USA
Local Loctite® Brand Adhesives and Sealants Specialist
1.800.323.5100

Nearest Authorized Loctite® Brand Distributor
Arrange an in-plant seminar
Technical Product Assistance
1.800.697.4430

To place an order
1.800.243.4874

Henkel Corporation
1001 Trout Brook Crossing
Rocky Hill, Connecticut 06067
800.323.6035
Fax: 860.571.5465

Canada
Local Loctite® Brand Adhesives and Sealants Specialist
Nearest Authorized Loctite® Brand Distributor
Arrange an in-plant seminar
Technical Product Assistance
To place an order
1.866.263.5043 (within Canada)

Henkel Canada Corporation
2225 Meadowridge Blvd.
Mississauga, Ontario L5N 7R2
604.833.5433 (within Canada)
905.814.0311
Fax: 905.814.5891

Mexico
Local Loctite® Brand Adhesives and Sealants Specialist
Nearest Authorized Loctite® Brand Distributor
Arrange an in-plant seminar
Technical Product Assistance
To place an order
01.800.730.1812 (within Mexico)

Henkel Mexico, S.A. de C.V.
Calzada de la Viga s/n, Fracc. Los Laureles
Los Tuyutlac, C.P. 52090
Escaleras de Morelia, Edif. de Mexico,
011-525-936-1235
Fax: 01525.7813404

Latin America
Brazil
Local Loctite® Brand Adhesives and Sealants Specialist
Nearest Authorized Loctite® Brand Distributor
Arrange an in-plant seminar
Technical Product Assistance
To place an order
55.11.643.7300
800.122324 (within Brazil)

Henkel Ltda.
Av. Prof. Vernon Knibbs, 91
08550-111 Irajá
São Paulo, Brazil
Tel: 55.11.443.7300
Fax: 55.11.443.7100

Henkel Argentina S.A.
Córdoba 2228 - Sarandi
(1670) Avellanada, Buenos Aires, Argentina
Tel: 54.11.4901.0970
Fax: 54.11.4204.0293

Henkel Chile S.A.
Agrupación No. 2205, Primer Piso, Of. 8
Las Condes, Santiago, Chile
Tel: 562.233.3600
Fax: 552.234.1448

Henkel Colombia S.A.
Calle 17 No. 68-73, Edificio Henkel
Bogotá, Colombia
Tel: 571.423.1330
Fax: 571.423.1331

Henkel Venezuela S.A.
Guarnera Oficina
Urbanización Industrial Privada
Calle 2 Edificio Henkel
Guárico - Carabobo, Venezuela
Tel: 58.245.894.7133
Fax: 58.245.894.7376

Henkel Venezuela S.A.
Guarnera Oficina
Urbanización Matavaría
Centro Comercial del Este
1º Av. de Maracay 3,
Parque F-3, Edificio Corinta
Guaranda - Estado Miranda, Venezuela
Tel: 58.212.283.3401
Fax: 58.212.283.3324

For technical information and/or product availability, call 1-800-LOCTITE or on the web
Visit www.loctite.com

Henkel Corporation
Engineering, Assembly & Maintenance Technologies
1001 Trout Brook Crossing • Rocky Hill, CT 06067 U.S.A. • 800-562-8483 • www.henkel.us • www.loctite.com

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Built on Sound Technology

To access our on-line technical resources, visit www.loctite.com
THE RESINAID® PROCESS

Henkel Corporation offers the most complete line of products for use in the manufacture, assembly, and repair of hearing aids – from UV/Visible Light Cure Molding Compounds and UV/Visible Light Cure Equipment to Instant Adhesives, UV Silicones, Light Cure Acrylic and Light Cure Cyanoacrylate Adhesives. All Loctite® products are formulated with the highest quality raw materials and are fully supported by our technical sales and engineering staff. Our process offers:

- Manufacturing flexibility resulting in increased comfort for the end user
- Custom matched colors
- A total system solution — equipment, molding compounds, secondary bonding aids, process know-how
- Experience — more than a decade of industry partnerships and development

We support our customers with a service program that is unmatched in the industry. It’s what sets Henkel apart from the rest.

Henkel is committed to innovation through imagination and teamwork. Our commitment to the improvement of hearing aid fabrication continues with the latest advancements in molding compounds, assembly adhesives, and new processing systems and methods.
Loctite® brand Resinaid® Molding Compounds have transformed the traditional process of molding hearing aid shells. By integrating the one-part Loctite® Resinaid® Molding Compounds and the Loctite® Resinaid® Dispensing and Curing process, hearing aid manufacturers can easily:

- Speed up production cycles
- Achieve consistent shell-wall thickness
- Reduce overall size of hearing aids
- Reduce manufacturing costs

Henkel uses state-of-the-art color matching equipment to ensure that every batch of Loctite® brand Resinaid® Molding Compound produced meets strict color quality requirements. The color matching equipment is also used to develop custom molding compound colors that closely match even the most unique face plates.

Loctite® brand Resinaid® Molding Compounds are available in a variety of standard colors in both low and high viscosity formulations.
ADHESIVES

In addition to Loctite® Resinaid® Molding Compounds, the Resinaid® process also incorporates a full complement of secondary aids for various assembly applications.

<table>
<thead>
<tr>
<th>Adhesive Type</th>
<th>Application</th>
</tr>
</thead>
<tbody>
<tr>
<td>Cyanoacrylate Instant Adhesives</td>
<td>Bonding the face plate to the shell</td>
</tr>
<tr>
<td>Light Curing</td>
<td>Bonding volume control into face plate</td>
</tr>
<tr>
<td>Cyanoacrylate Adhesives</td>
<td>Bonding the face plate to the shell</td>
</tr>
<tr>
<td>Light Curing Acrylic Adhesives</td>
<td>Bonding volume control into face plate</td>
</tr>
<tr>
<td>Light Curing Silicone Adhesive/Sealant</td>
<td>Form vent channel for soft shells</td>
</tr>
<tr>
<td></td>
<td>Bonding the receiver tube to receiver</td>
</tr>
<tr>
<td></td>
<td>Bonding the receiver tube to shell</td>
</tr>
</tbody>
</table>

Henkel offers the most complete line of products for use in the manufacture, assembly and repair of hearing aids.

RESINAID® PROCESSING EQUIPMENT

Henkel offers a complete line of application and curing equipment specifically designed for the hearing aid manufacturer. From simple Pressure-time Dispense Systems to Molding Compound Retrieval Applicators and patented Shell Curing Systems, Loctite® Resinaid® processing equipment ensures a repeatable, consistent hearing aid manufacturing process—every time.

LOCTITE® RESINAID® CURING SYSTEM
WITH OPTIONAL RETRIEVAL SYSTEM
HENKEL CORPORATION
A SYSTEM SOLUTION

At Henkel, our goal is to become your productivity consultant. Whether you need a quick recommendation on the correct product to use, or a turn-key process, Henkel can provide the right solution. Our engineers have over a decade of experience developing solutions for hearing aid manufacturers. Consult with Henkel and gain access to:

- The best product, process and solution for your specific hearing aid manufacturing needs
- Products tested and in compliance with the Henkel ISO-10993 biocompatibility test program
- Highly trained and skilled specialists and technical service engineers to troubleshoot and solve problems
- In-plant product application training and support
- Global support — operating in over 75 countries

Henkel's ISO-10993 biocompatibility certificates of compliance are available online at www.loctite.com

Henkel Corporation…
your productivity consultant.
Built on **Sound Technology**
# LOCTITE® BRAND RESINAID® LOW VISCOSITY MOLDING COMPOUNDS

<table>
<thead>
<tr>
<th>Product</th>
<th>Color</th>
<th>Cure Type</th>
<th>Viscosity</th>
<th>Primary Usage</th>
<th>Typical Cure Time</th>
<th>Package Size</th>
<th>Item #</th>
</tr>
</thead>
<tbody>
<tr>
<td>3582™</td>
<td>Pink</td>
<td>Rigid</td>
<td>UV/V</td>
<td>Acrylated Urethane</td>
<td>ISO-10993</td>
<td>700 cP</td>
<td>ITE, ITC, CIC</td>
</tr>
<tr>
<td>3584™</td>
<td>Pink</td>
<td>Rigid</td>
<td>UV/V</td>
<td>Acrylated Urethane</td>
<td>ISO-10993</td>
<td>700 cP</td>
<td>ITE, ITC, CIC</td>
</tr>
<tr>
<td>3586™</td>
<td>Light Brown</td>
<td>Rigid</td>
<td>UV/V</td>
<td>Acrylated Urethane</td>
<td>ISO-10993</td>
<td>700 cP</td>
<td>ITE, ITC, CIC</td>
</tr>
<tr>
<td>3677™</td>
<td>Light Brown</td>
<td>Rigid</td>
<td>UV/V</td>
<td>Acrylated Urethane</td>
<td>ISO-10993</td>
<td>700 cP</td>
<td>ITE, ITC, CIC</td>
</tr>
<tr>
<td>3679™</td>
<td>Cocoa Brown</td>
<td>Rigid</td>
<td>UV/V</td>
<td>Acrylated Urethane</td>
<td>ISO-10993</td>
<td>700 cP</td>
<td>ITE, ITC, CIC</td>
</tr>
<tr>
<td>3680™</td>
<td>Cocoa Brown</td>
<td>Rigid</td>
<td>UV/V</td>
<td>Acrylated Urethane</td>
<td>ISO-10993</td>
<td>700 cP</td>
<td>ITE, ITC, CIC</td>
</tr>
<tr>
<td>3682™</td>
<td>Cocoa Brown</td>
<td>Rigid</td>
<td>UV/V</td>
<td>Acrylated Urethane</td>
<td>ISO-10993</td>
<td>700 cP</td>
<td>ITE, ITC, CIC</td>
</tr>
<tr>
<td>3684™</td>
<td>Cocoa Brown</td>
<td>Rigid</td>
<td>UV/V</td>
<td>Acrylated Urethane</td>
<td>ISO-10993</td>
<td>700 cP</td>
<td>ITE, ITC, CIC</td>
</tr>
<tr>
<td>3686™</td>
<td>Cocoa Brown</td>
<td>Rigid</td>
<td>UV/V</td>
<td>Acrylated Urethane</td>
<td>ISO-10993</td>
<td>700 cP</td>
<td>ITE, ITC, CIC</td>
</tr>
<tr>
<td>3688™</td>
<td>Cocoa Brown</td>
<td>Rigid</td>
<td>UV/V</td>
<td>Acrylated Urethane</td>
<td>ISO-10993</td>
<td>700 cP</td>
<td>ITE, ITC, CIC</td>
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<tr>
<td>3690™</td>
<td>Cocoa Brown</td>
<td>Rigid</td>
<td>UV/V</td>
<td>Acrylated Urethane</td>
<td>ISO-10993</td>
<td>700 cP</td>
<td>ITE, ITC, CIC</td>
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<tr>
<td>3692™</td>
<td>Cocoa Brown</td>
<td>Rigid</td>
<td>UV/V</td>
<td>Acrylated Urethane</td>
<td>ISO-10993</td>
<td>700 cP</td>
<td>ITE, ITC, CIC</td>
</tr>
</tbody>
</table>

# LOCTITE® BRAND RESINAID® HIGH VISCOSITY MOLDING COMPOUNDS

<table>
<thead>
<tr>
<th>Product</th>
<th>Color</th>
<th>Cure Type</th>
<th>Viscosity</th>
<th>Primary Usage</th>
<th>Typical Cure Time</th>
<th>Package Size</th>
<th>Item #</th>
</tr>
</thead>
<tbody>
<tr>
<td>3676™</td>
<td>Pink</td>
<td>Rigid</td>
<td>UV/V</td>
<td>Acrylated Urethane</td>
<td>ISO-10993</td>
<td>6500 cP</td>
<td>ITE, ITC, CIC</td>
</tr>
<tr>
<td>3678™</td>
<td>Beige</td>
<td>Rigid</td>
<td>UV/V</td>
<td>Acrylated Urethane</td>
<td>ISO-10993</td>
<td>6500 cP</td>
<td>ITE, ITC, CIC</td>
</tr>
<tr>
<td>3679™</td>
<td>Light Brown</td>
<td>Rigid</td>
<td>UV/V</td>
<td>Acrylated Urethane</td>
<td>ISO-10993</td>
<td>6500 cP</td>
<td>ITE, ITC, CIC</td>
</tr>
<tr>
<td>3680™</td>
<td>Cocoa Brown</td>
<td>Rigid</td>
<td>UV/V</td>
<td>Acrylated Urethane</td>
<td>ISO-10993</td>
<td>6500 cP</td>
<td>ITE, ITC, CIC</td>
</tr>
<tr>
<td>3682™</td>
<td>Cocoa Brown</td>
<td>Rigid</td>
<td>UV/V</td>
<td>Acrylated Urethane</td>
<td>ISO-10993</td>
<td>6500 cP</td>
<td>ITE, ITC, CIC</td>
</tr>
<tr>
<td>3684™</td>
<td>Cocoa Brown</td>
<td>Rigid</td>
<td>UV/V</td>
<td>Acrylated Urethane</td>
<td>ISO-10993</td>
<td>6500 cP</td>
<td>ITE, ITC, CIC</td>
</tr>
<tr>
<td>3686™</td>
<td>Cocoa Brown</td>
<td>Rigid</td>
<td>UV/V</td>
<td>Acrylated Urethane</td>
<td>ISO-10993</td>
<td>6500 cP</td>
<td>ITE, ITC, CIC</td>
</tr>
<tr>
<td>3688™</td>
<td>Cocoa Brown</td>
<td>Rigid</td>
<td>UV/V</td>
<td>Acrylated Urethane</td>
<td>ISO-10993</td>
<td>6500 cP</td>
<td>ITE, ITC, CIC</td>
</tr>
<tr>
<td>3690™</td>
<td>Cocoa Brown</td>
<td>Rigid</td>
<td>UV/V</td>
<td>Acrylated Urethane</td>
<td>ISO-10993</td>
<td>6500 cP</td>
<td>ITE, ITC, CIC</td>
</tr>
<tr>
<td>3692™</td>
<td>Cocoa Brown</td>
<td>Rigid</td>
<td>UV/V</td>
<td>Acrylated Urethane</td>
<td>ISO-10993</td>
<td>6500 cP</td>
<td>ITE, ITC, CIC</td>
</tr>
<tr>
<td>3694™</td>
<td>Cocoa Brown</td>
<td>Rigid</td>
<td>UV/V</td>
<td>Acrylated Urethane</td>
<td>ISO-10993</td>
<td>6500 cP</td>
<td>ITE, ITC, CIC</td>
</tr>
<tr>
<td>3696™</td>
<td>Cocoa Brown</td>
<td>Rigid</td>
<td>UV/V</td>
<td>Acrylated Urethane</td>
<td>ISO-10993</td>
<td>6500 cP</td>
<td>ITE, ITC, CIC</td>
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<tr>
<td>3698™</td>
<td>Cocoa Brown</td>
<td>Rigid</td>
<td>UV/V</td>
<td>Acrylated Urethane</td>
<td>ISO-10993</td>
<td>6500 cP</td>
<td>ITE, ITC, CIC</td>
</tr>
<tr>
<td>3700™</td>
<td>Blue</td>
<td>Rigid</td>
<td>UV/V</td>
<td>Acrylated Urethane</td>
<td>ISO-10993</td>
<td>6500 cP</td>
<td>ITE, ITC, CIC</td>
</tr>
<tr>
<td>3702™</td>
<td>Red</td>
<td>Rigid</td>
<td>UV/V</td>
<td>Acrylated Urethane</td>
<td>ISO-10993</td>
<td>6500 cP</td>
<td>ITE, ITC, CIC</td>
</tr>
<tr>
<td>3704™</td>
<td>Pink</td>
<td>Rigid</td>
<td>UV/V</td>
<td>Acrylated Urethane</td>
<td>ISO-10993</td>
<td>6500 cP</td>
<td>ITE, ITC, CIC</td>
</tr>
</tbody>
</table>

Cure Type: UV= Ultraviolet Light, V= Visible Light, M= Moisture Curing

Primary Device: ITE= In the Ear, ITC= In the Canal, CIC= Completely in the Canal, BTE= Behind the Ear
## LOCTITE® BRAND ADHESIVES

<table>
<thead>
<tr>
<th>#</th>
<th>PRODUCT</th>
<th>COLOR</th>
<th>CURE TYPE</th>
<th>RESIN TYPE</th>
<th>PRIMARY USAGE</th>
<th>TYPICAL CURE TIME</th>
<th>PACKAGE SIZE</th>
<th>ITEM #</th>
</tr>
</thead>
<tbody>
<tr>
<td>401™ Prism®</td>
<td>Clear</td>
<td>M</td>
<td>Cyanoacrylate</td>
<td>N/A**</td>
<td>Face plate assembly</td>
<td>15 sec</td>
<td>1/3 oz.</td>
<td>34646</td>
</tr>
<tr>
<td>406™ Prism®</td>
<td>Clear</td>
<td>M</td>
<td>Cyanoacrylate</td>
<td>N/A**</td>
<td>Face plate assembly</td>
<td>15 sec</td>
<td>1/3 oz.</td>
<td>31564</td>
</tr>
<tr>
<td>408™ Prism®</td>
<td>Clear</td>
<td>M</td>
<td>Cyanoacrylate</td>
<td>N/A**</td>
<td>Face plate assembly</td>
<td>50 sec</td>
<td>1/3 oz.</td>
<td>24389</td>
</tr>
<tr>
<td>7452™ Tak Pak®</td>
<td>–</td>
<td>–</td>
<td>Solvent w/ Basic Species</td>
<td>0.4 cP</td>
<td>Face plate to shell, Vent channel for soft shell</td>
<td>24 hours</td>
<td>N/A</td>
<td>19400</td>
</tr>
<tr>
<td>705™ Tak Pak B®</td>
<td>Clear</td>
<td>–</td>
<td>Solvent w/ Basic Species</td>
<td>3 cP</td>
<td>Accelerator for cyanoacrylate adhesives</td>
<td>N/A</td>
<td>1.75 fl. oz.</td>
<td>22440</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>#</th>
<th>Flashcure®</th>
<th>Clear</th>
<th>UV/V/M</th>
<th>Light Cure</th>
<th>Cyanoacrylate</th>
<th>ISO-10993</th>
<th>20 cP</th>
<th>ITE, ITC, CIC</th>
<th>Face plate assembly</th>
<th>1 oz.</th>
<th>37429</th>
</tr>
</thead>
<tbody>
<tr>
<td>4030™ Flashcure®</td>
<td>Clear</td>
<td>UV/V/M</td>
<td>Light Cure</td>
<td>Cyanoacrylate</td>
<td>ISO-10993</td>
<td>900 cP</td>
<td>ITE, ITC, CIC</td>
<td>Face plate assembly</td>
<td>1 oz.</td>
<td>37461</td>
<td></td>
</tr>
<tr>
<td>3200™</td>
<td>Clear/Pale straw</td>
<td>UV/V</td>
<td>Acrylated Urethane</td>
<td>ISO-10930</td>
<td>150 cP</td>
<td>ITE, ITC, CIC</td>
<td>Face plate to shell</td>
<td>25 ml</td>
<td>ISO-10933</td>
<td></td>
<td></td>
</tr>
<tr>
<td>5241™</td>
<td>Pink</td>
<td>UV/V</td>
<td>Acrylated Urethane</td>
<td>ISO-10930</td>
<td>450 cP</td>
<td>ITE, ITC, CIC</td>
<td>Face plate to shell, Vent channel for soft shell</td>
<td>25 ml</td>
<td>22372</td>
<td></td>
<td></td>
</tr>
<tr>
<td>3921™</td>
<td>Clear/Pale straw</td>
<td>UV/V</td>
<td>Acrylated Urethane</td>
<td>ISO-10930</td>
<td>150 cP</td>
<td>ITE, ITC, CIC</td>
<td>Face plate to shell</td>
<td>25 ml</td>
<td>36484</td>
<td></td>
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</tr>
<tr>
<td>3971™</td>
<td>Clear/Pale straw</td>
<td>UV/V</td>
<td>Acrylated Urethane</td>
<td>ISO-10930</td>
<td>300 cP</td>
<td>ITE, ITC, CIC</td>
<td>Face plate to shell</td>
<td>25 ml</td>
<td>36732</td>
<td></td>
<td></td>
</tr>
<tr>
<td>5083™ Novo-Sil®</td>
<td>Clear</td>
<td>UV/M</td>
<td>Modified Acetoxy Silicone</td>
<td>140 g/min</td>
<td>ITE, ITC, CIC, BTE</td>
<td>Receiver tube to receiver and to shell</td>
<td>300 ml</td>
<td>ISO-10933</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>5064™ Novo-Sil®</td>
<td>Yellow</td>
<td>UV/M</td>
<td>Modified Acetoxy Silicone</td>
<td>150 g/min</td>
<td>ITE, ITC, CIC, BTE</td>
<td>Receiver tube to receiver and to shell</td>
<td>300 ml</td>
<td>ISO-10933</td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**Cure Type:** UV= Ultraviolet Light, V= Visible Light, M= Moisture Curing

**Primary Device:** ITE= In the Ear, ITC= In the Canal, CIC= Completely in the Canal, BTE= Behind the Ear

**Not ISO-10993 tested but medical device adhesives are available in alternate package sizes.

Henkel's ISO-10993 biocompatibility certificates of compliance are available online at [www.loctite.com](http://www.loctite.com)

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Loctite® 3596™ is a light curing molding compound designed to produce tear-resistant, yet soft and deformable hearing aid shells, tips and earmolds. The nature of this inventive, soft body design yields greater comfort and durability, and provides better acoustic sealing performance.

**STEP 1**
The investment is filled with Loctite® 3596™ Resinaid® Soft Molding Compound. Care should be taken to minimize excess material on the top of the investment.

**STEP 2**
The filled investment is covered and then placed in the Loctite® Resinaid® Light Cure System for the initial cure.

**STEP 3**
When exposed to light, the outer portion of the shell is formed, creating a uniform wall thickness of ~0.030” throughout the shell. Typical exposure times range from 3-10 seconds depending on the desired wall thickness.

**STEP 4**
The remaining uncured molding compound material is removed from the investment using the Loctite® Retrieval System.

**STEP 5**
The uncovered investment is given its full and final cure (25-120 seconds) in the Loctite® Resinaid® Curing System. The use of the inert gas option should result in a shell with a tack-free surface. If the inert gas option is not used, the shell may require post processing in order to achieve the desired surface.

**STEP 6**
The receiver is assembled with a Loctite® brand Light/Moisture Curing Adhesive and then positioned in the shell. The receiver tube is then fed through the receiver hole and tacked to the shell with a Loctite® Light/Moisture Curing Adhesive.

**STEP 7**
Refer to the Rigid Molding Process beginning with Step 8 to complete the shell.
SOFT TIP PROCESS

STEP 1
The investment is partially filled with Loctite® 3596™ Resinaid® Soft Molding Compound to the desired tip size.

STEP 2
The investment is placed in the Loctite® Resinaid® Light Cure System for 3 to 6 seconds for initial curing of the tip. Additional exposure may result in poor adhesion of the tip to the rigid portion of the shell and/or may cause the tip to become increasingly rigid.

STEP 3
The remainder of the investment is filled with Loctite® Resinaid® Low Viscosity Molding Compound of the desired color.

STEP 4
Refer to the Rigid Molding Process beginning with Step 2 to complete the shell.

SOLID SOFT EARMOLD FOR BTEs

STEP 1
The investment is filled with Loctite® 3596™ Resinaid® Soft Molding Compound.

STEP 2
The investment is placed in the Loctite® Resinaid® Light Cure System for curing. Cure time is dependent on the earmold size.

STEP 3
The cured solid earmold is removed from the investment.

STEP 4
The solid earmold is bored out in order to insert the necessary electronic components for the BTE hearing aid.

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Loctite® brand Resinaid® High Viscosity Molding Compounds are the choice for the repair of cracked or damaged hearing aid shells. Repairs can be accomplished in seconds utilizing the Light Cure Molding Compounds and Equipment, ensuring that the hearing aid is back in the hands of the user in the shortest time possible.

**STEP 1**
A cracked shell.

**STEP 2**
The shell is lightly abraded in the cracked area to remove potential surface contamination and prepare the surface for the repair process.

**STEP 3**
A coating of the appropriate Loctite® Resinaid® High Viscosity Molding Compound is applied to the abraded area.

**STEP 4**
The Molding Compound is cured using a Loctite® brand High Intensity Light Source.

**STEP 5**
The patched area is buffed to blend in with the hearing aid shell.

**STEP 6**
The repair is complete and the shell is ready for return.
Loctite® brand Resinaid® products are easy to integrate into your existing process. Once a shell investment has been made, the shell molding process utilizing the Loctite® brand Resinaid® Molding Compounds and Loctite® brand Adhesives begins.

**STEP 1**
The investment is filled with Loctite® Resinaid® Low Viscosity Molding Compound.

**STEP 2**
The filled investment is covered and then placed in the Loctite® Resinaid® Light Cure System for the initial cure.

**STEP 3**
When exposed to light, the outer portion of the shell is formed, creating a uniform wall thickness of 0.030” throughout the shell. Typical exposure times range from 5-20 seconds, depending on the color of the molding compound.

**STEP 4**
The remaining uncured molding compound material is removed from the investment using the Loctite® Retrieval System.

**STEP 5**
The uncovered investment is given its full and final cure in the Loctite® Resinaid® Curing System. The use of the inert gas option will result in a shell with a tack-free surface and high gloss, thus minimizing subsequent cleaning steps. If the inert gas option is not used, the shell may require cleaning and buffing in order to achieve a high gloss finish.

**STEP 6**
A high viscosity Loctite® Resinaid® Molding Compound is used to form the vent channel and cured by a Loctite® brand High Intensity Light Source.

**STEP 7**
The receiver is assembled with a Loctite® brand Light/Moisture Curing Adhesive and then positioned in the shell. The receiver tube is then fed through the receiver hole and tacked to the shell with the Light/Moisture Curing Adhesive.

**STEP 8**
Once the electronics are inserted into the shell, the face plate is positioned onto the open end of the shell and bonded with Loctite® brand Instant Adhesive or Light Cure Adhesive.

**STEP 9**
A Loctite® brand High Intensity Light Source is used to cure Loctite® brand Light Cure Adhesives.

**STEP 10**
Once the receiver tube is cut, the face plate is then trimmed to the contours of the shell, and the process is complete.
Features

- Timed inert gas blanketing option provides for tack-free shell surfaces with minimal gas usage.
- Air-cooled surface of curing chamber prevents overheating of devices.
- Multiple timers allow operators to prepare hearing aid shells using a variety of Loctite® brand Resinaid® Molding Compounds without resetting individual timers.
- Light source is specifically designed for use with Loctite® brand Resinaid® Molding Compounds.
- Loctite® Resinaid® Curing System curing area of 8" x 8" provides sufficient space for irradiating multiple devices simultaneously.

Technical Specifications

<table>
<thead>
<tr>
<th>Size</th>
<th>18”w x 43”h x 27”d</th>
</tr>
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<tbody>
<tr>
<td>Weight</td>
<td>100 lbs</td>
</tr>
<tr>
<td>Power Input</td>
<td>110 VAC, 60 Hz, 8 amps</td>
</tr>
<tr>
<td>Power Supply</td>
<td>400 watt</td>
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<tr>
<td>Gas Supply</td>
<td>60 psi minimum, 100 psi maximum @ 150 SCFH</td>
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<tr>
<td>Connection</td>
<td>Regulator 1/8” NPT female</td>
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Part Number Description

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Description</th>
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<tbody>
<tr>
<td>98422</td>
<td>Loctite® Resinaid® Curing System</td>
</tr>
<tr>
<td>98421</td>
<td>Loctite® Resinaid® Curing System with Retrieval System</td>
</tr>
<tr>
<td>98423</td>
<td>Loctite® Retrieval System</td>
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</table>
The \textit{Loctite® Zeta®} 7735 Wand System, with output up to 7 W/cm², is designed for the curing of \textit{Loctite®} brand Light Cure Molding Compounds and Adhesives. The unit’s state-of-the-art lamp and reflector design deliver unequalled spectral and optical performance in the 50 watt metal halide arc lamp category. The \textit{Loctite® Zeta®} 7735 system can be operated manually or in the timed mode. The light guides are sold separately from the base unit for selection based on individual requirements.

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<tbody>
<tr>
<td>98317</td>
<td>\textit{Loctite® Zeta®} 7735 Wand System</td>
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<tr>
<td>983677</td>
<td>\textit{Loctite®} Single Light Guide, 1m long x 5mm diameter</td>
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<tr>
<td>983684</td>
<td>\textit{Loctite®} Dual Light Guide, 1m long x 3mm diameter</td>
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<tr>
<td>985045</td>
<td>\textit{Loctite®} Dual Wand Adapter Kit</td>
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<tr>
<td>983800</td>
<td>\textit{Loctite®} Single Light Guide, 1.5m long x 5mm diameter</td>
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</tbody>
</table>

The \textit{Loctite® Zeta®} 7401 Light Cure Chamber is designed for use with \textit{Loctite®} brand Light Curing Molding Compounds, Adhesives, and Coatings. This medium intensity light source offers an 8” x 8” curing area and can accommodate components that are 4” or less in height. The convenient pull out drawer ensures that operator’s hands have no direct exposure to UV/visible light energy.

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<tr>
<td>98039</td>
<td>\textit{Loctite® Zeta®} 7401 UV Chamber</td>
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</tbody>
</table>

The \textit{Loctite® Bond-A-Matic® Dispensers} are pneumatically-operated systems with precision control for dispensing \textit{Loctite®} brand Molding Compounds and Adhesives. The dispensers can be used with 8 ounce and 1 quart bottles of Molding Compounds, and one pound, one liter and two kilogram bottles of Adhesives. These units are available in two different pressure ranges: 0-100 psi for the dispensing of high viscosity fluids (>3000 cP); 0-15 psi for the dispensing of low to medium viscosity fluids (<3000 cP). The Bond-A-Matic™ dispensers are available with a low level sensing option.

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<tr>
<td>982720/982726</td>
<td>\textit{Loctite® Bond-A-Matic® Dispenser} 0-15 psi</td>
</tr>
<tr>
<td>982723/982727</td>
<td>\textit{Loctite® Bond-A-Matic® Dispenser} 0-100 psi</td>
</tr>
</tbody>
</table>

The \textit{Loctite® Hand Held Applicator} is suitable for dispensing \textit{Loctite®} brand Molding Compounds and Adhesives from the \textit{Loctite®} brand Bond-A-Matic Dispense Systems. This ergonomically designed applicator provides hand comfort and application control to eliminate hand fatigue and improve dispensing accuracy. Actuating the trigger lever manually operates the 97111 Hand Held Applicator.

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<tr>
<td>97111</td>
<td>\textit{Loctite® Hand Held Applicator}</td>
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