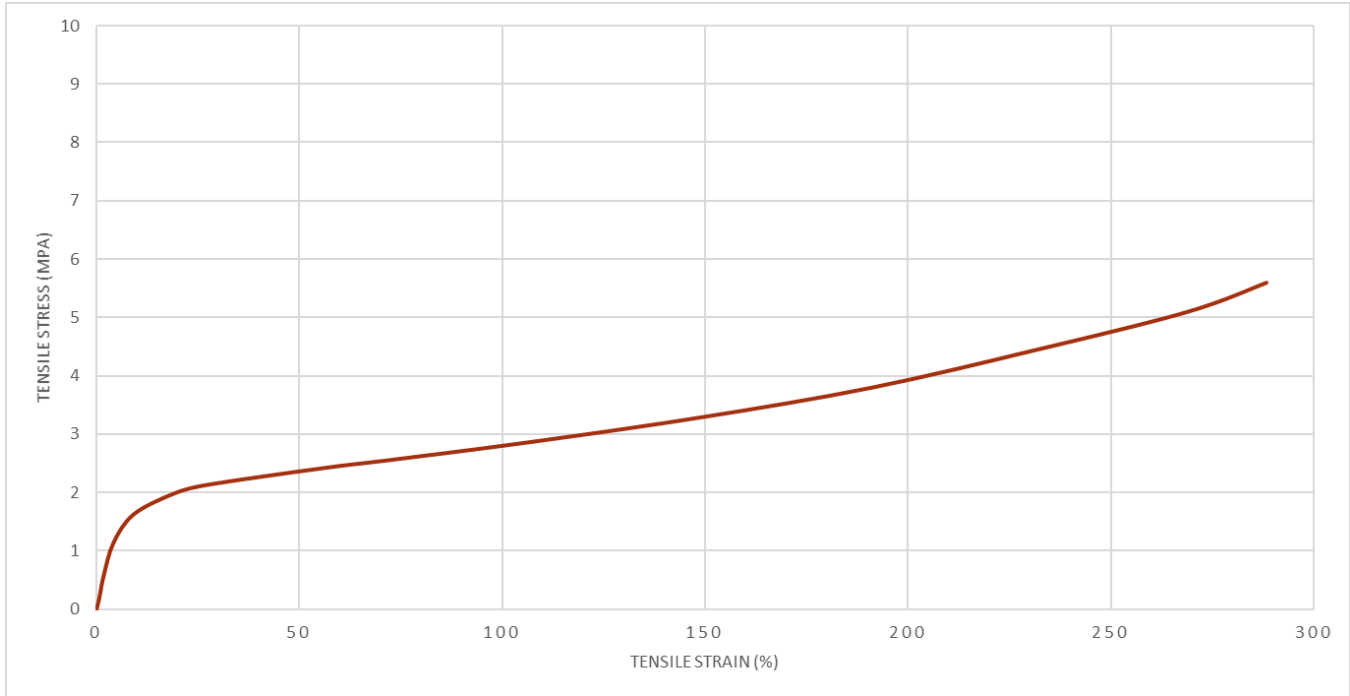


E-IND402—A70 High Rebound

Description

LOCTITE Engineering Grade products are high performance fluids developed to be highly consistent with extraordinary attributes. **E-IND402** is an elastomeric UV photocurable resin for Digital Light Processing (DLP) systems. **E-IND402** exhibits high resilience while maintaining excellent tensile strength. **E-IND402** is a single component system with excellent green strength and does not require thermal post processing.



Mechanical Properties	Method	Value
Tensile Strength	ASTM D638	5.6 ± 0.1 MPa ¹
Young's Modulus	ASTM D638	30 ± 5 MPa ¹
Elongation at Break	ASTM D638	285 ± 6 % ¹
Energy Return	Internal method	37 % ²

Liquid Properties

Viscosity @ 25°C (77°F)	13,500 cP ³
Flow Characteristic	Self-leveling, Newtonian fluid
Appearance Color	Red

- 1) FOR10540
- 2) FOR10887
- 3) FOR10888

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Machine Settings

LOCTITE IND402 is formulated to print with 385-405 nm wavelength projectors with irradiance between 3-7 mW/cm². Layer time is given below at 6 mW/cm².

Layer Thickness:	50um	100um
Base Cure Time:	25s	25s
Model Layer Cure Time:	2-4s	4-6s

Post Processing

E-IND402 requires post processing to achieve specified properties. Support structures should be removed from the printed part then the part may be washed in IPA for 2 minutes and sprayed with pressurized air to remove residual resin. Part should be allowed to dry at room temperature or 35C for 5-15 minutes to remove any residual solvent.

Post Curing

It is recommend to use wide spectrum UV light (5-10 J/cm² per side, eg: Heraeus microwave UV system LH6 mercury bulb, 100% intensity, 10-20 feet per minute, 2-4 passes per part side).

Liquid Handling Requirements

When handling liquid, always wear gloves and protective glasses to prevent skin and eye contact. User must wear suitable respiratory protection if liquid is heated above ambient temperature (25C) or aerosolized during post-processing.

Please refer to the Material Safety Data Sheet (MSDS) on this product for more information on safe handling.