

LOCTITE®



LOCTITE 3D MED414™

Elastomer

Blue, Clear, Red

LOCTITE®

Henkel Corporation
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MED414™ ELASTOMER



LOCTITE 3D MED414™

LOCTITE 3D MED414 is a high-performance, soft material boasting excellent elongation and tear strength properties.

Shore A hardness combined with good tear resistance and strength make this material ideal for use in a wide variety elastomeric medical device and skin contact applications.

LOCTITE 3D MED414 is TPO free formulated and capable of meeting ISO 10993-5-10-23 standards for biocompatibility when processed using a validated workflow.

Certificates of Compliance are available upon request.



Benefits:

- True elastomeric behavior
- Good balance of strength and elongation
- Good tear resistance & torsional flexibility
- Good print resolution with low shrinkage



Ideal for:

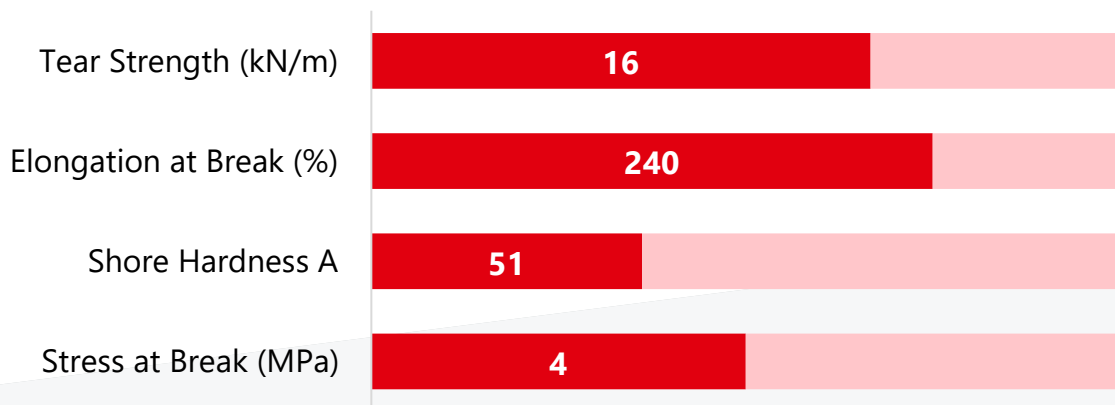
- Custom fit ear device applications for the audiology, noise protection equipment and consumer audiology parts.
- Wearables
- Medical devices and components



Markets:



Healthcare



**Values shown are linked to LOCTITE MED414 Blue as reference, please refer to the specific mechanical properties for each of the colors shown in this document*





PROPERTIES

| Mechanical Properties | Measure | Method | Green | Post Processed (Broad Band UV) |
|-----------------------------|---------|-----------|------------------------|--------------------------------|
| Stress at 50% Strain | MPa | ASTM D412 | 0.7-0.9 ^[1] | 1.6-1.7 ^[1] |
| Stress at 100% Strain | MPa | ASTM D412 | 1.1-1.3 ^[1] | 2.1-2.2 ^[1] |
| Stress at 150% Strain | MPa | ASTM D412 | 1.4-1.7 ^[1] | 2.7-2.8 ^[1] |
| Elongation at Break | % | ASTM D412 | 215-230 ^[1] | 220-240 ^[1] |
| Stress at Break | MPa | ASTM D412 | 2.3-2.6 ^[1] | 3.5-4 ^[1] |
| Tear Strength | kN/m | ASTM D624 | 7.5-8.5 ^[1] | 13.5-16 ^[1] |
| Young's Modulus | MPa | ASTM D638 | 3-5 ^[1] | 9-15 ^[1] |
| Tensile Stress at Break | MPa | ASTM D638 | 1.2-1.5 ^[1] | 2.5-2.8 ^[1] |
| Tensile Elongation at Break | % | ASTM D638 | 160-170 ^[1] | 170-190 ^[1] |
| Tensile Stress at Yield | MPa | ASTM D638 | N/A | N/A |

Other Properties

| | | | | |
|--------------------------|-------------------|------------|---------------------|---------------------|
| Energy Return | % | Internal | N/A | 50 ^[2] |
| Shore Hardness (5 sec) | A | ASTM D2240 | 32 ^[3] | 51 ^[4] |
| Water Absorption (24 hr) | % | ASTM D570 | N/A | 3.0 ^[5] |
| Solid Density | g/cm ³ | ASTM D1475 | 1.06 ^[6] | 1.02 ^[6] |

| Liquid Properties | Measure | Method | Value |
|--------------------------|-------------------|------------|----------------------------|
| Viscosity at 25°C (77°F) | cP | ASTM D7867 | 1600 - 3000 ^[7] |
| Liquid Density | g/cm ³ | ASTM D1475 | 1.0 ^[8] |

| Biocompatibility | Method | Value |
|------------------|--------------|------------------------|
| Cytotoxicity | ISO 10993-5 | Comply ^[10] |
| Sensitization | ISO 10993-10 | Comply ^[11] |
| Irritation | ISO 10993-23 | Comply ^[11] |

All specimen are printed unless otherwise noted. All specimen were conditioned in ambient lab conditions at 19-23°C / 40-60% RH for at least 24 hours.
ASTM Methods and Parameters: D638-14 Type IV, 50 mm/min, D412-16 (21) Die C Shape, 3 mm thickness, 500 mm/min, D624, 500 mm/min

Internal Data Sources:

[1] GEN1092, [2] FOR42131, [3] FOR43680, [4] FOR42122, [5] FOR42148, [6] FOR42136, [7] GEN794243, [10] FOR52316, [11] FOR157979, [7] FOR42660, [8] FOR42136, [10] GEN250788, [11] FOR157979.





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 MED414 BL 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, higher intensities can result in reduced surface quality and mechanical properties

| Settings: 385nm at 3mW/cm ² | Measure | Method | Value |
|--|---------|----------|-------|
| Layer Thickness | µm | Internal | 100 |
| Burn-in Region | s | Internal | 30 |
| Transition Region | s | Internal | 25 |
| Model Region | s | Internal | 12-16 |

| Settings: 385nm at 3mW/cm ² | Measure | Method | Value |
|--|--------------------|----------|----------|
| E _C | mJ/cm ² | Internal | 9 [9] |
| D _p | mm | Internal | 0.13 [9] |

| Settings: 385nm at 3mW/cm ² | Measure | Method | Exposure time |
|--|---------|----------|---------------|
| D _C = 50µm | s | Internal | 5.7 |
| D _C = 100µm | s | Internal | 7.5 |

Test parameters:

*Exposure times are calculated without a safety factor

Internal data source:

[9] FOR42274





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>

CLEANING

LOCTITE 3D MED414 BL 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 Cycle 1 | IPA | Ultra sonic bath | 2 min | 1 | Allow parts to dry between intervals |
| Cleaning Cycle 2 | IPA | Ultra sonic bath | 2 min | 1 | Use fresh IPA |
| Dry | n.a. | Compressed air | 10 to 60 s | 2 | Air pressure (50psi) |
| Wait before post curing | n.a. | Ambient condition | 60 min | 1 | Room temperature |

POST CURING

LOCTITE 3D MED414 BL requires post curing to achieve specified properties. A wide array of post cure equipment can be used to cure appropriately. See Validation chart for examples of type and time. Exact devices with detailed information can be found by contacting us at www.loctiteAM.com.

| UV Curing Unit | UV Source | Intensity | Cure time per side | Additional Settings (Shelf, Output Energy) |
|---------------------|-----------------------------------|---------------------------------|--------------------|--|
| Loctite UVALOC 1000 | Mercury Arc Bulb (broad spectrum) | 50 mW/cm ² at 380 nm | 5min | 500 W 2 nd Shelf from bottom |

STORAGE

Store LOCTITE MED414 BL 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.

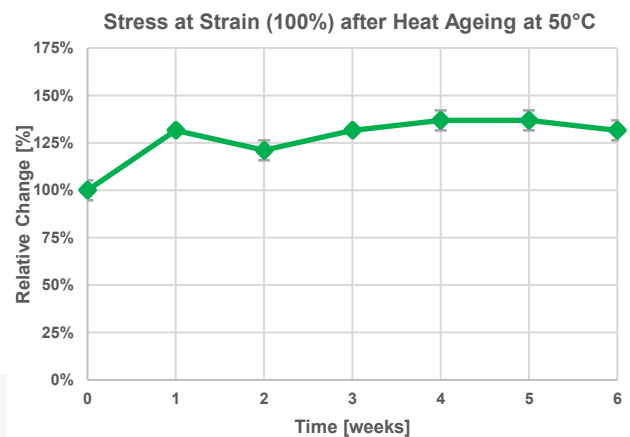
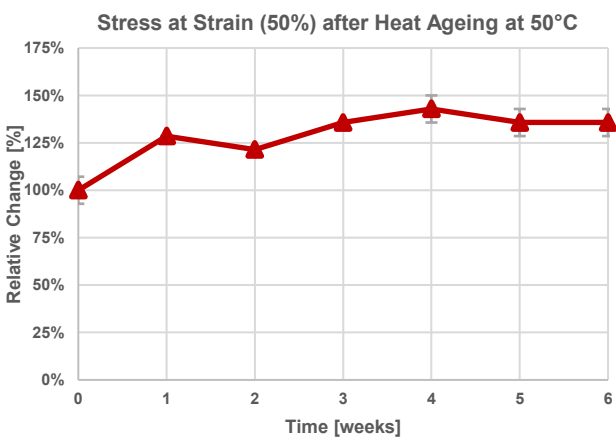
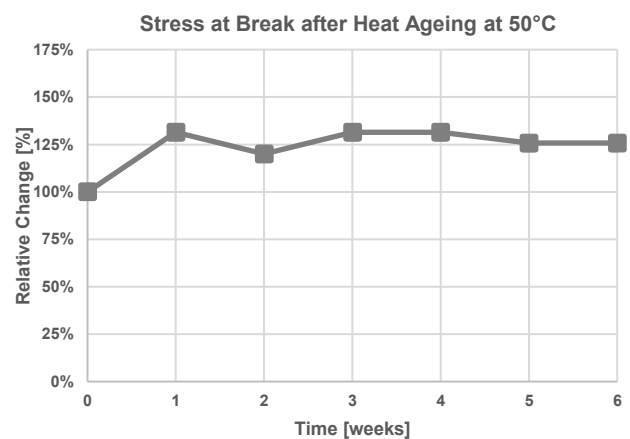
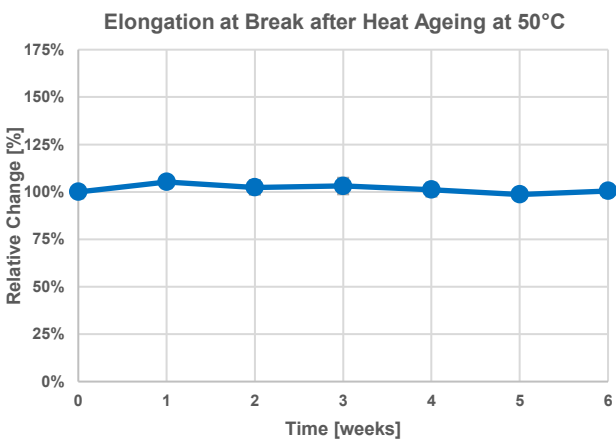




AGEING AND ENVIRONMENTAL EFFECTS – HEAT AGEING

LOCTITE 3D MED414 BL 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:
[FOR220974](#), [FOR220970](#)



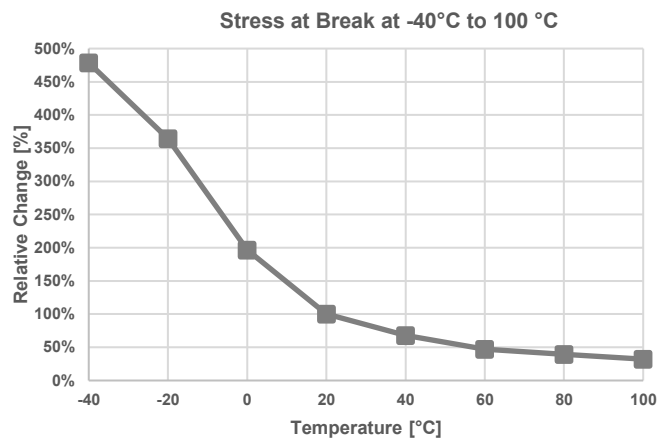
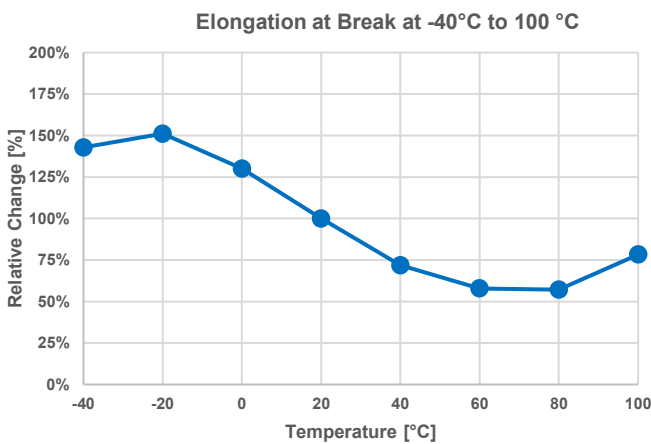


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THERMAL INFLUENCE ON MECHANICAL PROPERTIES

LOCTITE 3D MED414 BL 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

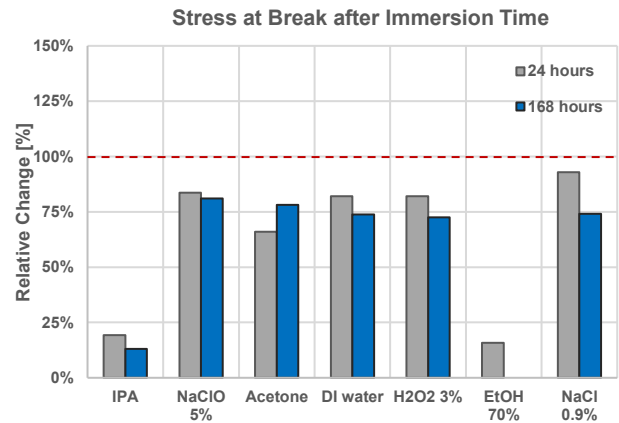
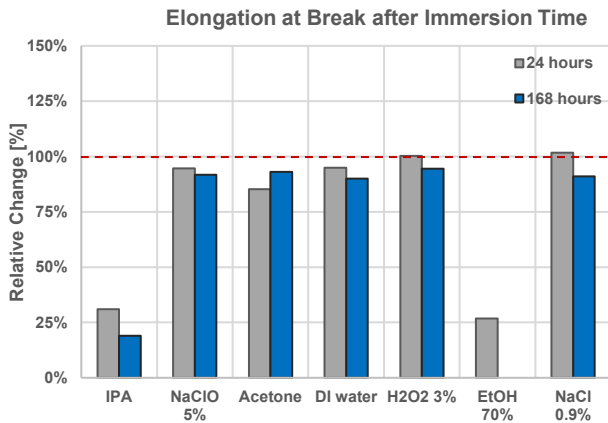
Internal Data Sources:
[FOR137768](#)





AGEING AND ENVIRONMENTAL EFFECTS – MEDICAL CHEMICAL RESISTANCE

LOCTITE 3D MED414 BL 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 D412 at standard lab conditions (22°C). The 100% value represents the initial weight 24 hours after post-processing.



Test parameters:
 ASTM D412: Type C, 22°C, Pull speed: 500 mm/min
 ASTM D543: Samples immersed in different chemicals were stored at 22°C. Properties of media used: pH(H₂O₂ 3%) = 2; pH(NaClO 5%) = 13

Internal Data Sources:
[FOR713415](#), [FOR713417](#), [FOR713574](#), [FOR713576](#), [FOR716029](#), [FOR716030](#), [FOR716031](#)

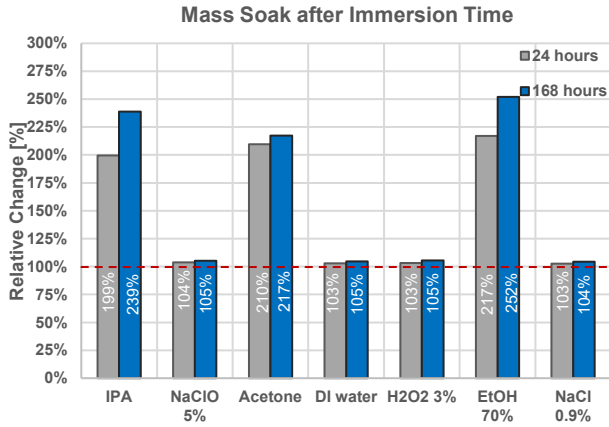




AGEING AND ENVIRONMENTAL EFFECTS – MEDICAL CHEMICAL MASS SOAK

LOCTITE 3D MED414 BL 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 D543: Samples immersed in different chemicals were stored at 22°C. Properties of media used: pH(H₂O₂ 3%) = 2; pH(NaClO 5%) = 13

Internal Data Sources:

[FOR713415](#), [FOR713417](#), [FOR713574](#), [FOR713576](#), [FOR716029](#), [FOR716030](#), [FOR716031](#)





PROPERTIES

| Mechanical Properties | Measure | Method | Green | Post Processed |
|-----------------------------|-------------------|------------|---------------|------------------|
| Young's Modulus | MPa | ASTM D638 | 3 [1] | 6 - 7 [2] |
| Tensile Stress at Break | MPa | ASTM D638 | 2.5 - 2.9 [1] | 3.1 - 3.5 [2] |
| Elongation at Break | % | ASTM D638 | 280 - 310 [1] | 270 - 290 [2] |
| Stress at 50% Strain | MPa | ASTM D412 | 0.9 [3] | 1.1 - 1.3 [4] |
| Stress at 100% Strain | MPa | ASTM D412 | 1.2 [3] | 1.6 - 1.8 [4] |
| Stress at 150% Strain | MPa | ASTM D412 | 1.7 [3] | 2.0 - 2.2 [4] |
| Stress at Break | MPa | ASTM D412 | 2.6 - 3.4 [3] | 3.6 - 4.8 [4] |
| Strain at Break | % | ASTM D412 | 240 - 300 [3] | 260 - 280 [4] |
| Tear Strength | kN/m | ASTM D624 | 8.4 - 8.8 [5] | 12.9 - 13.3 [6] |
| Energy Return | % | Internal | - | 53 - 58 [7,8] |
| Compression Set (22°C/24hr) | % | D395-B | - | 7 - 12 [9,10] |
| Compression Set (70°C/24hr) | % | D395-B | - | 25 - 36 [9,10] |
| Shore Hardness (5s) | A | ASTM D2240 | - | 53.8 - 55.4 [11] |
| Other Properties | | | | |
| Solid Density (Cured) | g/cm ³ | ASTM D792 | - | 1.05 [13] |
| Water Absorption (24hr) | % | ASTM D570 | - | 2.6 [14] |
| Water Absorption (72hr) | % | ASTM D570 | - | 3.5 [14] |
| Water Absorption (168hr) | % | ASTM D570 | - | 4.0 [14] |
| Thermal Conductivity | W/(m·K) | ASTM D5930 | - | 0.2 [15] |
| Heat Capacity | J/(g·K) | ASTM D5930 | - | 1.5 [15] |

Test parameters:

All specimen are printed unless otherwise noted. All specimen were conditioned in ambient lab conditions at 19-23°C / 40-60% RH for at least 24 hours. ASTM Methods: D638 Type IV, 50 mm/min, D412 Type C, 500 mm/min, D570 Sheet samples 24hr@ 23°C, D2240, Type "A" (5 seconds), D7867, D1475; ASTM D5930 80x40x10 mm³

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

Internal Data Sources:

[1] FOR870272, [2] FOR870281, [3] FOR867845, [4] FOR867883, [5] FOR861472, [6] FOR867883, [7] FOR871848, [8] FOR871850, [9] FOR871842, [10] FOR871844, [11] FOR873342, [12] FOR873341, [13] FOR873333, [14] FOR873346, [15] FOR873340





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CLEAR



PROPERTIES

| Biocompatibility | Method | Green | Post Processed |
|-------------------------|---------------|--------------|------------------------------|
| Cytotoxicity | ISO 10993-5 | - | <i>comply</i> ^[1] |
| Sensitization | ISO 10993-10 | - | <i>comply</i> ^[2] |
| Irritation | ISO 10993-23 | - | <i>comply</i> ^[3] |

| Liquid Properties | Measure | Method | Value |
|--------------------------|-------------------|---------------|----------------------------|
| Viscosity at 25°C (77°F) | cP | ASTM D7867 | 2500 - 3500 ^[4] |
| Liquid Density | g/cm ³ | ASTM D1475 | 1.0 ^[5] |

Test parameters:

"All specimen are printed unless otherwise noted. All specimen were conditioned in ambient lab conditions at 19-23°C / 40-60% RH for at least 24 hours." ASTM Methods: D638 Type IV, 50 mm/min, D412 Type C, 500 mm/min, D570 Sheet samples 24hr@ 23°C, D2240, Type "A" (5 seconds), D7867, D1475; ASTM D5930 80x40x10 mm³

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

Internal Data Sources:

[1] FOR868308, [2] FOR868316, [3] FOR868313, [4] FOR868039, [5] FOR861330





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 MED414 CL 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: 5 mW/cm²

| Settings: 385nm at 5mW/cm ² | Measure | Method | Value |
|--|---------|----------|-------|
| Layer Thickness | µm | Internal | 100 |
| Burn-in Region | s | Internal | 50 |
| Transition Region | s | Internal | 25 |
| Model Region | s | Internal | 8 |

| Settings: 385nm at 5mW/cm ² | Measure | Method | Value |
|--|--------------------|----------|---------------------|
| E _C | mJ/cm ² | Internal | 12.4 ^[1] |
| D _p | mm | Internal | 0.24 ^[1] |

| Settings: 385nm at 5mW/cm ² | Measure | Method | Exposure time |
|--|---------|----------|---------------|
| D _C = 50µm | s | Internal | 5-6 |
| D _C = 100µm | s | Internal | 7-8 |

Test parameters:

*Exposure times are calculated without a safety factor

Internal data source

[1] FOR863459





MED414™ ELASTOMER CLEAR



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>

CLEANING

LOCTITE 3D MED414 CL 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 Cycle 1 | IPA | Ultra sonic bath | 2 min | 1 | Allow parts to dry between intervals |
| Cleaning Cycle 2 | IPA | Ultra sonic bath | 2 min | 1 | Use fresh IPA |
| Dry | n.a. | Compressed air | 10 to 60 s | 2 | Air pressure (50psi) |
| Wait before post curing | n.a. | Ambient condition | 60 min | 1 | Room temperature |

POST CURING

LOCTITE 3D MED414 CL requires post curing to achieve specified properties. A wide array of post cure equipment can be used to cure appropriately. See Validation chart for examples of type and time. Exact devices with detailed information can be found by contacting us at www.loctiteAM.com.

| UV Curing Unit | UV Source | Intensity | Cure time per side | Additional Settings (Shelf, Output Energy) |
|---------------------|-----------------------------------|---------------------------------|--------------------|--|
| Loctite UVALOC 1000 | Mercury Arc Bulb (broad spectrum) | 50 mW/cm ² at 380 nm | 5min | 500 W 2 nd Shelf from bottom |

STORAGE

Store LOCTITE MED414 CL 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.





PROPERTIES

| Mechanical Properties | Measure | Method | Green | Post Processed |
|-----------------------------|-------------------|------------|--------------------------|----------------------------|
| Young's Modulus | MPa | ASTM D638 | 3 - 4 ^[1] | 6 ^[2] |
| Tensile Stress at Break | MPa | ASTM D638 | 1.7 - 2.1 ^[1] | 2.4 - 2.6 ^[2] |
| Elongation at Break | % | ASTM D638 | 200 - 250 ^[1] | 210 - 230 ^[2] |
| Stress at 50% Strain | MPa | ASTM D412 | 0.6 ^[3] | 1.2 - 1.3 ^[4] |
| Stress at 100% Strain | MPa | ASTM D412 | 0.9 ^[3] | 1.7 - 1.8 ^[4] |
| Stress at 150% Strain | MPa | ASTM D412 | 1.2 ^[3] | 2.2 - 2.3 ^[4] |
| Stress at Break | MPa | ASTM D412 | 2.3 - 3.0 ^[3] | 4.0 - 4.3 ^[4] |
| Strain at Break | % | ASTM D412 | 260 - 300 ^[3] | 260 - 280 ^[4] |
| Tear Strength | kN/m | ASTM D624 | 6.6 - 6.8 ^[5] | 12.0 - 13.0 ^[6] |
| Energy Return | % | Internal | - | 55-58 ^[10,11] |
| Compression Set (22°C/24hr) | % | D395-B | - | 7-9 ^[12,13] |
| Compression Set (70°C/24hr) | % | D395-B | - | 28 - 36 ^[12,13] |
| Shore Hardness (5s) | A | ASTM D2240 | - | 56.1 - 56.5 ^[8] |
| Other Properties | | | | |
| Solid Density (Cured) | g/cm ³ | ASTM D792 | - | 1.06 ^[14] |
| Water Absorption (24hr) | % | ASTM D570 | - | 3.0 ^[7] |
| Water Absorption (72hr) | % | ASTM D570 | - | 4.1 ^[7] |
| Water Absorption (168hr) | % | ASTM D570 | - | 4.7 ^[7] |
| Thermal Conductivity | W/(m·K) | ASTM D5930 | - | 0.2 ^[9] |
| Heat Capacity | J/(g·K) | ASTM D5930 | - | 1.5 ^[9] |

Test parameters:

All specimen are printed unless otherwise noted. All specimen were conditioned in ambient lab conditions at 19-23°C / 40-60% RH for at least 24 hours. ASTM Methods: D638 Type IV, 50 mm/min, D412 Type C, 500 mm/min, D570 Sheet samples 24hr@ 23°C, D2240, Type "A" (5 seconds), D7867, D1475; ASTM D5930 80x40x10 mm³

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

Internal Data Sources:

[1] FOR853623, [2] FOR853626, [3] FOR847211, [4] FOR847215, [5] FOR847880, [6] FOR847217, [7] FOR856571, [8] FOR856555, [9] FOR856582, [10] FOR856708, [11] FOR856703
[12] FOR856697, [13] FOR856691, [14] FOR856590



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RED



PROPERTIES

| Biocompatibility | Method | Green | Post Processed |
|-------------------------|---------------|--------------|-----------------------|
| Cytotoxicity | ISO 10993-5 | - | comply [12] |
| Sensitization | ISO 10993-10 | - | comply [12] |
| Irritation | ISO 10993-23 | - | comply [12] |

| Liquid Properties | Measure | Method | Value |
|--------------------------|-------------------|---------------|------------------|
| Viscosity at 25°C (77°F) | cP | ASTM D7867 | 1800 - 2800 [10] |
| Liquid Density | g/cm ³ | ASTM D1475 | 1.0 [9] |

Test parameters:

"All specimen are printed unless otherwise noted. All specimen were conditioned in ambient lab conditions at 19-23°C / 40-60% RH for at least 24 hours." ASTM Methods: D638 Type IV, 50 mm/min, D412 Type C, 500 mm/min, D570 Sheet samples 24hr@ 23°C, D2240, Type "A" (5 seconds), D7867, D1475; ASTM D5930 80x40x10 mm³
*The biological assessment has been performed based on the in vitro method according to ISO10993-23

Internal Data Sources:

[9] FOR804352, [10] FOR824473, [11] FOR840119, [12] GEN966585





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 MED414 RD 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: 5 mW/cm²

| Settings: 385nm at 5mW/cm ² | Measure | Method | Value |
|--|---------|----------|-------|
| Layer Thickness | µm | Internal | 100 |
| Burn-in Region | s | Internal | 40 |
| Transition Region | s | Internal | 25 |
| Model Region | s | Internal | 7 |

| Settings: 385nm at 5mW/cm ² | Measure | Method | Value |
|--|--------------------|----------|---------------------|
| E _C | mJ/cm ² | Internal | 12.7 ^[1] |
| D _p | mm | Internal | 0.17 ^[1] |

| Settings: 385nm at 5mW/cm ² | Measure | Method | Exposure time |
|--|---------|----------|---------------|
| D _C = 50µm | s | Internal | 4-5 |
| D _C = 100µm | s | Internal | 6-7 |

Internal data source:

[1] FOR795535





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>

CLEANING

LOCTITE 3D MED414 RD 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 Cycle 1 | IPA | Ultra sonic bath | 2 min | 1 | Allow parts to dry between intervals |
| Cleaning Cycle 2 | IPA | Ultra sonic bath | 2 min | 1 | Use fresh IPA |
| Dry | n.a. | Compressed air | 10 to 60 s | 2 | Air pressure (50 psi) |
| Wait before post curing | n.a. | Ambient condition | 60 min | 1 | Room temperature |

POST CURING

LOCTITE 3D MED414 RD requires post curing to achieve specified properties. A wide array of post cure equipment can be used to cure appropriately. See Validation chart for examples of type and time. Exact devices with detailed information can be found by contacting us at www.loctiteAM.com.

| UV Curing Unit | UV Source | Intensity | Cure time per side | Additional Settings (Shelf, Output Energy) |
|---------------------|-----------------------------------|---------------------------------|--------------------|--|
| Loctite UVALOC 1000 | Mercury Arc Bulb (broad spectrum) | 50 mW/cm ² at 380 nm | 5 min | 500 W 2 nd Shelf from bottom |

STORAGE

Store LOCTITE MED414 RD 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.

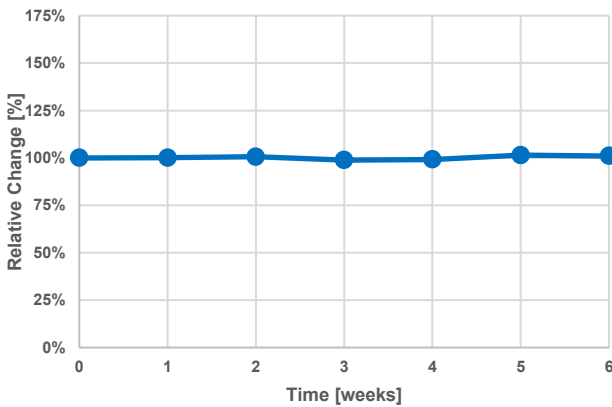


AGEING AND ENVIRONMENTAL EFFECTS – HEAT AGEING

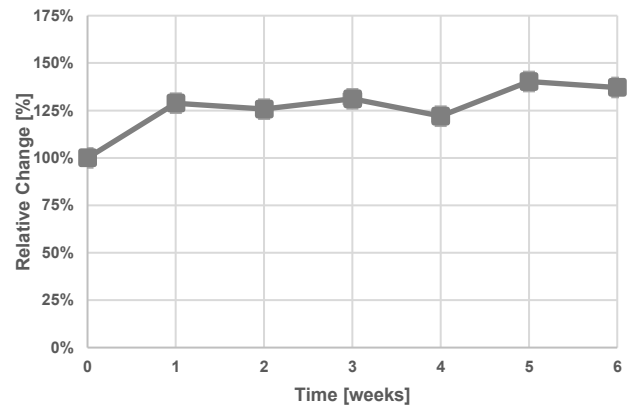
LOCTITE 3D MED414 RD was heat aged without load according to ASTM D3045. Test samples were exposed for a defined time at 50°C and conditioned for 24 hours at 22°C before mechanical testing. Control samples were stored at a constant 22°C. All samples were printed in the same print job using a validated 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.

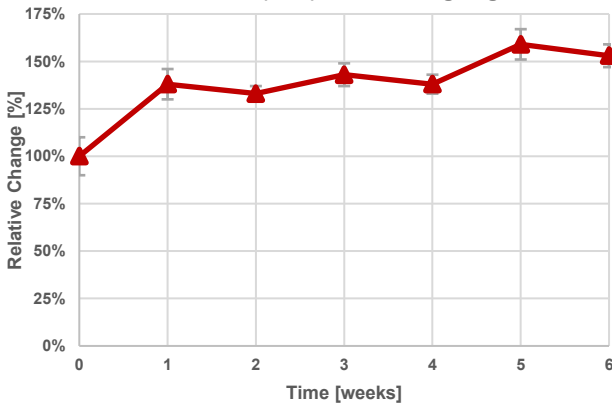
Elongation at Break after Heat Ageing at 50°C



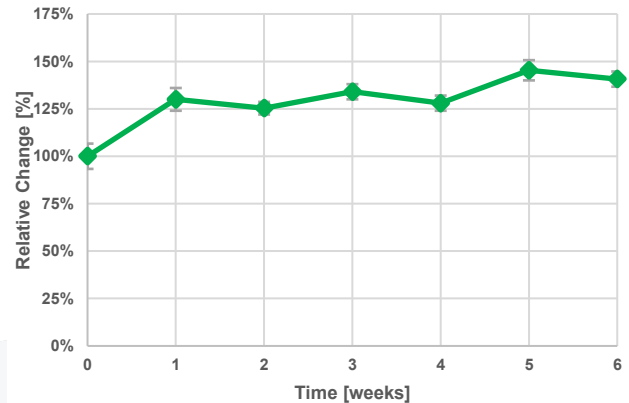
Stress at Break after Heat Ageing at 50°C



Stress at Strain (50%) after Heat Ageing at 50°C



Stress at Strain (100%) after Heat Ageing at 50°C



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

Internal Data Sources:
[FOR857256](#), [FOR857259](#)



LOCTITE®

MED414™ ELASTOMER



NOTE

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Version 2026/19/06