



Technical Data Sheet

HPA High Performance Acrylic

Product Description

A flexible, fast drying transparent acrylic conformal coating for the protection of electronic circuitry formulated to meet the highest defence and aerospace requirements. This product has been formulated for professional use only.

Features

- Excellent adhesion to a wide variety of substrates.
- Fluoresces under UV light for ease of inspection.
- Wide operating temperature range.
- Can be soldered through without fear of highly toxic gases being produced (contains no isocyanates).
- Non-corrosive to Cadmium and Zinc plate (contains no phenols).
- Resistant to mould growth.
- Cured coating can be removed with Electrolube Ultrasolve (ULS).
- Excellent Dielectric properties

Approvals	MIL Approval (MIL-1-46058C): RoHS Compliant (2002/95/EC): IPC-CC-830 NATO Stock Number:	Approved (Qualification Reference: 46058-562-90) Yes Meets approval 6850992608540 (HPA200H)
Liquid Properties	Appearance: Specific Gravity (Density) @ 20°C: VOC Content: Flash Point: Solids content: Viscosity @ 20°C: Touch Dry: Recommended Drying Time: Coverage @ 25µm:	Pale Coloured Liquid 0.91 (Bulk), 0.78 (Aerosol) g/ml 65% (Bulk), 75% (Aerosol) -7°C (Bulk), -4°C (Aerosol) 35% (Bulk), 15% (Aerosol) 300 - 350 Centipoise (Bulk) 10-15 minutes. 24 Hours @ 20°C 4 Hours @ 60°C 2 Hours @ 90°C 14 m ² per litre (Bulk), 2.4 m ² (200ml Aerosol)
Dry Film Coating	Colour: Operating Temperature Range: Flammability: Thermal Cycling (MIL-1-46058C): Coefficient of Expansion: Dielectric Strength: Dielectric Constant: Insulation Resistance: Comparative Tracking Index Dissipation Factor @ 1MHz @ 25°C Moisture Resistance (MIL-1-46058C):	Colourless -55°C to +130°C Self-extinguishing (ASTM Method D635) Pass 130ppm 45 kV/mm 2.5 1 x 10 ¹⁵ Ohms/cm (DEF-STAN 59/47) >300 Volts 0.01 Pass

<u>Packaging</u>	<u>Description</u>	<u>Order Code</u>	<u>Shelf Life</u>
<u>HPA Conformal Coating</u>	200ml Aerosol	HPA200H	36 Months
	1 Litre Bulk	HPA01L	48 Months
	5 Litre Bulk	HPA05L	48 Months
<u>Universal Acrylic Thinners</u>	5 Litre	UAT05L	72 Months
<u>Removal Solvent</u>	200ml Aerosol	ULS200D	36 Months
	400ml Aerosol	ULS400D	36 Months
	1 Litre Bulk	ULS01L	72 Months
	5 Litre Bulk	ULS05L	72 Months
	25 Litre Bulk	ULS25L	72 Months

Directions For Use

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

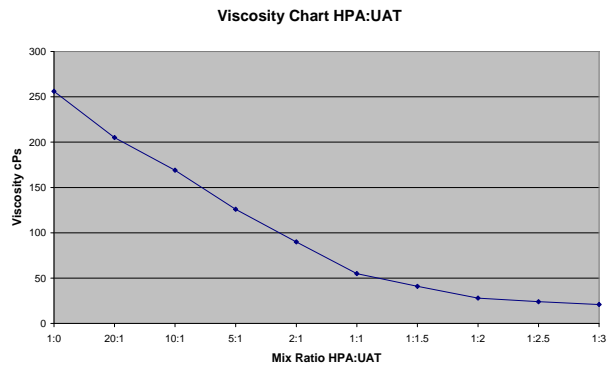
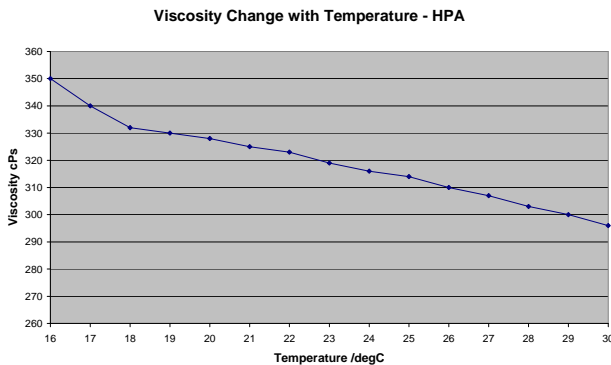
Substrates should be thoroughly cleaned before coating. This is required to ensure that satisfactory adhesion to the substrate is achieved. Also, all flux residues must be removed as they may become corrosive if left on the PCB. Electrolube manufacture a range of cleaning products using both hydrocarbon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

Spraying – Bulk

HPA needs to be diluted with the appropriate thinners (UAT) before spraying. The optimum viscosity to give coating quality and thickness depends on the spray equipment and conditions, but normally a dilution ratio of 2:1 (HPA to UAT) is required. Suitable spray viscosity is typically 50-80 centipoise. If bulk coating material has been agitated, allow to stand until air bubbles have dispersed.

HPA is suitable both for use in manual spray guns and selective coating equipment.

The selected nozzle should enable a suitable even spray to be applied in addition to suiting the prevailing viscosity. The normal spray gun pressure required is 274 to 413 kPa (40 - 60 lbs/sq.inch). After spraying, the boards should be placed in an air-circulating drying cabinet and left to dry.



Spraying - Aerosol

When applying HPA 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 / second 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.

Dip Coating

Ensure that the coating material in the container has been agitated thoroughly and has been allowed to stand for at least 2 hours for all the air bubbles to disperse.

Universal Acrylic Thinners (UAT) should be used to keep the HPA coating at a suitable viscosity for dipping (200 – 300cps @ 20°C). UAT is added periodically as the solvent evaporates. The viscosity should be checked using a viscosity meter or "flow cup".

The board assemblies should be immersed in the HPA dipping tank in the vertical position, or at an angle as close to the vertical as possible. Connectors should not be immersed in the liquid unless they are very carefully masked. Electrolube Peelable Coating Mask (PCM) is ideal for this application.

Leave submerged for approximately 10 seconds until the air bubbles have dispersed. The board or boards should then be withdrawn slowly (1 to 2 Seconds / mm) so that an even film covers the surface. After withdrawing, the boards should be left to drain over the tank or drip tray until the majority of residual coating has left the surface.

After the draining operation is complete, the boards should be placed in an air-circulating drying cabinet and left to dry.

Brushing

Ensure that the coating material has been agitated thoroughly and has been allowed to settle for at least 2 hours. The coating should be kept at ambient temperature.

When the brushing operation is complete the boards should be placed in an air-circulating drying cabinet and left to dry.

Inspection

HPA 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 is.

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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.