

HumiSeal 1B31-245

Acrylic Conformal Coating

System Description

A fast air drying, single component, acrylic coating providing excellent moisture and environmental protection for printed circuit assemblies. The final film demonstrates excellent flexibility and is easily repairable. This coating is qualified to MIL-I-46058C, AR. Fluoresces under UV light for ease of inspection.

Properties of Liquid HumiSeal

Density, (g/cm ³) per ASTM, Meth. D1475	0.90 ± 0.02
Solids Content, % by weight per Fed-Std-141, Meth.4044	35 ± 3
Viscosity, centipoise per Fed-Std--141, Meth. 4287	40 ± 3
Flashpoint, °C (°F) per ASTM, Meth. D56	-1
VOC (grams / liter)	592
Drying Time to Handle per Fed-Std-141, Meth.4061	10 minutes
Recommended Coating Thickness	1 - 3 mils
Recommended Curing Conditions	24 hrs @ rm. temp or 30 min. @ 76°C
Time Required to Reach Optimum Properties	7 days
Thinner, if needed (dipping & brushing)	Thinner 602-245
(spraying)	Thinner 521
Recommended Stripper	Stripper 1080
Pot Life at Room Temperature	12 months
Shelf Life at Room Temperature	12 months

Properties of Cured HumiSeal

Thermal Properties

Continuous Use Operating Range°C	-65°C to +125°C
Thermal Shock, per MIL-I-46058C	Passes
Solderability	Excellent
Coefficient of Thermal Expansion - DMA	55ppm /°C
Glass Transition Temperature - TMA	14°C
Young's Modulus - DMA	1260 psi

Physical Properties

Clarity	Transparent
Build per Dip, mils, per ASTM,Meth.D823	2
Flexibility, per MIL-I-46058C	Excellent
Adhesion, per ASTM, Meth. D2197	Excellent
Flammability, per ASTM, Meth. D635	Self-Extinguishing
Weather Resistance	Very Good

Electrical Properties

Dielectric Withstand Voltage, volts per MIL-I-46058C	>1,500
Dielectric Breakdown Voltage, volts, per ASTM, Meth. D149	7500
Dielectric Constant, at 1MHz and 25°C, per ASTM-D150-65T	2.5
	0.01
Dissipation Factor, at 1MHz and 25°C, per ASTM-D150-65T	800 x 10 ¹²
Insulation Resistance, ohms, per MIL-I-46058C	60 x 10 ⁹
Moisture Resistance, ohms, per MIL-I-46058C	

Chemical Properties

Main Constituent	Acrylic
Fungus Resistance, per ASTM-G21	Passes
Resistance to Chemicals	Fair

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, which may lead to assembly failures.

HumiSeal coatings may be applied by brush, dip or spray.

Dipping

Depending on the complexity, density and configuration of components on the assembly, it may be necessary to reduce the viscosity of HumiSeal 1B31-245 with HumiSeal Thinner 602-245 in order to obtain a uniform film. Once optimum viscosity is determined, a controlled rate of immersion and withdrawal (2 to 6" per minute) will further insure even deposition of the coating and ultimately a uniform film. During the application, evaporation of solvent causes an increase in viscosity, which should be adjusted by adding small amounts of Thinner 602-245. Viscosity in the dip tank should be regularly checked by the use of a simple measuring device such as a Zahn or Ford viscosity cup.

Spraying

HumiSeal 1B31-245 can be sprayed using conventional spraying equipment. As a rule, the addition of Thinner 602-245 is necessary to assure 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. The spraying should be done under an exhaust hood so that the vapour and mist are carried away from the operator. The recommended ratio of HumiSeal 1B31-245 to HumiSeal Thinner 602-245 is 1 to 1 by volume, as a starting point. The quantities may be adjusted to obtain a uniform coating.

Brushing

HumiSeal 1B31-245 may be brushed with a small addition of HumiSeal Thinner 602-245. Uniformity of the film depends on component density and operator's technique.

Storage

HumiSeal 1B31-245 should be stored at room temperature, away from excessive heat, in tightly closed containers. HumiSeal products may be stored at temperatures of 18-38°C. Avoid direct sunlight. Prior to use, allow the product to equilibrate for 24 hours at 18-32°C.

Caution

The solvents in HumiSeal 1B31-245 are flammable. Do not use in presence of open flame or sparks. Avoid inhalation of vapours or spray. Use only in well-ventilated areas. Avoid contact with skin and eyes. If contact occurs, wash with soap and water. If swallowed, call physician immediately. Refer to MSDS before use.

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