

UVCL-HV High Viscosity UV Cure Conformal Coating

UVCL-HV single-part conformal coating, which cures rapidly on exposure to the correct dose of UV light. UVCL-HV has a highly effective, moisture initiated secondary cure mechanism to ensure curing in shadowed areas. It has been specifically designed to offer the highest level of protection for electronic circuitry at high production throughputs. UVCL-HV has been designed for application via selective spray equipment and demonstrates ease of application in an automated process, along with excellent storage stability and shelf-life.

- Dual cure system; secondary moisture cure for full cure, even in shadow areas
- Eliminates the use of solvents; VOC-free and non-flammable coating
- High viscosity coating for improved coverage; reduces effects of capillary flow
- Ultimate protection in harsh environments, including high humidity, corrosive and chemical atmospheres

Approvals	RoHS Compliant (2015/863/EU): IPC-CC-830: IEC-61086:	Yes Meets Requirements Meets Requirements
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Liquid Properties	Appearance: Base material: Density @ 20°C (g/ml): Solids Content: VOC content: Flash Point: Viscosity @ 20°C (mPa s):	Pale Coloured Liquid Urethane acrylate 1.1 100% 0% >90°C 1200
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Dry Film Coating	Colour: Operating Temperature Range: Surface Insulation Resistance: Dielectric Strength: Dielectric Constant @ 1MHz: Dissipation Factor @ 1MHz, 25°C: Flammability: Moisture Resistance (IPC-CC-830): Thermal Shock: IPC-CC-830 (-65°C to +125°C): Additional (-40°C to +125°C):	Colourless -65°C to +135°C $1 \times 10^{15} \Omega$ 27 kV/mm 2.5 0.01 Self-extinguishing $7 \times 10^{12} \Omega$ Pass 100 Cycles Pass >1000 Cycles
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<u>Packaging*</u>	<u>Description</u>	<u>Order Code</u>	<u>Shelf Life</u>
UVCL-HV UV Cure Coating	5 Litre Bulk	EUVCL-HV05L	12 Months
Industrial Machine Cleaner	5 Litre Bulk	IMC05L	36 months

*Other packaging sizes may be available upon request.

Directions for Use

Substrates should be thoroughly cleaned before coating to ensure satisfactory adhesion to the substrate. All flux residues should be removed as they may become corrosive or interfere with adhesion if left on the PCB. Electrolube manufacture a range of cleaning products using both hydrocarbon solvent and aqueous technology. UVCL-HV has been specifically designed for automated processes using selective spray technology however other spraying techniques and touch-up application via brush may also be employed. The coating application must be done away from the UV light source to prevent premature curing.

Spraying – Bulk

UVCL-HV is supplied in a ready to use viscosity for selective spraying. Due to the secondary moisture cure it is advised that all storage tanks are kept sealed from moisture during use to allow a longer pot life. Nozzles and applicator heads should be immersed in machine cleaner when not in use.

Depending on the spray equipment and parameters used, UVCL-HV can be applied in a range of thicknesses; the exact thickness should be determined for each application however a maximum of 300 microns is advised. Heating jackets can be applied to the storage tanks to reduce the coating viscosity further and are advised to ensure a stable viscosity is achieved particularly in environments where the operating temperature is changeable. Please see below graph for further information.

Brushing

As it is a manual process with many variables, brush coating is only advised for touch-up applications. Brushes should be clean and dry prior to use and exposure to UV light minimised to avoid premature curing.

Curing

The speed of UV cure depends on UV intensity, wavelength, applied coating thickness and height of components. The material will be touch-dry and can be moved further in production once the coating has seen the correct dose of UV light. Coating in shadow areas that does not receive the full UV dose will cure by the secondary moisture cure mechanism. The time for full cure depends on the thickness of the coating, humidity and temperature.

It is essential that the correct UV exposure is determined for each board, prior to any production, and it is recommended that a radiometer is used to ensure the dose is consistent. UVCL-HV has been designed to achieve optimum cured film properties through a simple application process. As such, UVCL-HV utilises a combination of wavelengths, with the majority dose of UVA, the most common form of UV light. UVCL-HV has been designed to cure using standard 'H' or 'H+' type bulbs, running at 40% power with a conveyor speed of 1m/min. This provides UV irradiance and doses in the range:

	Irradiance (W/cm ²)			Dose (J/cm ²)		
	UVA	UVB	UVC	UVA	UVB	UVC
Min	0.6	0.6	0.15	1.5	1.5	0.5
Max	0.8	0.8	0.25	3.0	3.0	0.8

The UV doses above refer to parameters measured with an EIT UV Power Puck. Further information on the application and curing of UVCL-HV is available on request.

Inspection

UVCL-HV contains a fluorescent dye, which allows 'blacklight' inspection of the PCB after coating, to ensure complete and uniform coverage. The stronger the reflected UV light, the thicker the coating layer is. UV light in the region of 375nm should be used for inspection.

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