

LOCTITE®



LOCTITE® 3D IND249™

Black

LOCTITE®

Henkel Corporation

loctite3dp@henkel.com





IND249 BK™



LOCTITE 3D IND249 BK™

LOCTITE 3D IND249 BK is a high-temperature, high-strength material that prints challenging geometries with fine feature resolution. This low-viscosity material features exceptionally high green strength to enable ease of processing.

Stiffness and thermal durability make LOCTITE 3D IND249 BK ideal for production applications, including mold tooling, manufacturing aids, and other complex geometries.

LOCTITE 3D IND249 BK has validated workflows for printing on various DLP platforms.



Benefits:

- Exceptionally high stiffness
- Low viscosity
- High accuracy
- Good temperature resistance



Ideal for:

- Challenge geometries
- Mold tooling
- Manufacturing aids



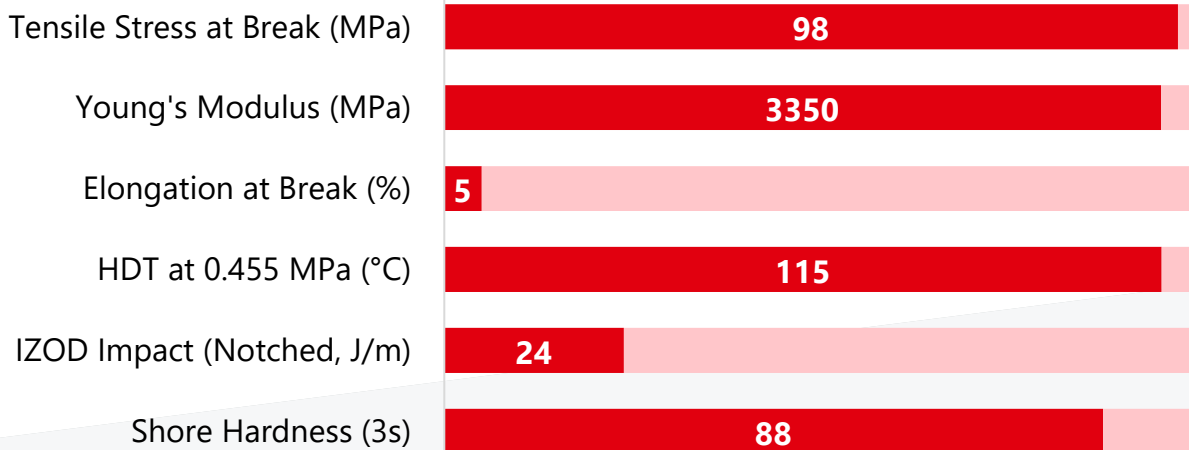
Markets:



Industry



Consumer Goods



*Values shown are linked to LOCTITE IND249 BK 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
Tensile Stress at Yield	MPa	ASTM D638	43 - 53 ^[1]	-
Tensile Stress at Break	MPa	ASTM D638	37 - 46 ^[1]	83 - 98 ^[1]
Young's Modulus	MPa	ASTM D638	1700 - 1880 ^[1]	2980 - 3350 ^[1]
Elongation at Break	%	ASTM D638	16 - 24 ^[1]	4 - 7 ^[1]
Flexural Modulus	MPa	ASTM D790	2340 - 3330 ^[2,3]	3170 - 3600 ^[3,4]
Flexural Elongation at Break	%	ASTM D790	> 5 ^[2,3]	4 - 5 ^[3,4]
Flexural Stress at Break	MPa	ASTM D790	94 - 130 ^[2,3]	127 - 153 ^[3,4]
Other Properties				
HDT at 0.455 MPa	°C	ASTM D648	-	113 - 117 ^[5,6]
HDT at 1.82 MPa	°C	ASTM D648	-	96 - 101 ^[7,6]
IZOD Impact (Notched)	J/m	ASTM D256	11 - 24 ^[8,9]	13 - 24 ^[10,8]
Water Absorption (24hr)	%	ASTM D570	-	0.5 - 0.7 ^[11,12]
Water Absorption (72hr)	%	ASTM D570	-	0.7 - 0.9 ^[11,12]
Shore Hardness (3s)	D	ASTM D2240	74 - 87 ^[13,14]	81 - 88 ^[13,15]
Solid Density	g/cm ³	ASTM D792	1.16 - 1.19 ^[16,17]	1.17 - 1.20 ^[16,17]
Thermal Conductivity	W/(m·K)	ASTM D5930	-	0.2 - 0.21 ^[21]
Heat Capacity	J/(g·K)	ASTM D5930	-	1.4 - 1.5 ^[21]
CTE (< 55°C)	µm/(m·K)	ASTM E831	-	60.4 - 66.6 ^[22]

Liquid Properties	Measure	Method	Value
Viscosity at 25°C (77°F)	cP	ASTM D7867	444 - 461 ^[18,19]
Liquid Density	g/cm ³	ASTM D1475	1.09 - 1.10 ^[17,16]

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, 5 mm/min, D790-B, 2 mm/min, D648, D256 Notched IZOD (Machine Notched), 6 mm x 12 mm, D570 0.125" x 2" Disc 24hr@ 25°C, D2240, Type "D" (3 seconds), D7867, D1475

Internal Data Sources:

[1] GEN329696, [2] FOR317892, [3] FOR317854, [4] FOR317895, [5] FOR338673, [6] FOR338726, [7] FOR332911, [8] FOR332913, [9] FOR331481, [10] FOR317866, [11] FOR332975, [12] FOR316403, [13] FOR332977, [14] FOR317904, [15] FOR317906, [16] FOR332976, [17] FOR316402, [18] FOR323025, [19] FOR316377, [21] FOR377534, [22] FOR377524





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PROPERTIES

Electrical Properties	Measure	Method	Green	Post Processed
Volume Resistivity	$\Omega \cdot \text{cm}$	ASTM D257	-	8.54E+15 - 1.42E+16 ^[23]
Surface Resistivity	Ω	ASTM D257	-	2.03E+16 - 4.61E+16 ^[23]
Dielectric Strength	kV/mm	ASTM D149	-	24.00 – 26.4 ^[24]
AC Relative Permittivity (Dielectric Constant) ^[25]				
at 50 Hz (XY)	none	ASTM D150	-	3.2 - 3.8
at 1 kHz (XY)	none	ASTM D150	-	3.4 - 3.8
at 1 MHz (XY)	none	ASTM D150	-	2.5 - 3.3
AC Loss Characteristic (Dissipation Factor) ^[25]				
at 50 Hz (XY)	none	ASTM D150	-	0.107 - 0.147
at 1 kHz (XY)	none	ASTM D150	-	0.054 - 0.094
at 1 MHz (XY)	none	ASTM D150	-	0.208 - 0.348

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, 5 mm/min, D790-B, 2 mm/min, D648, D256 Notched IZOD (Machine Notched), 6 mm x 12 mm, D570 0.125" x 2" Disc 24hr@ 25°C, D2240, Type "D" (3 seconds), D7867, D1475

Internal Data Sources:

[23] FOR402775, [24] FOR402788, [25] FOR402809





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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 IND249 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

Settings: 385 nm at 5 mW/cm ²	Measure	Method	Value
Layer Thickness	µm	Internal	100
First Layer	s	Internal	30
Burn in Region	s	Internal	20
Model Layer Cure Time	s	Internal	7

Settings: 385 nm at 5 mW/cm ²	Measure	Method	Value
E _C	mJ/cm ²	Internal	11.37 ^[1, 20]
D _p	mm	Internal	0.28 ^[1, 20]

Settings: 385 nm at 5 mW/cm ²	Measure	Method	Exposure time
D _C = 100µm	s	Internal	1.82 ^[1, 20, *]
D _C = 50µm	s	Internal	1.30 ^[1, 20, *]

Test parameters:
* Exposure times are calculated without a safety factor.

Internal Data Sources:
[1] GEN329696, [20] FOR328621





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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>

CLEANING

LOCTITE 3D IND249 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 Step #1	IPA	Ultrasonic	1 min	1	Dry after each interval
Cleaning Step #2	IPA	Ultrasonic	1 min	1	Dry after each interval
Dry	n.a.	Compressed air	10 to 60 s	1	Air pressure (50psi)
Wait before post curing	n.a.	Ambient condition	60 min	1	Room temperature

POST CURING

LOCTITE 3D IND249 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.

If a lower energy LED or other post cure unit is used, an additional heat cure at 130°C for 2 hours may be required to realize highest HDT performance. Allow the parts to rest one hour between UV cure and heat cure. To minimize risk of warpage place parts in cold oven before ramping up temperature to target value and cool down parts slowly in switched off oven after reaching the heat curing conditions.

UV Curing Unit	UV Source	Intensity	Cure time per side	Additional Settings (Shelf, Output Energy)	Heat Cure
Dymax 5000 EC Flood	Mercury Arc Bulb (broad spectrum)	148 mW/cm ² at 380 nm	10 min	400W, Shelf K	-
Loctite CL36	405nm LED	80 mW/cm ² at 405 nm	30 min	100% top & side	2 hours at 130°C
PCU 90	Metal halide	100%	20 min	Rotary Table	2 hours at 130°C



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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>

STORAGE

Store **LOCTITE 3D IND249 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.





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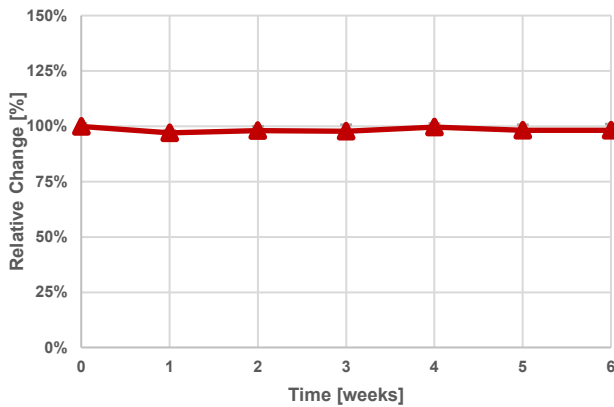
AGEING AND ENVIRONMENTAL EFFECTS – HEAT AGEING

LOCTITE 3D IND249 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 D638 at standard lab conditions (22°C).

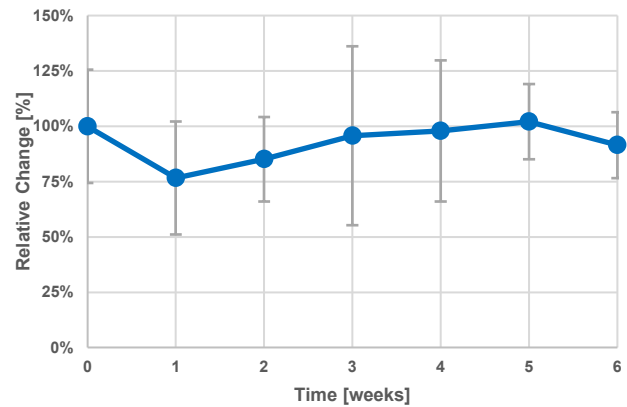
“0 weeks” represents non-aged samples stored at 22°C and tested 24 hours after post-processing.

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.

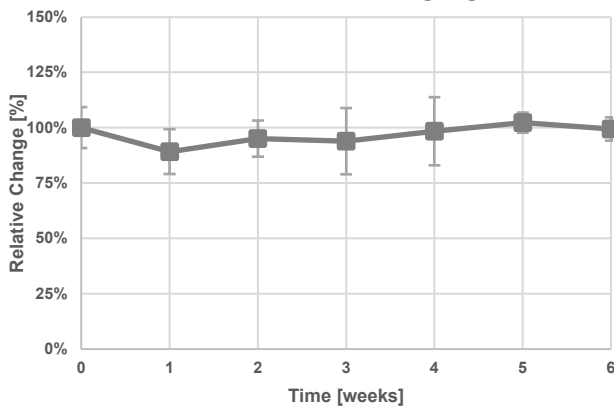
Young's Modulus after Heat Ageing at 50°C



Elongation at Break after Heat Ageing at 50°C



Stress at Break after Heat Ageing at 50°C



Test parameters:

ASTM D638: Type IV, Pull speed: 5 mm/min, Young's modulus measured at 0.1-1.0% (regression), 22°C

Internal Data Sources:
[FOR382546](#), [FOR382551](#)





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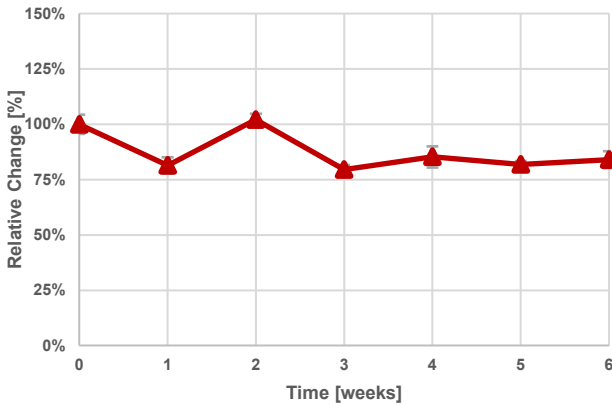


AGEING AND ENVIRONMENTAL EFFECTS – ACCELERATED WEATHERING (UV AGEING)

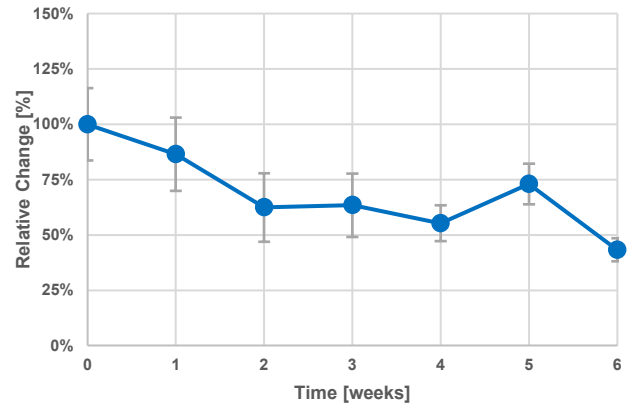
LOCTITE 3D IND249 BK has been tested after accelerated outdoor weathering according to ASTM D4329 (Cycle A). Test samples were exposed to defined conditions of heat, water condensation and UV light. Exposed samples were conditioned for 24 hours at 22°C before mechanical testing. Control samples were 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 D638 at standard lab conditions (22°C). "0 weeks" represents non-aged samples stored at 22°C and tested 24 hours after post-processing.

Please note, accelerated weathering testing can never fully represent real outdoor conditions and complexity. It is therefore recommended to conduct additional (outdoor) testing relevant for your specific application needs.

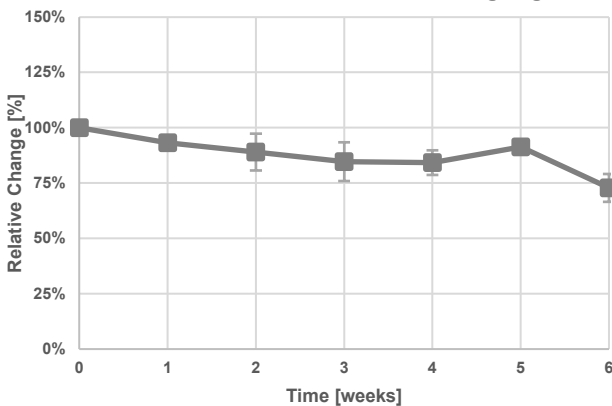
Young's Modulus after UV Ageing



Elongation at Break after UV Ageing



Stress at Break after UV Ageing



Test parameters:

ASTM D638: Type IV, Pull speed: 5 mm/min, Young's modulus measured at 0.1-1% (regression), 22 °C

ASTM D4329: Cycle A for general applications, QUV/se, UVA 340 nm, 0.89 W/m²·nm, 8 hours UV light at 60°C followed by 4 hours at 50°C condensation in the dark. To reduce any sample warpage during test time samples were placed in tailor-made holders without any fixation clamps or mechanical load. Exposed samples were always removed from QUV before next condensation cycle to avoid samples that are soaked excessively with water before testing.

Internal Data Sources:
[FOR390777](#), [FOR390768](#)

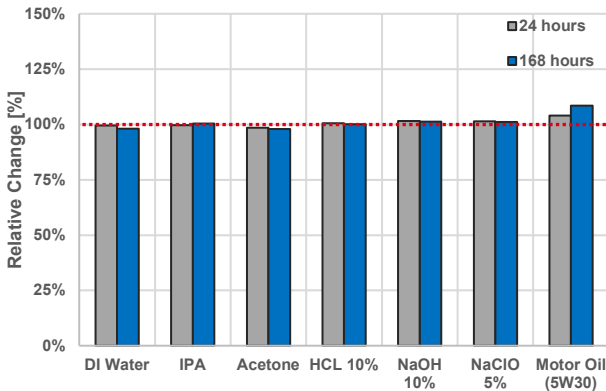




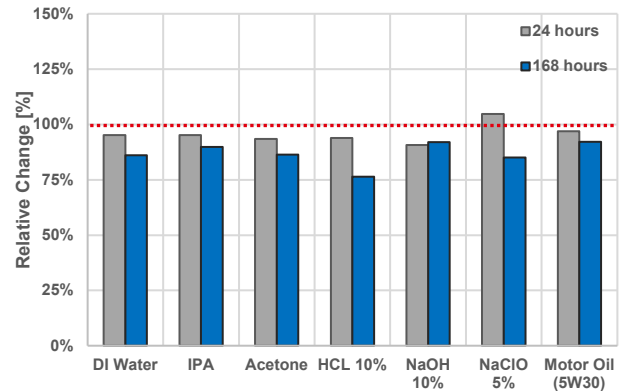
AGEING AND ENVIRONMENTAL EFFECTS – CHEMICAL RESISTANCE (1/2)

LOCTITE 3D IND249 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). "100%" represents non-aged samples stored at 22°C and tested 24 hours after post-processing.

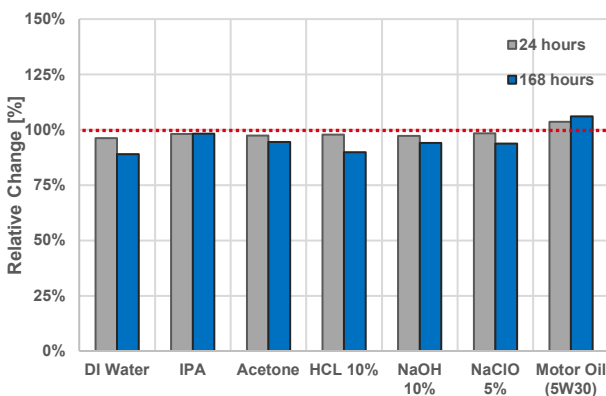
Young's Modulus after Immersion Time



Elongation at Break after Immersion Time



Stress at Break after Immersion Time



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 Motor Oil were stored at 50°C.

Properties of media used: pH(HCl, 10%) = 1; pH(NaOH, 10%) = 14; pH(NaClO, 5%) = 13

Internal Data Sources:

DI water: FOR423057, IPA: FOR423062, Acetone: FOR423064, HCL 10 %: FOR423065, NaOH 10 %: FOR402572, NaClO 5 %: FOR402575, 5W30: FOR402578



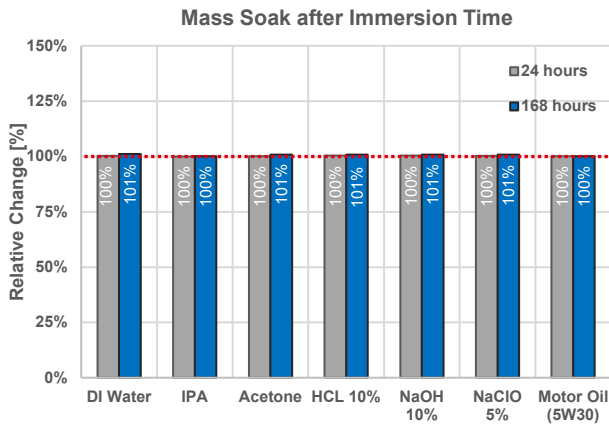


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AGEING AND ENVIRONMENTAL EFFECTS – CHEMICAL RESISTANCE (2/2)

LOCTITE 3D IND249 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. "100%" represents the initial weight 24 hours after post-processing.



Test parameters:

ASTM D543: Samples immersed in different chemicals were stored at 22°C. Samples immersed in Motor Oil were stored at 50°C. Properties of media used: pH(HCl, 10%) = 1; pH(NaOH, 10%) = 14; pH(NaClO, 5%) = 13

Internal Data Sources:

DI water: FOR423067, IPA: FOR423069, Acetone: FOR423073, HCl 10 %: FOR423076, NaOH 10 %: FOR402584, NaClO 5 %: FOR402585, 5W30: FOR402586





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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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