792914, [2]FOR19857, [3]FOR20028, [4]FOR549180, [5] FOR549162

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WORKFLOW

Validated workflows need to be followed to achieve properties as provided in the TDS. Examples of validated workflow steps are listed below. Users should defer to the most current workflow information for best results which can be found at https://www.loctiteam.com/printer-validation-settings

PRINTER SETTINGS

LOCTITE 3D IND402 BK is formulated to print optimally on industrial DLP printer. Read the safety data sheet carefully to get details about health and safety instructions. Recommended print parameters:

- Shake resin bottle well before usage
- Temperature: 20°C to 35°C
- Intensity: 3 mW/cm² to 7 mW/cm²

Exposure time for an intensity of 6 mW/cm²

Layer Thickness (µm):	50	100	50
First layer time (s)	25	25	25
Burn in region (s):	2-4	4-6	2-4
Model Layer Exposure (s):			6.5

Ec (mJ/cm²)	6.06
Dp (mm):	0.09

CLEANING

LOCTITE 3D IND402 BK requires post processing to achieve specified properties. Prior to post curing, support structures should be removed from the printed part, and the part should then be washed. Use compressed air to remove residual solvent from the surface of the material between intervals.

Post Process Step	Agent	Method	Duration	Intervals	Additional Info
Cleaning	IPA	Manual	2 min	2	Ensure parts are dry before next interval
Dry	n.a.	Compressed air	30 s	1	Air pressure (30 psi)
Wait before post curing	n.a.	Ambient condition	60 min	1	Room temperature

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Validated workflows need to be followed to achieve properties as provided in the TDS. Examples of validated workflow steps are listed below. Users should defer to the most current workflow information for best results which can be found at https://www.loctiteam.com/printer-validation-settings

POST CURING

LOCTITE 3D IND402 BK requires post curing to achieve specified properties. It is recommended that either an LED or wide spectrum lamp be used to post cure parts.

UV Curing Unit	UV Source	Intensity	Cure time per side	Additional Settings (Shelf, Output Energy)
Loctite UVALOC 1000	Mercury Arc Bulb (broad spectrum)	30 mW/cm² at 365 nm	3 min	500 W, lowest shelf
Dymax 5000 EC Flood	Mercury Arc Bulb (broad spectrum)	148 mW/cm² at 380 nm	5 min	400W, Shelf K

STORAGE

Store LOCTITE 3D IND402 BK in the unopened container in a dry location. Optimal Storage: 8°C to 30°. Storage below 8°C or above 30°C can adversely affect product properties. Material removed from containers may be contaminated during use. For this reason, filter used resin with 190µm mesh filter before placing back into proper storage container.

LIQUID HANDLING

When handling liquid, always wear gloves and protective glasses to prevent skin and eye contact. ***User must provide adequate ventilation (like fume hood) or wear suitable respiratory protection (like filter type: A per EN 14387) when printing/processing.***
Please refer to the Safety Data Sheet (SDS) on this product for more information on safe handling.

LIMITATIONS & OPTIONS

Post Cure: LOCTITE 3D IND402 BK requires broadband spectrum for post cure.

Modification: LOCTITE 3D IND402 BK has limited potential for any tensile property adjustments.

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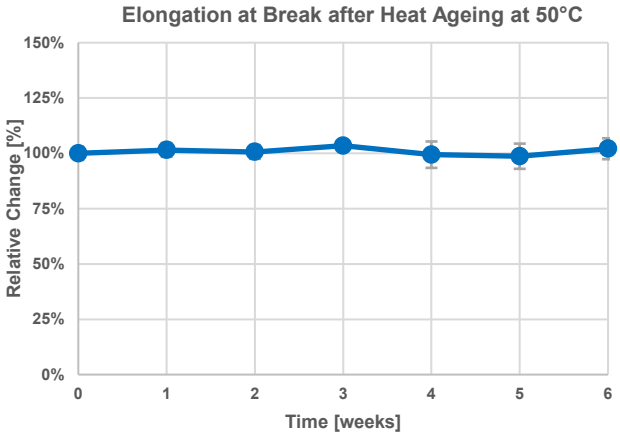
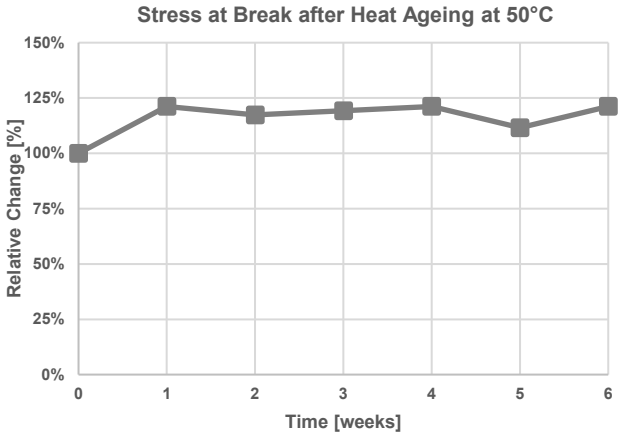
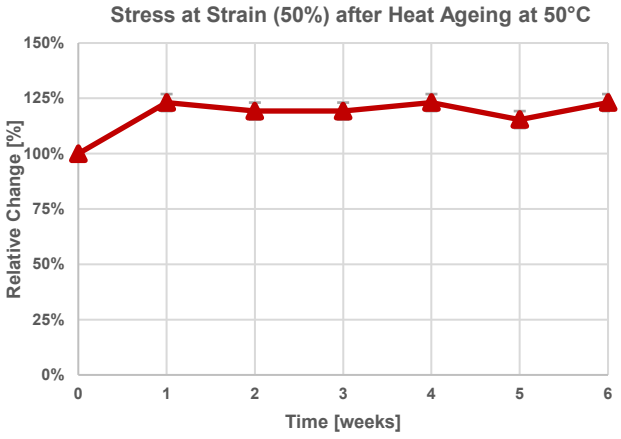
AGEING AND ENVIRONMENTAL EFFECTS – HEAT AGEING

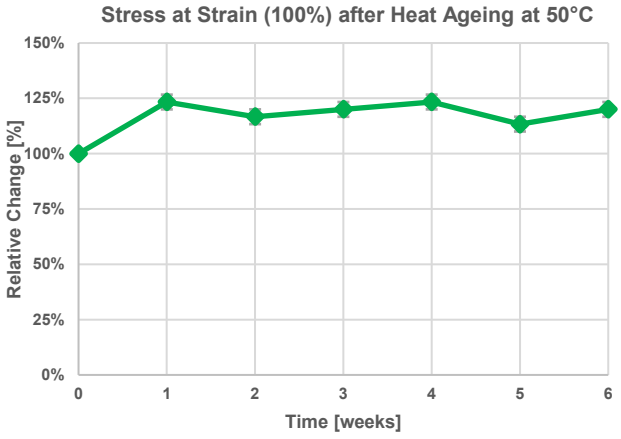
LOCTITE 3D IND402 BK was heat aged without load according to ASTM D3045. Test samples were exposed for a defined time at 50°C and conditioned for 24 hours at 22°C before mechanical testing. Control samples were stored at a constant 22°C. All samples were printed in the same print job using a validated workflow. Mechanical testing was conducted according to ASTM D412 at standard lab conditions (22°C). "0 weeks" represents non-aged samples stored at 22°C and tested 24 hours after post-processing.

Based on temperature dependence of reaction rates a test time of 6 weeks at 50°C can be interpreted as approximately 12 months at ambient temperature.









Test parameters:
ASTM D412: Type Die C, Pull speed: 500 mm/min, 22°C

Internal Data Sources:
FOR154441, FOR154442

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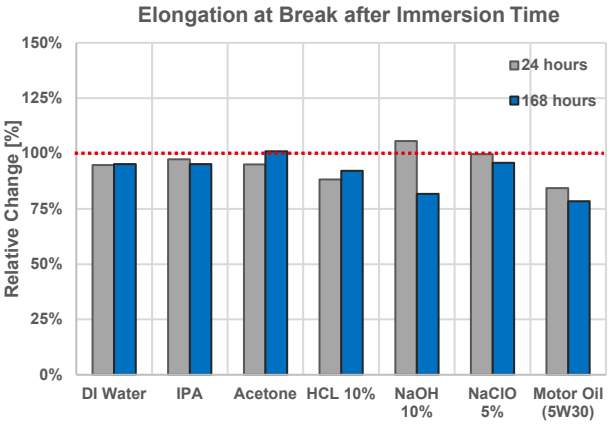
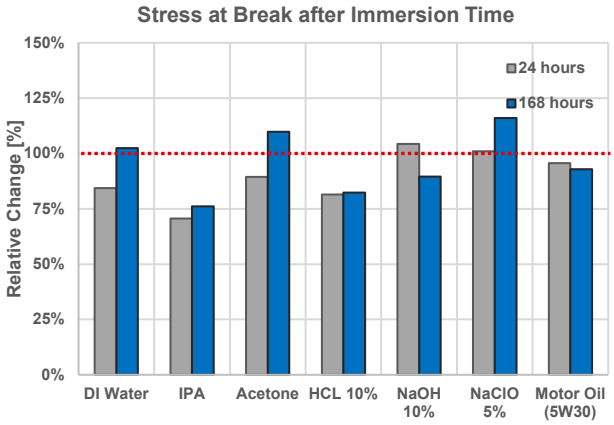
AGEING AND ENVIRONMENTAL EFFECTS – CHEMICAL RESISTANCE INDUSTRIAL

LOCTITE 3D IND402 BK has been tested after chemical ageing according to ASTM D543. The influence of chemicals was tested by measuring mechanical properties after different test times (Immersion test for 24 and 168 hours). Exposed samples were stored in containers and fully immersed in different chemicals. Samples were stirred every 24 hours using a shaker. After removal, exposed samples were washed and conditioned for 24 hours at 22°C before mechanical testing. All samples were printed using a validated workflow. Mechanical testing was conducted according to ASTM D638 at standard lab conditions (22°C).

The 100% value represents the initial weight 24 hours after post-processing.





Test parameters:
ASTM D412: Type Die C, Pull speed: 500 mm/min, 22°C
ASTM D543: Samples immersed in different chemicals were stored at 22°C. Samples immersed in Motor Oil were stored at 50°C.

Internal Data Sources:
FOR228570, FOR228564, FOR228558, FOR228550, FOR235260, FOR235270, FOR235328, FOR797442, FOR804298, FOR804299, FOR804297, FOR797435, FOR797433, FOR797436

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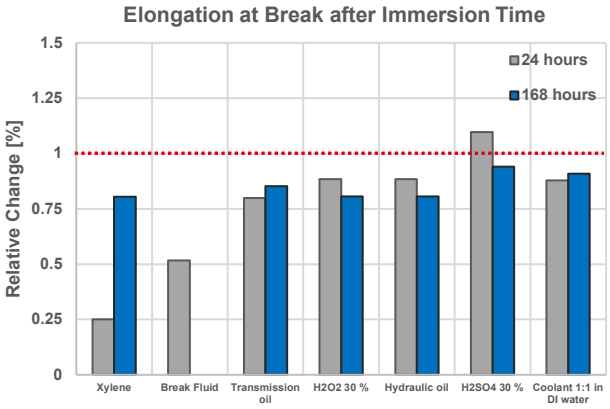
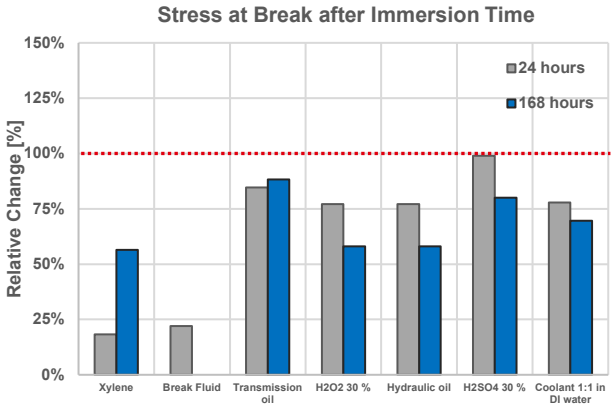
AGEING AND ENVIRONMENTAL EFFECTS – CHEMICAL RESISTANCE AUTOMOTIVE

LOCTITE 3D IND402 BK has been tested after chemical ageing according to ASTM D543. The influence of chemicals was tested by measuring mechanical properties after different test times (Immersion test for 24 and 168 hours). Exposed samples were stored in containers and fully immersed in different chemicals. Samples were stirred every 24 hours using a shaker. After removal, exposed samples were washed and conditioned for 24 hours at 22°C before mechanical testing. All samples were printed using a validated workflow. Mechanical testing was conducted according to ASTM D638 at standard lab conditions (22°C).

The 100% value represents the initial weight 24 hours after post-processing.





Test parameters:
ASTM D638: Type IV, Pull speed: 5 mm/min, Young's modulus measured at 0.1-1.0% (regression), 22°C
ASTM D543: Samples immersed in different chemicals were stored at 22°C. Samples immersed in Transmission oil and Coolant mix 1:1 were stored at 50°C. Properties of media used: pH(H_2SO_4 30%) = 0; pH(H_2O_2 30%) = 5; pH (NaCl solution 0.9%) = 5. Viscosity: Hydraulic fluid = 3000 mPas at 40°C; Transmission oil = 8200 mPas at 40°C; Minimum temperature of coolant mix 1:1 = -40°C in Motor Oil were stored at 50°C.

Internal Data Sources:
FOR797442, FOR804298, FOR804299, FOR804297, FOR797435, FOR797433, FOR797436

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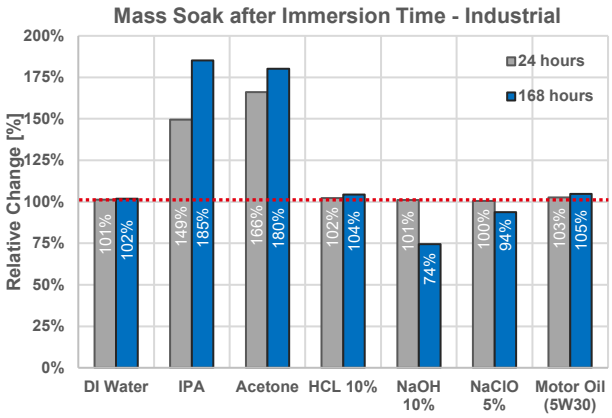
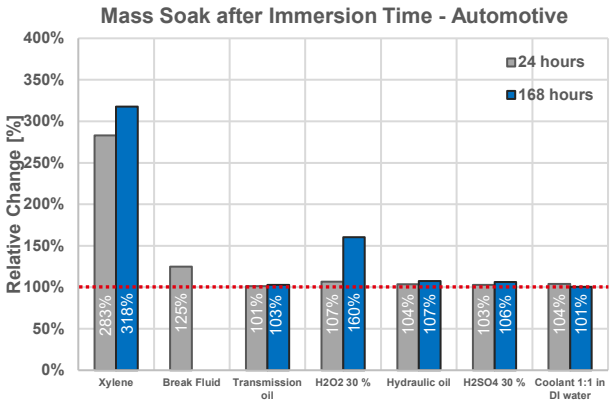
AGEING AND ENVIRONMENTAL EFFECTS – CHEMICAL RESISTANCE MASS SOAK

LOCTITE 3D IND402 BK has been tested after chemical ageing according to ASTM D543. The influence of chemicals was tested by measuring the mass change after different test times (Immersion test for 24 and 168 hours). Exposed samples were stored in containers and fully immersed in different chemicals. Samples were stirred every 24 hours using a shaker. After removal exposed samples were washed, dried and immediately weighed. All samples were printed using a validated workflow.

The 100% value represents the initial weight 24 hours after post-processing.





Test parameters:
ASTM D638: Type IV, Pull speed: 5 mm/min, Young's modulus measured at 0.1-1.0% (regression), 22°C
ASTM D543: Samples immersed in different chemicals were stored at 22°C. Samples immersed in Transmission oil and Coolant mix 1:1 were stored at 50°C. Properties of media used: pH(H_2SO_4 30%) = 0; pH(H_2O_2 30%) = 5; pH (NaCl solution 0.9%) = 5. Viscosity: Hydraulic fluid = 3000 mPas at 40°C; Transmission oil = 8200 mPas at 40°C; Minimum temperature of coolant mix 1:1 = -40°C in Motor Oil were stored at 50°C.

Internal Data Sources:
FOR225180, FOR225181, FOR225182, FOR225184, FOR235312, FOR235315, FOR235289, FOR797442, FOR804298, FOR804299, FOR804297, FOR797435, FOR797433, FOR797436

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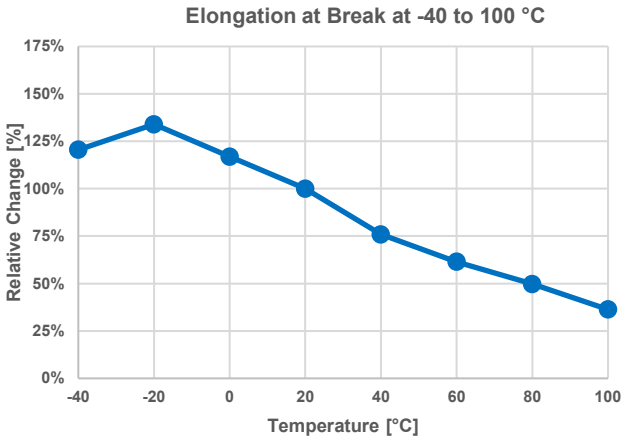
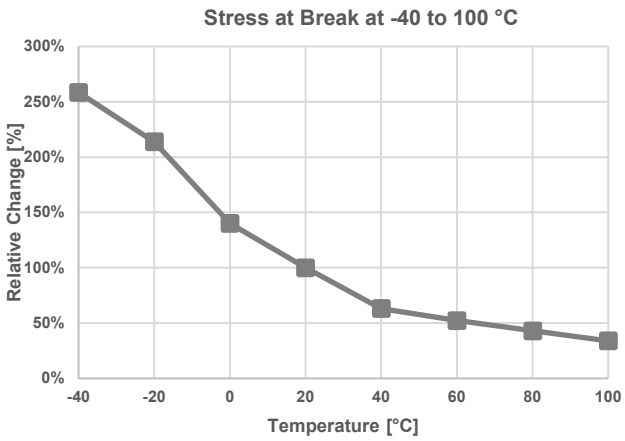
THERMAL INFLUENCE ON MECHANICAL PROPERTIES

LOCTITE 3D IND402 BK has been tested according to ASTM D412 at varied environmental temperatures, from -40°C to 100°C. All samples were printed in the same print job using a validated workflow. Mechanical testing was conducted according to ASTM D412. Before each test series samples were conditioned for 60 minutes at the specific test temperature.





Test parameters:
ASTM D412: Type Die C, Pull speed: 500 mm/min

Internal Data Sources:
FOR178967

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NOTE

The information provided in this Technical Data Sheet (TDS) including the recommendations for use and application of the product are based on our knowledge and experience of the product as at the date of this TDS. The product can have a variety of different applications as well as differing application and working conditions in your environment that are beyond our control. Henkel is, therefore, not liable for the suitability of our product for the production processes and conditions in respect of which you use them, as well as the intended applications and results. We strongly recommend that you carry out your own prior trials to confirm such suitability of our product.
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