

LFCC Lead Free Conformal Coating

LFCC has been specifically designed for the protection of electronic circuitry processed with lead-free soldering products. It offers excellent adhesion properties to a variety of substrates including no-clean, lead-free flux residues.

- Ideal for use with no-clean, lead-free flux residues that can cause issues with coating adhesion
- High degree of flexibility; suitable for applications requiring a wide and variable operating temperature
- Fast coating application; ready to use, can be cured under ambient conditions or accelerated using heat
- Can be reworked using specialist removal product, Electrolube CCRG

Approvals

RoHS Compliant (2015/863/EU):	Yes
DEF-STAN 59/47 (Issue 4):	Meets approval
MIL Approval (MIL-1-46058C):	Meets approval
IPC-CC-830:	Meets approval

Liquid Properties

Appearance:	Clear Pale Straw
Density @ 20°C (g/ml):	0.78 (Aerosol)
VOC Content:	83% (Aerosol)
Flash Point:	<23°C (Aerosol)
Solids content:	27% (Aerosol)
Touch Dry:	50 - 55 minutes
Recommended Drying Schedule:	24 hours @ 20°C Or 1 hour @ 20°C followed by 2 hours at 90°C
Coverage @ 25 µm:	4.32m ² (400ml Aerosol)

Cured Film Coating

Colour:	Colourless
Operating Temperature Range:	-50°C to +150°C
Flammability:	Meets UL94 V-1
Thermal Cycling:	Meets MIL 1-46058C Approval
Coefficient of Expansion:	85ppm
Dielectric Strength:	80 kV/mm
Dielectric Constant:	3.5 @ 1 MHz
Surface Insulation Resistance:	1 x 10 ¹⁵ Ω
Dissipation Factor (@1 MHz, 25°C):	0.034
Moisture Resistance (MIL-1-46058C):	Meets approval

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All information is given in good faith but without warranty. Properties are given as a guide only and should not be taken as a specification.

Electrolube cannot be held responsible for the performance of its products within any application determined by the customer, who must satisfy themselves as to the suitability of the product.

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BS EN ISO 9001:2008
Certificate No. FM 32082

<u>Description</u>	<u>Packaging</u>	<u>Order Code</u>	<u>Shelf Life</u>
<u>LFCC Conformal Coating</u>	400ml Aerosol	LFCC400ML	36 Months
<u>Conformal Coating Removal Gel</u>	1 Litre Bulk	CCRG01L	36 Months

Directions for Use

The thickness of the coating depends on the method of application (typically 25-75 microns). Temperatures of less than 16°C or relative humidity in excess of 75% are unsuitable for the application of LFCC. As is the case for all solvent based conformal coatings, adequate extraction should be used (refer to MSDS for further information).

Substrates should be thoroughly cleaned before coating. This is required to ensure that satisfactory adhesion to the substrate is achieved. Also, all flux residues must be removed as they may become corrosive if left on the PCB. Electrolube manufacture a range of cleaning products using both hydrocarbon solvent and aqueous technology. Electrolube cleaning products produce results within Military specification.

Spraying - Aerosol

When applying LFCC in aerosol form care must be taken to ensure the can is not shaken before use. Shaking the can will introduce excessive air bubbles and will give a poor coating finish.

The can should be held at 45° and 200mm from the substrate to be coated. The valve should then be depressed when the can is pointing slightly off target and moved at about 100mm/s across the target. To ensure the best coating results are achieved try to use a smooth sweeping motion with small overlap for successive rows.

To ensure penetration of the coating beneath the components and in confined spaces, spray the assembly from all directions to give an even coating. After spraying, the boards should be placed in an air-circulating drying cabinet and left to dry.

Inspection

LFCC contains a UV trace, which allows inspection of the PCB after coating to ensure complete and even coverage. The stronger the reflected UV light, the thicker the coating layer. UV light in the region of 375nm should be used for inspection.

Revision 3: November 2018