



UV40 GEL Dual Cure Acrylated Urethane Coating Technical Data Sheet

System Description

HumiSeal UV40 GEL is an one-part anti-sagging, 100% solids dual cure acrylated polyurethane conformal coating possessing excellent chemical resistance, surface hardness, flexibility and moisture resistance. The material is tack free after exposure to UV light and the secondary moisture cure mechanism will fully cure any unexposed areas of the coating within 2-3 days at ambient conditions. The secondary cure can be accelerated by baking at 60-80 °C with a small pan of water placed in the oven to increase humidity. The coating fluoresces under UV light to allow coating inspection and can be applied by all selective coating equipment. HumiSeal UV40 GEL is in full compliance with the RoHS Directive (Directive 2002/95/EC).

Properties of Liquid HumiSeal UV40 GEL

Density	1.06 g/cm ³
Solids Content	98%
Flashpoint, °C	84
Recommended Coating Thickness	1-5 mils
NB: Thicker amounts are more prone to cracking when cured.	
Lamp type for UV curing	Fusion H bulb, Mercury doped, 120W/cm
Secondary Cure (for shadow areas) (*Place open pan of water in oven during curing)	2-3 days at ambient or 2-4 hrs at 60-80 °C*
Recommended Removal Method	Thermal burn-through and mechanical
Shelf Life at Room Temperature	6 months from date of shipment

Properties of Cured HumiSeal UV40 GEL

Thermal Properties

Continuous Use Operating Range	-65 °C to +150 °C
Thermal Shock, per MIL-I-46058C	-65 °C to +125 °C
Solder Through for Rework?	Yes

Physical Properties

Clarity	Transparent
Flexibility, per MIL-I-46058C	Excellent
Adhesion, per ASTM, Meth. D2197	Excellent
Flammability, per ASTM, Meth. D635	Self-Extinguishing
Flammability, per UL-94	94V-0
Weather Resistance	Very Good

Electrical Properties

Dielectric Withstand Voltage, volts per MIL-I-46058C	>7,500
Dielectric Constant, at 1MHz and 25°C, per ASTM-D150-65T	2.5
Dissipation Factor, at 1MHz and 25°C, per ASTM-D150-65T	0.01
Insulation Resistance, ohms, per MIL-I-46058C	8.0 x 10 ¹⁴ (800T)
Moisture Resistance, ohms, per MIL-I-46058C	6.0 x 10 ¹⁰ (47G)

Chemical Properties

Main Constituents
Fungus Resistance, per ASTM-G21
Resistance to Chemicals
Recommended Stripper

Urethane, Acrylic
Pass
Excellent
Stripper 1072 (or solder through for rework)

Values are not intended for use in preparation of specifications.

APPLICATION

Cleanliness of the substrate is of extreme importance for the successful application of a conformal coating. Surfaces must be free of moisture, dirt, wax, grease and all other contaminants. Contamination under the coating will cause problems that may lead to assembly failures.

Dipping

HumiSeal UV40 GEL is not suitable for dipping.

UV40 GEL - Spraying

HumiSeal UV40 GEL is not applicable for spraying

Brushing - UV40 GEL

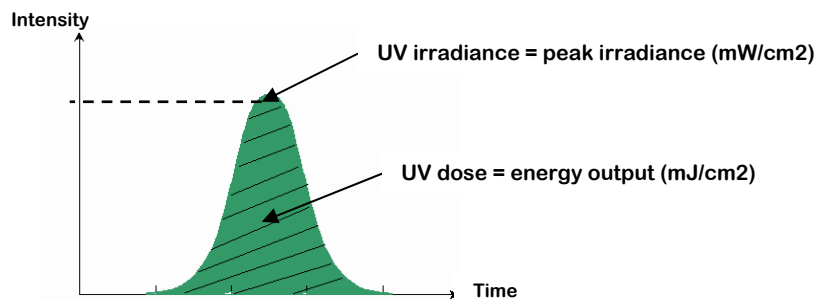
HumiSeal UV40 GEL may be applied by brush. The actual uniformity of the finished coating will depend on component density and operator technique. Brushed may be cleaned promptly using solvent.

Jetting - UV40 GEL

HumiSeal UV40 GEL can be applied with automated jetting system or screen printing system.

Curing- UV40 GEL

Dose and irradiance are key concepts when curing UV coatings. Those concepts are different but closely related together and defined as below:



Lamp intensity versus time

- UV irradiance (mW/cm²): is the power or the intensity of the UV energy, which is delivered to a surface per unit area. It is a characteristic of the lamp and geometry of the reflector and does not vary with the speed. The intense focused peak directed under the lamp is referred to as "peak irradiance".
- UV dose (mJ/cm²): is the total energy delivered to a surface per unit area, passes under a UV light source. It is inversely proportional to the speed under the light source and proportional to the number of exposures or rows of lamps.

Energy is the product of power and time. A low irradiance for a long time does not give the same cure results as a higher irradiance for a proportionally shorter time, due to the differing kinetics of the curing reaction that take place under the 2 conditions.

Process control of a UV curing material

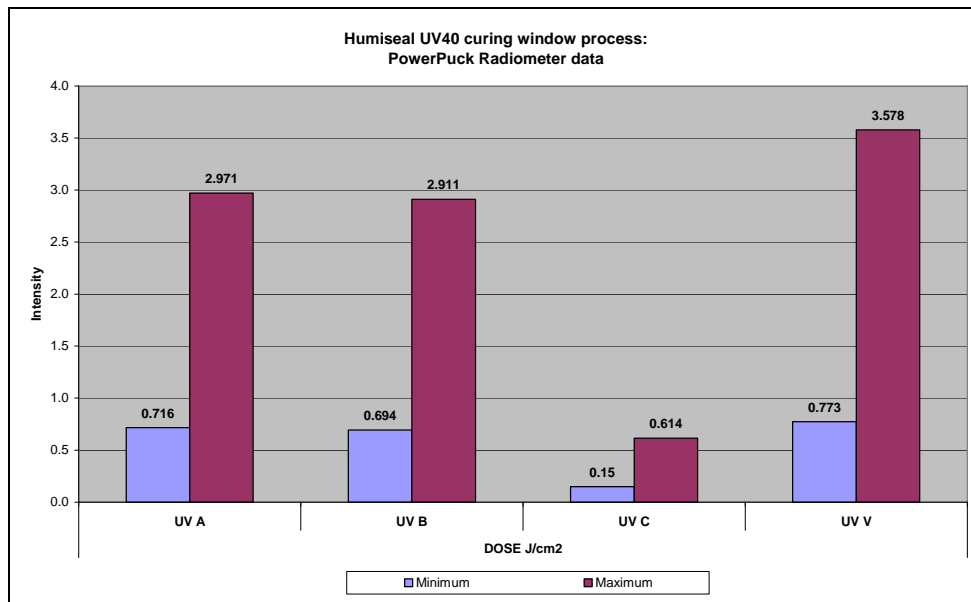
Controlling curing window process is easily quantifiable with a sensing system called a radiometer. This instrument measures the total UV dose and irradiance on 4 different channels (UV-A, UV-B, UV-C and UV-V) simultaneously, thus ensuring a repeatable and controlled curing process, while monitoring the output of the UV lamps. The procedure is as simple and fast as passing the instrument through the tunnel and removing it at the end while the radiometer is logging UV dose and energy.



Power Puck radiometer

UV40 will exhibit different responses to spectral distribution, dose and irradiance. Curing a coating without sufficient energy results in a sticky film; too much energy results in residual stress, cracking, excess shrinkage. Use of an inappropriate wavelength will give a softer film than when cure with the appropriate bulb type.

In the graph below is the window curing process (maximum and minimum UV dose) under which UV40 cures at a tack free stage and provide sufficient hardness to enable the boards to be handled. Conveyor speed can vary between 1m/min to 3m/min depending on height of lamp, power output of the lamp, shape of the reflector, height of components, etc....



Curing Window Process of UV40

Trying to increase production throughput by increasing the intensity of light while decreasing the duration of exposure may not always be successful since it must be ensured that sufficient UV dose has been applied to the coating. It is extremely important to cure a UV coating within the adequate recommended process window in order to obtain maximum reliability and performance of the coating. It is therefore essential to choose the correct UV curing equipment that will enable you to work adequately within this window process.

Clean Up

To flush equipment and clean uncured UV40 GEL, organic solvents such as methyl ethyl ketone, t-butylacetate, glycol ether acetates etc. can be used.

Rework

HumiSeal UV40 GEL is a highly crosslinked UV cured coating. The cured film has a high degree of environmental and chemical resistance and will be more difficult to remove than traditional conformal coatings. The following options are available for rework of UV40 GEL.

Thermal Removal: The most effective method for removal of UV40 GEL for selective rework applications is to burn through the coating directly using a hot soldering iron. The high temperature of the soldering iron (typically 300-400 °C) softens and decomposes the coating and allows it to be easily displaced from the substrate. This allows access to the underlying solder connections for component removal and replacement. A hot air desoldering tool may also be used also. Apply heat to the desired area and the coating can be removed mechanically after it softens. Care should be taken to avoid damage to any heat sensitive components.

Mechanical Removal: This method involves the use of "micro-blasting" equipment that safely removes the cured coating by using a pressurized abrasive. After coating removal, the abrasive can be removed from the assembly surface without damage to the components. HumiSeal UV40 GEL has been successfully removed using the Micro-Blaster System from Comco Inc. (800-796-6626, www.comcoinc.com), but there are several companies that supply similar systems.

Chemical Removal: If the UV40 GEL coating has been UV cured only and not allowed to undergo any further moisture curing, HumiSeal Stripper 1072 could be used to remove the UV-cured film. Extended dwell times and periodic mechanical agitation could be required. Warming the 1072 solution can increase its effectiveness.

Storage

Refer to MSDS to insure proper storage conditions. HumiSeal UV40 GEL should be stored at -18C +36C, away from excessive heat, in tightly closed opaque containers. Prior to use allow the product to equilibrate for 24 hours at room temperature. Since UV40 GEL is photosensitive, the product should not be exposed to direct sunlight or full spectrum fluorescent lighting. UV40 GEL is a moisture curing material and care should be taken to protect process vessels and partial containers from moisture. Partial, opened containers should be purged with a dry, inert gas such as dry air, nitrogen or argon before closure, otherwise premature polymerization by atmospheric moisture will occur.

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