LOCTITE®



LOCTITE® 3D 3843™

TOUGH
Matte Black, White, Clear

LOCTITE®
Henkel Corporation
loctite3d@henkel.com

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LOCTITE 3D 3843™

Semi-flexible resin with moderate temperature resistance HDT60, high impact strength, and versality for a broad range of applications.

LOCTITE 3D 3843 is a high-strength engineering plastic with good impact resistance and excellent surface finish. It is ideal for a wide variety of tooling applications on the production floor.

LOCTITE 3D 3843 displays high green strength and HDT enabling it to print accurately and function at room temperature. It is compatible with a broad range of DLP machines.

Benefits:

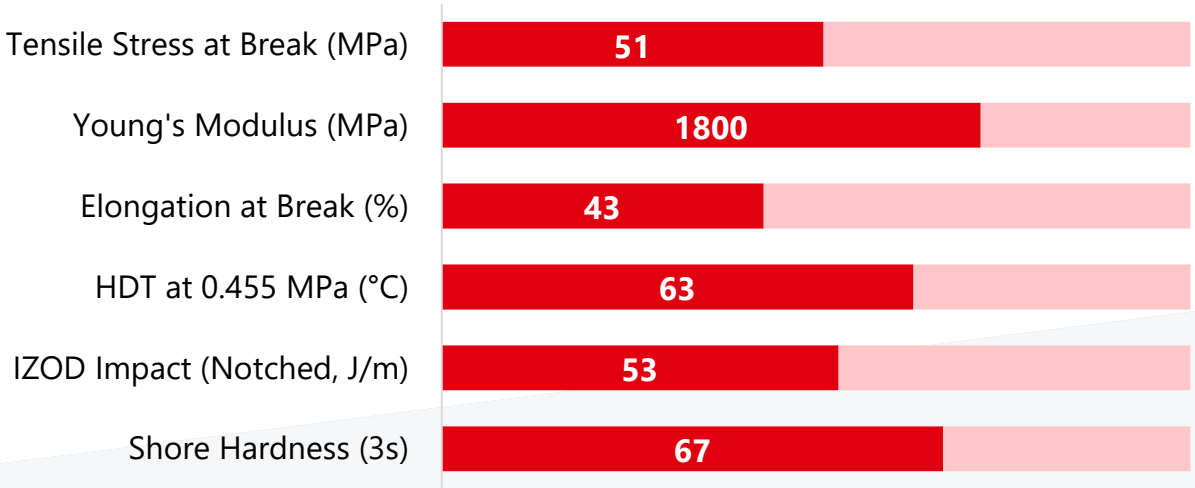
- Moderate heat resistance, HDT 60° C
- Tough with outstanding surface finish
- Superior strength and impact resistant

Ideal for:

- Manufacturing aids
- Jigs and fixtures
- Housings and covers
- Insoles

Markets:

Industry | Automotive | Consumer Goods



**Values shown are linked to LOCTITE 3843 Matte 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	1572 ± 31 [5]	1806 ± 47 [1]
Tensile Stress at Yield	MPa	ASTM D638	44 ± 1 [5]	53 ± 2 [1]
Elongation at Yield	%	ASTM D638	4.3 ± 0.1 [5]	4.7 ± 0.1 [1]
Tensile Stress at Break	MPa	ASTM D638	38 ± 1 [5]	51 ± 2 [1]
Elongation at Break	%	ASTM D638	52 ± 10 [5]	43 ± 10 [1]
Poisson's Ratio	-	ASTM D638	-	0.38 ± 0.03 [19]
Flexural Modulus	MPa	ASTM D790	1113 ± 23 [6]	1783 ± 45 [2]
Flexural Stress at Break	MPa	ASTM D790	-	-
Flexural Elongation at Break	%	ASTM D790	>5 [6]	>5 [2]
IZOD Impact (Notched)	J/m	ASTM D256	-	53 ± 4 [4]
Shore Hardness (3s)	D	ASTM D2240	63 [11]	67 [9]
Other Properties				
HDT at 0.455 MPa	°C	ASTM D648	-	63°C [3]
HDT at 1.82 MPa	°C	ASTM D648	-	54°C [16]
Water Absorption (24hr)	%	ASTM D570	-	1.94 [7]
Water Absorption (72hr)	%	ASTM D570	-	3.21 [7]
Solid Density	g/cm^3	ASTM D1475	1.18 [10]	1.18 [10]
Thermal Conductivity	W/(m·K)	ASTM D5930	-	0.21 [12]
Heat Capacity	J/(g·K)	ASTM D5930	-	1.5 ± 0.1 [12]
CTE (10°C to 60°C)	µm/(m·K)	ASTM E831	-	131.9 [14]
Tg	°C	ASTM E1640	-	113.9[17]
Horizontal Burning Test	-	UL94	-	HB at 2mm [18]

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, 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), UL94 at 2 mm thickness, 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]FOR16424, [2]FOR16426, FOR17678, [3]FOR19725, [4]FOR16427, [5]FOR16425, [6]FOR19115, [7]FOR19118, [9]FOR19117, [10]FOR19114, [11]FOR19119, [12]FOR26234, [14]FOR164745, [16]FOR367598, [17]FOR209254, [18]FOR408652, [19]FOR698463

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PROPERTIES

Biocompatibility	Measure	Method	Green	Post Processed
Cytotoxicity		ISO10993-5	-	Comply [15]
Irritation		ISO10993-23*	-	Comply [13]

Liquid Properties	Measure	Method	Value
Viscosity at 25°C (77°F)	cP	ASTM D7867	740 - 880 [8]
Liquid Density	g/cm³	ASTM D1475	1.07 [10]

Electrical Properties	Measure	Method	Green	Post Processed
Volume Resistivity	Ω·cm	ASTM D257	-	6.5E +14 [1]
Surface Resistivity	Ω	ASTM D257	-	5.7E +15 [1]
Dielectric Strength	kV/mm	ASTM D149	-	28.1± 1.8 [2]
AC Relative Permittivity (Dielectric Constant)[3]				
at 50 Hz (XY)	none	ASTM D150	-	4.8
at 1 kHz (XY)	none	ASTM D150	-	4.9
at 1 MHz (XY)	none	ASTM D150	-	4.4
AC Loss Characteristic (Dissipation Factor)[4]				
at 50 Hz (XY)	none	ASTM D150	-	0.021
at 1 kHz (XY)	none	ASTM D150	-	0.021
at 1 MHz (XY)	none	ASTM D150	-	0.041

Internal Data Sources:
[1] FOR25869, [2] FOR25870, [3] FOR25870, [4] FOR25872 [13]FOR52814, [8]GEN792130, [15]FOR105481

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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 3843 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: 385nm at 5 mW/cm²	Measure	Method	Value
Layer Thickness (µm):	µm	Internal	100
Burn-in Region (s)	s	Internal	50
Transition Region (s):	s	Internal	12.5
Model Region (s):	s	Internal	9.5

Settings: 385 nm at 5 mW/cm²	Measure	Method	Value
E_C	mJ/cm²	Internal	9.97 [1]
D_P	mm	Internal	0.16 [1]

Settings: 385 nm at 5 mW/cm²	Measure	Method	Exposure time
D_C =50um	s	Internal	2.7*
D_C =100um	s	Internal	3.7*

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

Internal Data Sources:
[1] FOR46925

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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 3843 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	Cleaner C	Ultrasonic	2 min	1 or 2	Dry after each interval
Cleaning Step #2	IPA	Ultrasonic	1 min	1	
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 3843 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)
Dymax 5000 EC Flood	Mercury Arc Bulb (broad spectrum)	148 mW/cm^2 at 380 nm	2 min	400W, Shelf K
Loctite CL36	405nm LED	80 mW/cm^2 at 405 nm	20 min	100% top & side
Uvitron Intelliray 600W	Mercury Arc Bulb (broad spectrum)	66% Intensity	2 min	

STORAGE

Store LOCTITE 3D 3843 BK in the unopened container in a dry location. Optimal Storage: 8°C to 30C°. 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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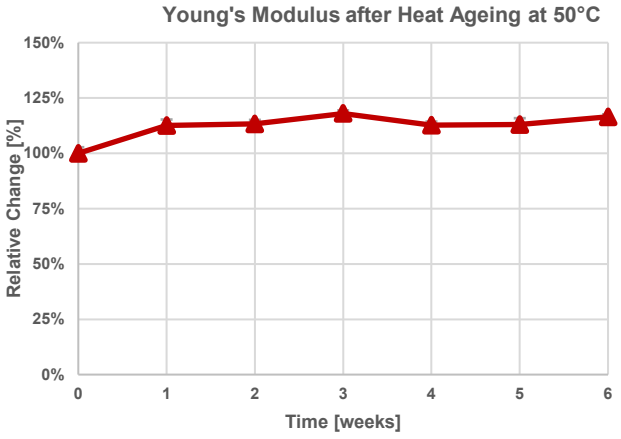


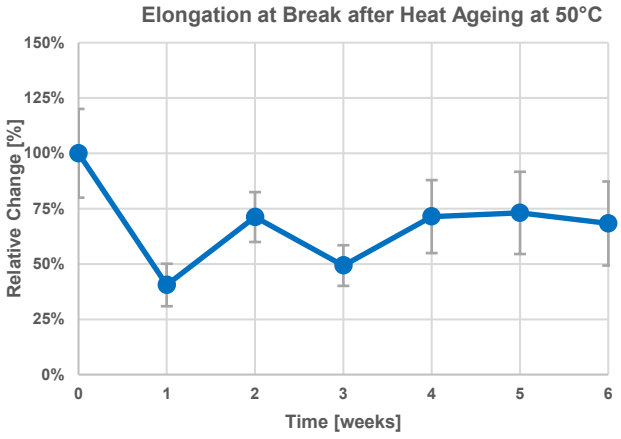
AGEING AND ENVIRONMENTAL EFFECTS – HEAT AGEING

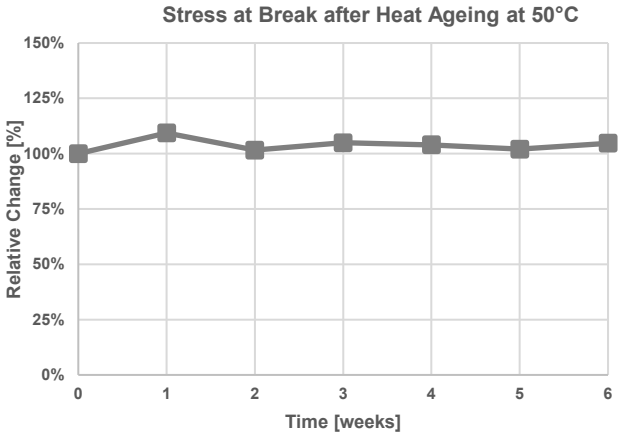
LOCTITE 3D 3843 BK was heat aged without load according to ASTM D3045. Test samples were exposed for a defined time at 50°C and conditioned for 24 hours at 22°C before mechanical testing. Control samples were stored at a constant 22°C. All samples were printed in the same print job using a validated workflow. Mechanical testing was conducted according to ASTM D638 at standard lab conditions (22°C).

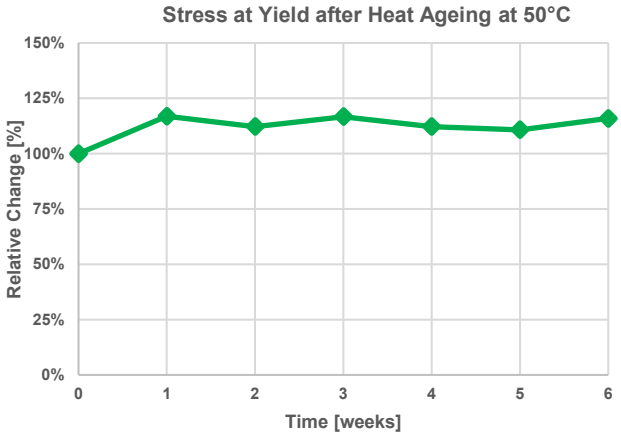
Values at '0 weeks' are non-aged samples stored at 22°C and tested after 24 hours of post-processing.

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

Internal Data Sources:
FOR88727, FOR88738

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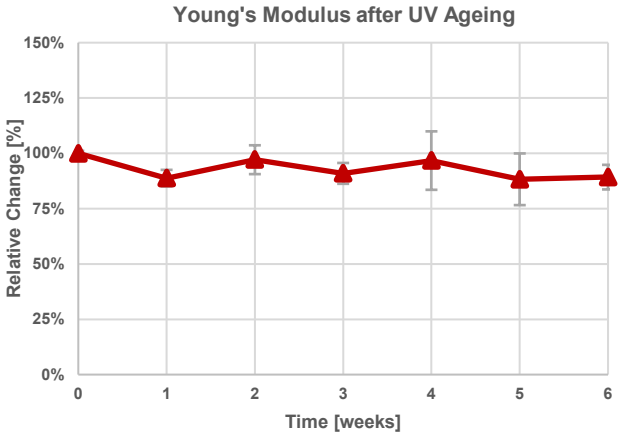


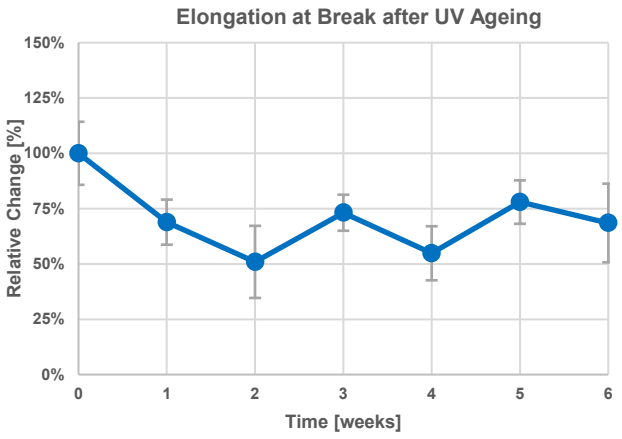
AGEING AND ENVIRONMENTAL EFFECTS – ACCELERATED WEATHERING (UV AGEING)

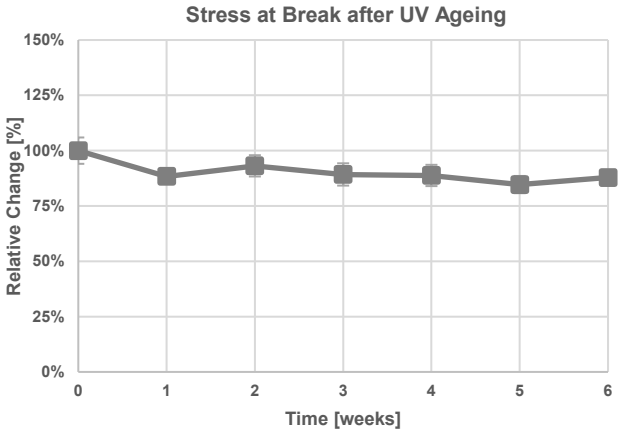
LOCTITE 3D 3843 BK has been tested after accelerated outdoor weathering according to ASTM D4329 (Cycle A). Test samples were exposed to defined conditions of heat, water condensation and UV light. Exposed samples were conditioned for 24 hours at 22°C before mechanical testing. Control samples were stored 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).

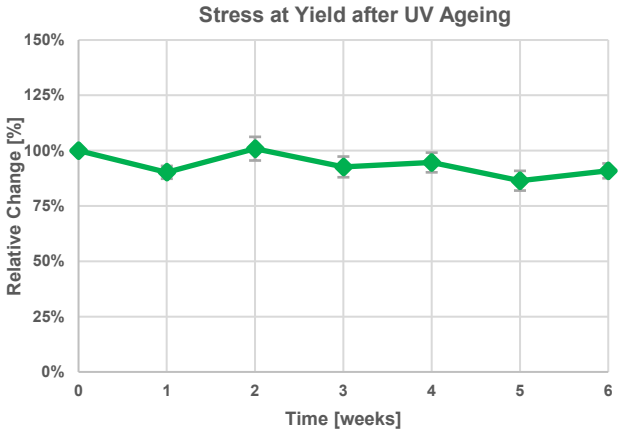
Values at '0 weeks' are non-aged samples stored at 22°C and tested after 24 hours of post-processing.

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.









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:
FOR123511, FOR123528

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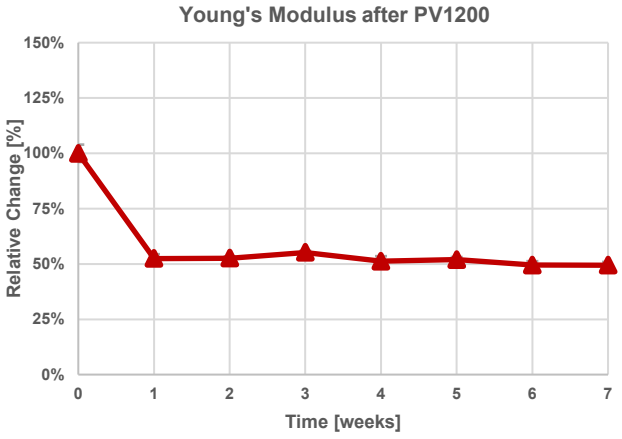


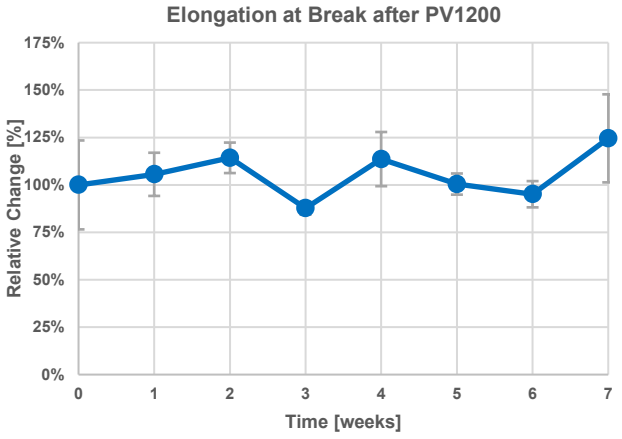
AGEING AND ENVIRONMENTAL EFFECTS – CLIMATE CYCLING TEST (PV1200)

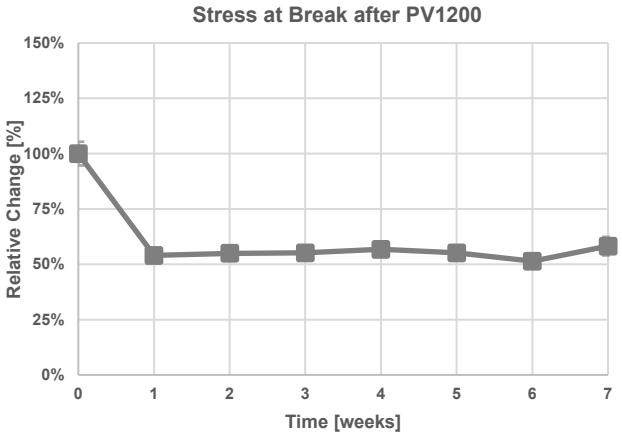
LOCTITE 3D 3843 BK was tested in an environmental climate cycling test according to PV1200 specification. This specification was developed by Volkswagen AG to evaluate material durability and cycles between -40°C (4 hours) and 80°C (4 hours at 80 % rel. humidity) during a repeating 12-hour cycle. Test samples were exposed to this temperature cycle for a total duration of 7 weeks (100 cycles).

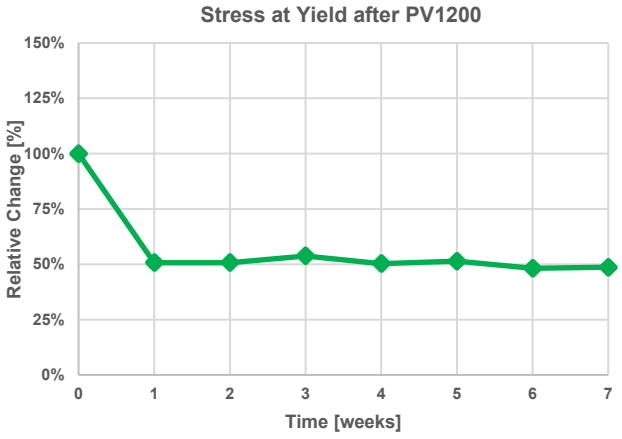
Before mechanical testing samples were conditioned for 24 hours at 22°C. Control samples were stored at a constant 22°C. All samples were printed in the same print job using a validated workflow. Mechanical testing was conducted according to ASTM D638 at standard lab conditions (22°C).

Values at '0 weeks' are non-aged samples stored at 22°C and tested after 24 hours of 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
PV1200: Samples were removed from climate chamber during heating phase (Cycle time: 240-300 minutes) and then conditioned for 24 hours at 22°C. One Test cycle is equal to 12 hours of test time. "7 weeks" of test time represent 100 test cycles or 1200 hours of test time.

Internal Data Sources:
FOR283032, FOR283043

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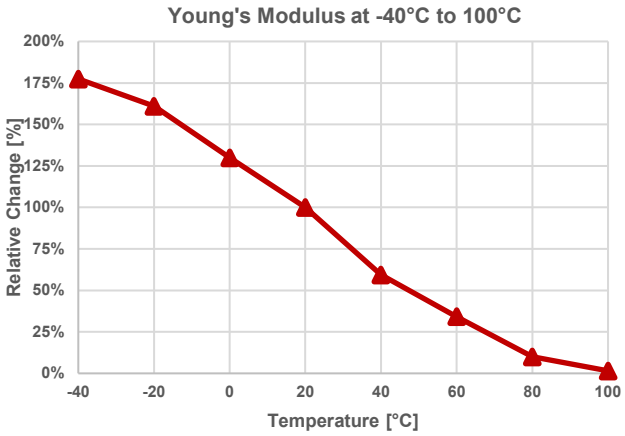
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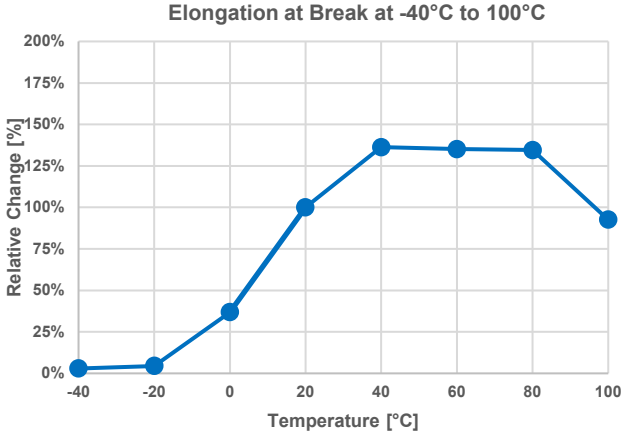
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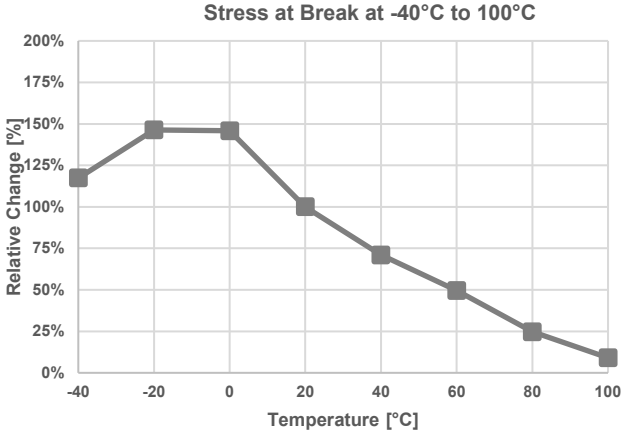


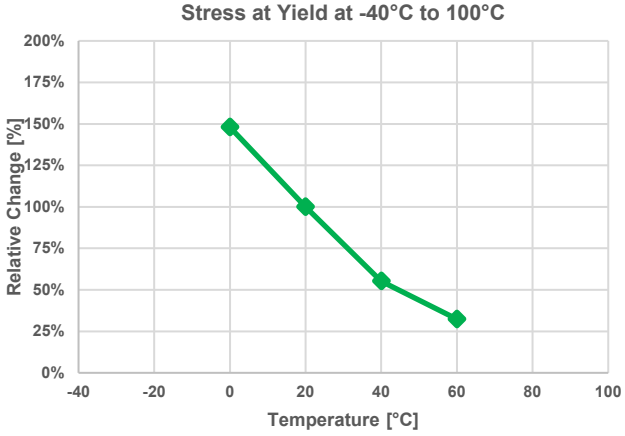
THERMAL INFLUENCE ON MECHANICAL PROPERTIES

LOCTITE 3D 3843 BK has been tested according to ASTM D638 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 D638. Before each test series samples were conditioned for 60 minutes at the specific test temperature.









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

Internal Data Sources:
[1] FOR176839

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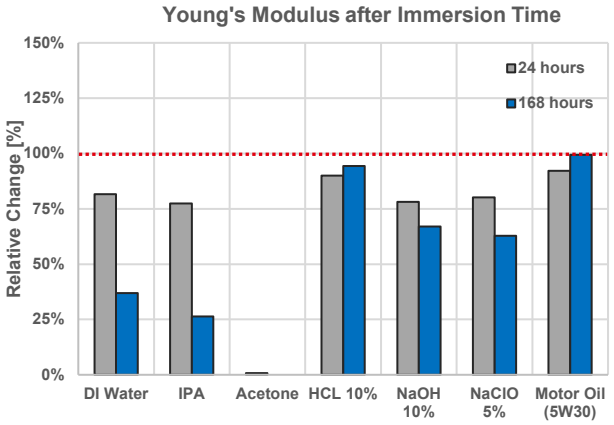
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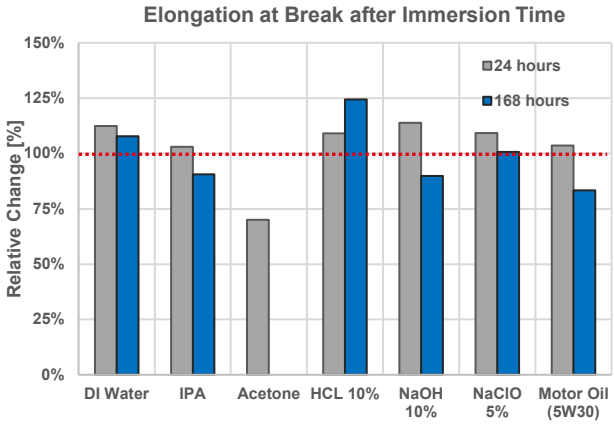


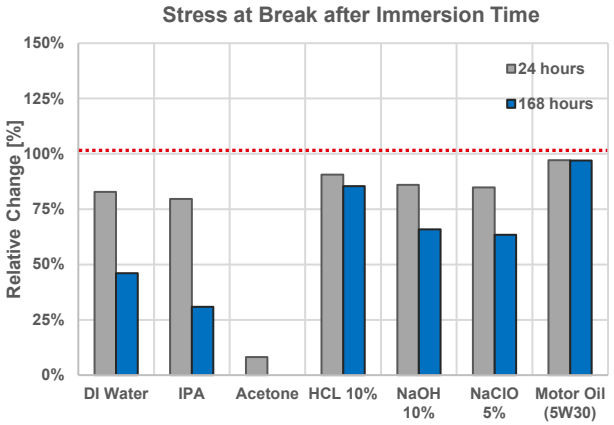
AGEING AND ENVIRONMENTAL EFFECTS – CHEMICAL RESISTANCE INDUSTRIAL

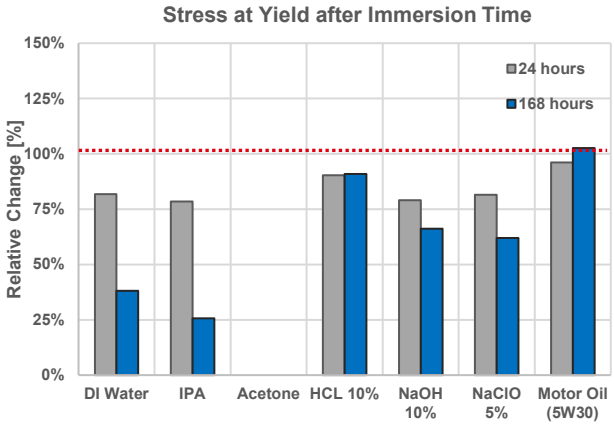
LOCTITE 3D 3843 BK has been tested after chemical ageing according to ASTM D543. The influence of chemicals was tested by measuring mechanical properties after different test times (Immersion test for 24 and 168 hours). Exposed samples were stored in containers and fully immersed in different chemicals. 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 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:
FOR151552, FOR151553, FOR154832, FOR151551, FOR158466, FOR158473, FOR158475

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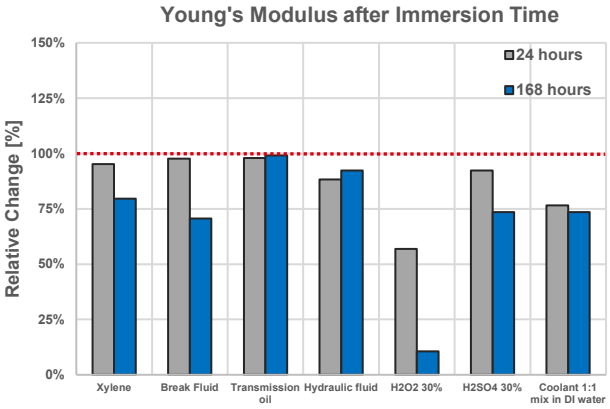
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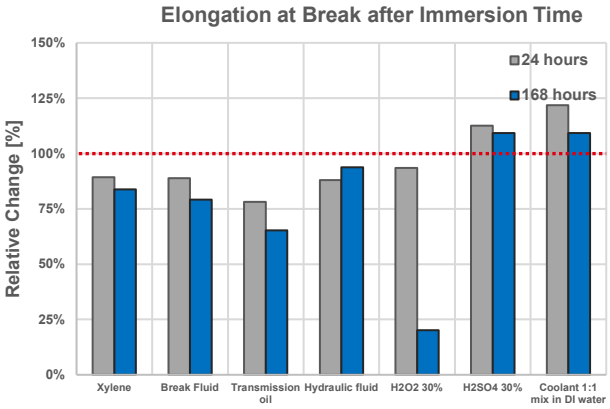


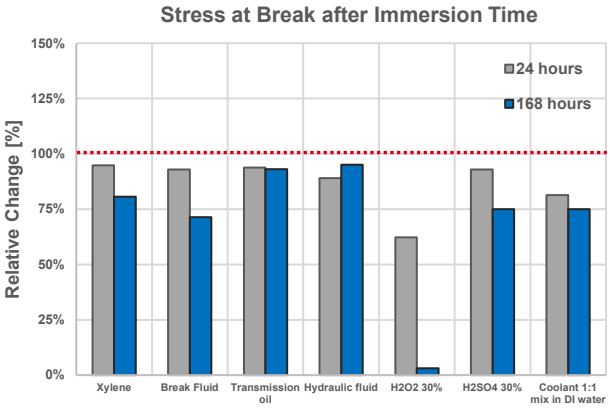
AGEING AND ENVIRONMENTAL EFFECTS – CHEMICAL RESISTANCE AUTOMOTIVE

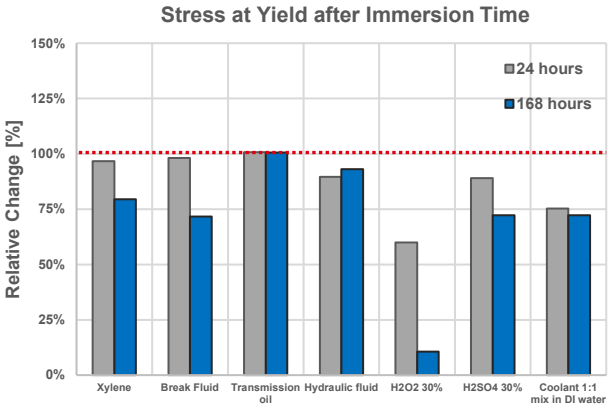
LOCTITE 3D 3843 BK has been tested after chemical ageing according to ASTM D543. The influence of chemicals was tested by measuring mechanical properties after different test times (Immersion test for 24 and 168 hours). Exposed samples were stored in containers and fully immersed in different chemicals. 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

Internal Data Sources:
FOR605058, FOR605059, FOR605060, FOR605068, FOR618204, FOR618223, FOR618234

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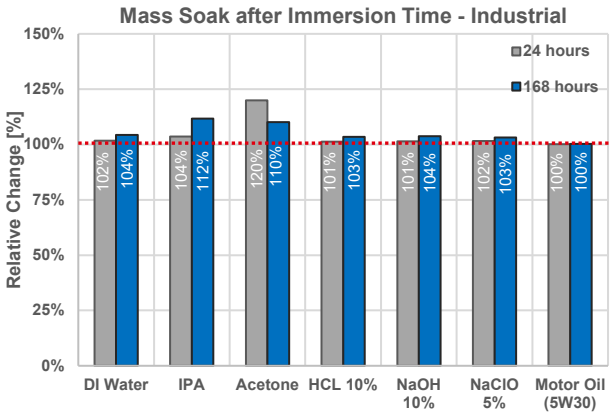
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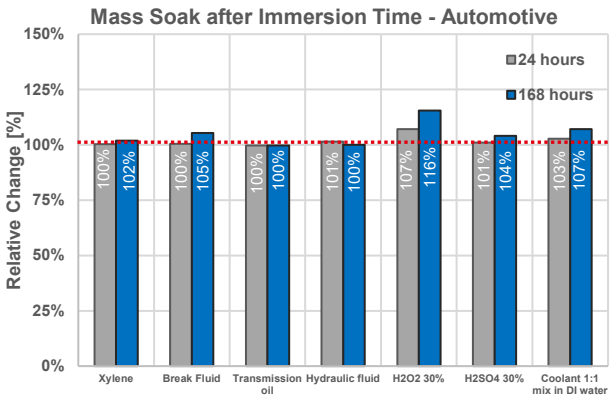


AGEING AND ENVIRONMENTAL EFFECTS – CHEMICAL RESISTANCE MASS SOAK

LOCTITE 3D 3843 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 D543: Samples immersed in different chemicals were stored at 22°C. Samples immersed in Motor Oil, Transmission Oil and Coolant mix 1:1 were stored at 50°C.
Properties of media used: pH(HCl 10%) = 1; pH(NaOH 10%) = 14; pH(NaClO 5%) = 13; 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 for coolant mix 1:1 = -40°C

Internal Data Sources:
FOR605058, FOR605059, FOR605060, FOR605068, FOR618204, FOR618223, FOR618234

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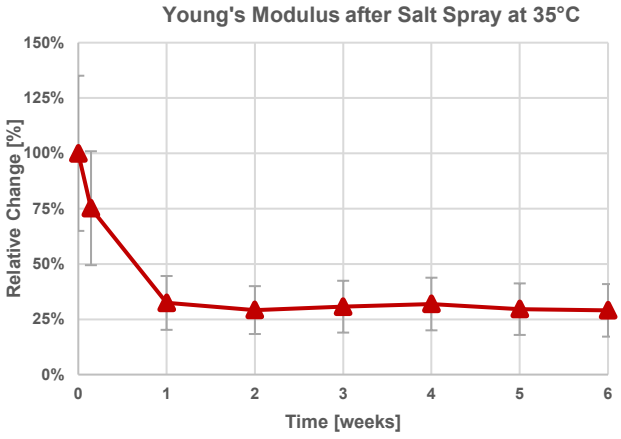


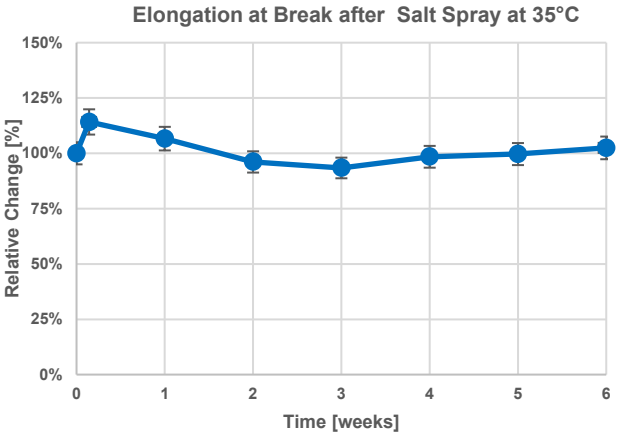
AGEING AND ENVIRONMENTAL EFFECTS – SALT SPRAY EXPOSURE

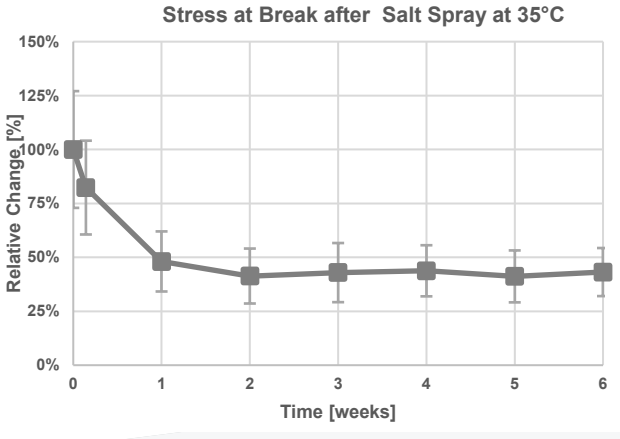
LOCTITE 3D 3843 BK was aged according to ASTM B117-19. During the test samples were exposed to salt spray at 35°C. After removal from the test chamber, exposed samples were dried, inspected, cleaned using water and wiped dry. Before mechanical testing, samples were conditioned for 24 hours at 22°C. All 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).

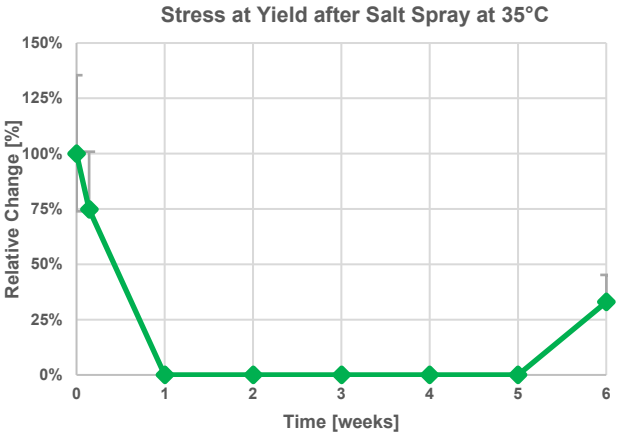
Values at '0 weeks' are non-aged samples stored at 22°C and tested after 24 hours of post-processing.

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.









Test parameters:
ASTM B117-19: pH = 6.1; Fog collection = 1.3 ml/h
ASTM D638: Type IV, Pull speed: 5 mm/min, Young's modulus measured at 0.1-1.0% (regression), 22°C

Internal Data Sources:
FOR464402, FOR483423

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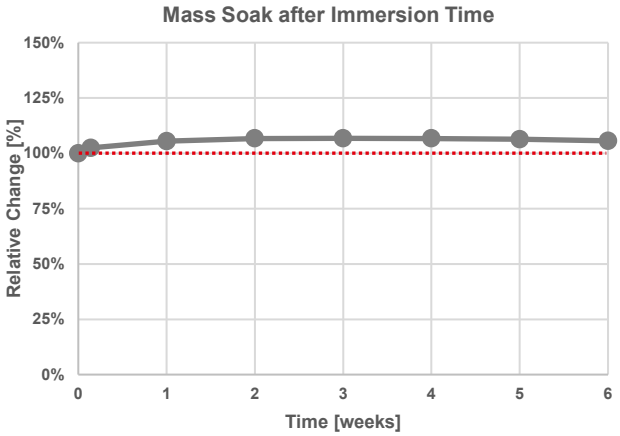


AGEING AND ENVIRONMENTAL EFFECTS – SALT SPRAY EXPOSURE

LOCTITE 3D 3843 BK has been tested after salt spray exposure according to ASTM B117-19. All samples were printed in the same print job using a validated workflow. After removal from the salt spray environment, exposed samples were dried, inspected, cleaned using water, wiped dry and immediately weighed.

The influence of the salt spray was measured by mass change after different exposure times. Samples were weighed after 24 hours and 1 to 6 weeks.

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



Test parameters:
ASTM B117-19: pH = 6.1; Fog collection = 1.3 ml/h
ASTM D638: Type IV, Pull speed: 5 mm/min, Young's modulus measured at 0.1-1.0% (regression), 22°C

Internal Data Sources:
FOR464403

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PROPERTIES

Mechanical Properties	Measure	Method	Green	Post Processed
Young's Modulus	MPa	ASTM D638	1318 ± 31 [1]	1720 ± 72 [2]
Tensile Stress at Yield	MPa	ASTM D638	36.2 ± 1.0 [1]	52.6 ± 1 [2]
Elongation at Yield	%	ASTM D638	4.4 ± 0.2 [1]	4.8 ± 0.1 [2]
Tensile Stress at Break	MPa	ASTM D638	33.1 ± 2.6 [1]	49.0 ± 1 [2]
Elongation at Break	%	ASTM D638	74.4 ± 9.9 [1]	47.6 ± 8 [2]
Flexural Modulus	MPa	ASTM D790	721 ± 36 [3]	1673 ± 44 [4]
Flexural Stress at Break	MPa	ASTM D790	-	-
Flexural Strain at Break	%	ASTM D790	>5 [3]	>5 [4]
IZOD Impact (Notched)	J/m	ASTM D256	-	58.3 ± 4.2 [7]
IZOD Impact (Unnotched)	J/m	ASTM D256	-	175.3 ± 12.8 [8]
Shore Hardness (3s)	D	ASTM D2240	64 [10]	76 [11]
Other Properties				
HDT at 0.455 MPa	°C	ASTM D648	50 [5]	62 [12]
HDT at 1.82 MPa	°C	ASTM D648	-	49 [18]
Water Absorption (24hr)	%	ASTM D570	-	2.3 [9]
Water Absorption (72hr)	%	ASTM D570	-	3.5 [9]
Solid Density	g/cm	ASTM D1475	1.18 [13]	1.18 [11]
Thermal Conductivity	W/(m·K)	ASTM D5930	-	0.22 [6]
Heat Capacity	J/(g·K)	ASTM D5930	-	1.6 [6]
CTE (10°C to 60°C)	µm/(m·K)	ASTM E831	-	121.1 [14]
Tg	°C	ASTM E1640	-	115.4[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, 5 mm/min, D790, 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)

Internal Data Sources:
[1]FOR17796, [2]FOR17795, [3]FOR17799, [4]FOR17797, [5]FOR17801, [6]FOR210087, [7]FOR17792, [8]FOR17793, [9]FOR17794, [10]FOR17790, [11]FOR17789, [12]FOR17800, [13]FOR17809, [14]FOR164748, [15] FOR210067, [16]FOR17791, [17]FOR37133, [18] FOR515947

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PROPERTIES

Biocompatibility	Measure	Method	Green	Post Processed
Cytotoxicity		ISO10993-5	-	Comply [3]
Irritation		ISO10993-23*	-	Comply [4]

Liquid Properties	Measure	Method	Green	Post Processed
Viscosity at 25°C (77°F)	cP	ASTM D7867		450 - 650 [1]
Liquid Density	g/cm^3	ASTM D1475		1.07 [2]

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

Internal Data Sources:
[[1]FOR17791, [2]FOR37133, [3]FOR38780, [4] FOR52785

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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 3843 WH 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: 385nm at 5 mW/cm²	Measure	Method	Value
Layer Thickness (µm):	µm	Internal	100
Burn-in Region (s)	s	Internal	45
Transition Region (s):	s	Internal	6
Model Region (s):	s	Internal	4.5

Settings: 385 nm at 5 mW/cm²	Measure	Method	Value
E_C	mJ/cm²	Internal	8.42 [1]
D_P	mm	Internal	0.19 [1]

Settings: 385 nm at 5 mW/cm²	Measure	Method	Exposure time
D_C =50um	s	Internal	2.2*
D_C =100um	s	Internal	2.8*

Test Parameter
*Exposure times are calculated without a safety factor

Internal Data Sources:
[1] FOR18336

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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 3843 WH 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	2 min	1 or 2	Dry after each interval
Dry	n.a.	Compressed air	10 to 60 s	1	Air pressure (50 psi)
Wait before post curing	n.a.		60 min	1	Room temperature

POST CURING

LOCTITE 3D 3843 WH 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/ side	Additional Settings (Shelf, Output Energy)
EnvisionTEC UVCA 3000	385 nm	3 mW/cm2	60 min	-
Dymax 5000 EC Flood	Mercury Arc Bulb (broad spectrum)	150 -175 mW/cm^2 at 380 nm	8 min	Shelf K

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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 3843 WH 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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PROPERTIES

Mechanical Properties	Measure	Method	Green	Post Processed
Young's Modulus	MPa	ASTM D638	1,562 ± 36 [6]	1,752 ± 42 [1]
Tensile Stress at Yield	MPa	ASTM D638	43.8 ± 0.7 [6]	45.0 ± 1.5 [1]
Elongation at Yield	%	ASTM D638	4.4 ± 0.2 [6]	4.2 ± 0.1 [1]
Tensile Stress at Break	MPa	ASTM D638	38.0 ± 1.7 [6]	44.0 ± 2.7 [1]
Elongation at Break	%	ASTM D638	58.0 ± 24 [6]	41.0 ± 6.7 [1]
Flexural Modulus	MPa	ASTM D790	-	1,878 ± 81 [2]
Flexural Stress at Break	MPa	ASTM D790	-	-
Flexural Strain at Break	%	ASTM D790	-	>5 [2]
IZOD Impact (Notched)	J/m	ASTM D256	-	65.0 ± 2.9 [3]
Shore Hardness (3s)	D	ASTM D2240	-	63 [8]
Other Properties				
HDT at 0.455 MPa	°C	ASTM D648	-	66 [9]
HDT at 1.82 MPa	°C	ASTM D648	-	51 [9]
Water Absorption (24hr)	%	ASTM D570	-	2.13 [7]
Solid Density	g/cm³	ASTM D1475	1.17 [4]	1.18 [4]
CTE (10°C to 60°C)	µm/(m·K)	ASTM E831	-	121.3 [12]
Tg	°C	ASTM E1640	-	113.5[13]

Liquid Properties	Measure	Method	Value
Viscosity at 25°C (77°F)	cP	ASTM D7867	740 – 880 [5]
Liquid Density	g/cm³	ASTM D1475	1.07 [4]

Test parameters:
All specimen are printed unless otherwise noted. All specimen were conditioned in ambient lab conditions at 19-23C / 40-60% RH for at least 24 hours." ASTM Methods: D638 Type IV, 5mm/min, D790, 2mm/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)

Internal Data Sources:
[1]FOR17386, [2]FOR17382, [3]FOR17385, [4]FOR17383, [5] GEN792141, [6]FOR17201, [7]FOR17380, [8]FOR19616, [9]FOR515949, [10]FOR20009, [11]FOR20010, [12]FOR165438, [13]FOR213542

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CLEAR COLOR PROPERTIES

In order to assess clear properties, color variation is measured as Delta-E (dE) to define parts transmittance.

dE measures changes from L*a*b*C*h. The table below shows the color variation for two different workflows: Method: ASTM E308, Total Transmission

Part State	L*	a*	b*	C*	h	dE
Green / no post-processing [10]	93.11	-1.06	2.28	2.52	114.9	-
Dymax 5000EC 5 min/side [10]	93.20	-0.46	1.14	1.22	111.89	1.29
Loctite CL36 60 min/side [11]	92.89	-0.36	1.28	1.33	105.85	1.24

The table below shows color variation after ageing for 650 hours

A dE of 1.0 - 2.0 change is the smallest color difference, in average, that the human eye can perceive

QUV exterior weathering conditions (ASTM G-154—Cycle 1): Clear color

Method: ASTM G-154—Cycle 1 & ASTM E308, Total Transmission

QUV Exposure Time (Hrs)	L*	a*	b*	C*	h	dE
0	93.82	-0.49	1.35	1.44	109.91	-
325	93.10	-0.61	1.68	1.79	109.96	0.80
650	93.40	-0.86	2.47	2.61	109.22	1.25

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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 3843 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: 3 mW/cm² to 7 mW/cm²

Settings: 385nm at 5 mW/cm²	Measure	Method	Value
Layer Thickness (µm):	µm	Internal	100
Burn-in Region (s)	s	Internal	45
Transition Region (s):	s	Internal	6
Model Region (s):	s	Internal	5

Settings: 385 nm at 5 mW/cm²	Measure	Method	Value
E_C	mJ/cm²	Internal	12.9 [1]
D_P	mm	Internal	0.31 [1]

Settings: 385 nm at 5 mW/cm²	Measure	Method	Exposure time
D_C =50um	s	Internal	3.0*
D_C =100um	s	Internal	3.6*

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

Internal Data Sources:
[1] FOR19220

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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 3843 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	IPA	Ultrasonic	2 min	1-2	Dry after each interval
Dry	n.a.	Compressed air	10 - 60 s	1	Air pressure (50psi)
Wait before post curing	n.a.	Ambient condition	60 min	1	Room temperature

POST CURING

LOCTITE 3D 3843 CL 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 CL36	405nm LED	80 mW/cm² at 405 nm	20 min	100% top & side
Rapidshape RS Cure XL	Multiple LEDs	150%	5 min	Third shelf from bottom Vacuum: 50 mbar

STORAGE

Store LOCTITE 3D 3843 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.

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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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