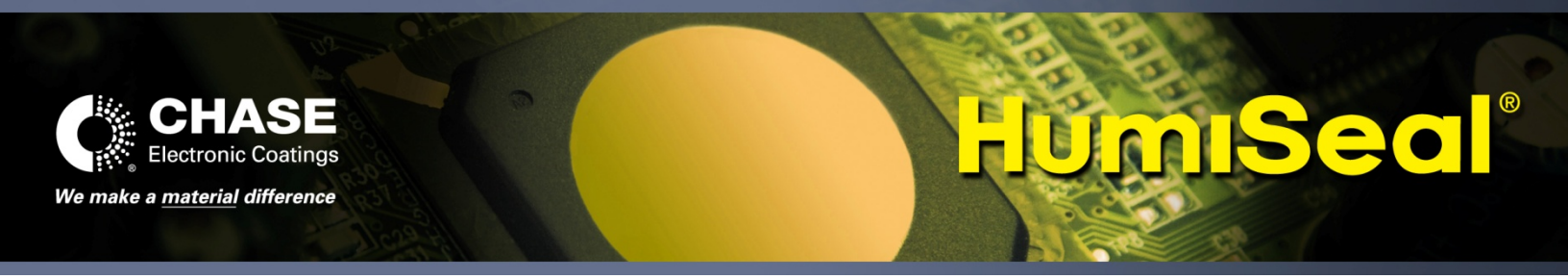

HumiSeal® 1A20R Urethane Conformal Coating Technical Data Sheet

HumiSeal® 1A20R is a single component, chemically resistant, fast curing polyurethane conformal coating. HumiSeal® 1A20R fluoresces under UV light for ease of inspection. HumiSeal® 1A20R coating is MIL-I-46058C qualified, IPC-CC-830 and RoHS Directive 2002/95/EC compliant.

Properties of HumiSeal® 1A20R

Density, per ASTM D1475	1.02 ± 0.02 g/cm³
Solids Content, % by weight per Fed-Std-141, Meth. 4044	50 ± 3 %
Viscosity, per Fed-Std-141, Meth. 4287	100 ± 30 centipoise
VOC	511 grams/litre
Recommended Coating Thickness	25 - 75 microns
Drying Time to Handle per Fed-Std-141, Meth. 4061	60 minutes
Recommended Curing Conditions	24 hrs @ RT or 3 hrs @ 76°C
Time Required to Reach Optimum Properties	7 days
Thinner, if needed (dipping, brushing, spraying)	HumiSeal® Thinner 521, 521EU
Recommended Stripper	HumiSeal® Stripper 1072
Shelf Life at Room Temperature, DOM	12 months
Thermal Shock, per MIL-I-46058C	-65°C to 125°C
Coefficient of Thermal Expansion - TMA	515 ppm/°C
Glass Transition Temperature - DSC	71°C
Modulus - DMA	89.6 MPa
Dielectric Withstand Voltage, per MIL-I-46058C	>1500 volts
Dielectric Constant, at 1MHz and 25°C per ASTM D150-98	3.5
Dissipation Factor, at 1MHz and 25°C per ASTM D150-98	0.028
Insulation Resistance, per MIL-I-46058C	3.0×10^{14} ohms (300TΩ)
Moisture Insulation Resistance, per MIL-I-46058C	4.8×10^{10} ohms (48GΩ)
Fungus Resistance, per ASTM G21	Passes
Resistance to Chemicals	Excellent

Application of HumiSeal® 1A20R

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. Otherwise, ionic or organic residues on the substrate could be trapped under the coating and cause problems with adhesion or electrical properties. The highest long term reliability for a coated printed circuit assembly will be when the conformal coating is applied over a clean, dry substrate.

The application of conformal coatings over no clean flux is a common practice. The user should perform adequate testing to confirm compatibility between the conformal coating and their particular assembly materials and process conditions. Please contact HumiSeal for additional information

Although its formulation allows HumiSeal® 1A20R to be applied using a wide variety of methods, care should be taken to ensure that it is only applied in an environment where the ambient relative humidity is at 60% or less. Application of the coating when the RH is higher than 60% can cause acceleration of the cure reaction, resulting in bubbles in the dried film.

Dipping

Depending on the complexity, density and configuration of components on the assembly, it may be necessary to reduce the viscosity of HumiSeal® 1A20R with HumiSeal® Thinner 521 or 521EU in order to obtain a uniform film. Once optimum viscosity is determined, a controlled rate of immersion and withdrawal (5-15 cm/min) will

HumiSeal® 1A20R Technical Data Sheet

further ensure even deposition of the coating and ultimately a uniform film. During the application, evaporation of solvent causes an increase in viscosity that should be adjusted by adding small amounts of HumiSeal® Thinner 521 or 521EU. Viscosity in the dip tank should be checked regularly, using a simple measuring device such as a Zahn or Ford viscosity cup.

Spraying

HumiSeal® 1A20R can be sprayed using conventional spraying equipment. Spraying should be done in an environment with adequate ventilation so that the vapour and mist are carried away from the operator. The addition of HumiSeal® Thinner 521 or 521EU is necessary to ensure a uniform spray pattern resulting in pinhole-free film. The amount of thinner and spray pressure will depend on the specific type of spray equipment used and operator technique. The recommended ratio of HumiSeal® 1A20R to HumiSeal® Thinner 521 or 521 EU is 5:2 by volume; however the ratio may need to be adjusted to obtain a uniform coating.

Brushing

HumiSeal® 1A20R may be brushed with a small addition of HumiSeal® Thinner 521 or 521EU. Uniformity of the film depends on component density and operator's technique.

Storage

HumiSeal® products may be stored at temperatures of 0 to 35°C. HumiSeal® 1A20R should be stored away from sunlight and excessive heat, in tightly closed containers. If coatings are partially used, the container should be purged with dry nitrogen prior to resealing. Prior to use, allow the product to equilibrate for 24 hours at a room temperature of 18 to 32°C.

Caution

Application of HumiSeal® Conformal Coatings should be carried out in accordance with local and National Health and Safety regulations.

The solvents in HumiSeal® 1A20R are flammable. Material should not be used in presence of open flame or sparks. Use only in well-ventilated areas to avoid inhalation of vapours or spray. Avoid contact with skin and eyes.

Consult MSDS/SDS prior to use.

Contact HumiSeal®

HumiSeal North America
201 Zeta Drive
Pittsburgh, PA 15238
USA
Tel: +1 412-828-1500
Toll Free (US only): 866-828-5470
sales@humiseal.com

HumiSeal Technical Center
295 University Avenue
Westwood, MA 02090
USA
Tel: +1 781-332-0734
Fax: +1 781-332-0703
techsupport@humiseal.com

HumiSeal Europe
505 Eskdale Road, IQ Winnersh
Berkshire RG41 5TU
UK
Tel: +44 (0)1189 442 333
Fax: +44 (0)1189 335 799
europeansales@chasecorp.com

HumiSeal Europe Support
Tel: +44 (0)1189 442 333
Fax: +44 (0)1189 335 799
europetechsupport@chasecorp.com

HumiSeal S.A.R.L
4/6 Avenue Eiffel
78420 Carrieres-Sur-Seine
France
Tel: +33 (0) 1 30 09 86 86
Fax: +33 (0) 1 30 09 86 87
humiseal.sarl@chasecorp.com

HumiSeal Asian Support
Tel: 852-9451-6434
Fax: 852-2413-6289
asiatechsupport@humiseal.com