

ELPEGUARD® thick film coating Twin-Cure® DSL 1604 FLZ/100

The **ELPEGUARD®** thick film coating **Twin-Cure® DSL 1604 FLZ/100** is used to protect and insulate electronic assemblies so that they can fulfil higher requirements regarding reliability and service life.

- basis: copolymerisate of polyurethane (UR) and polyacrylate (AR)
- solvent-free / VOC-free
- UV LED curing at a wavelength of 395 nm
- powerful protection through electrical insulation properties directly after UV curing
- chemical cross-linking reaction in shadow zones
- excellent mechanical and chemical resistance
- corresponds to best flame class V-0 acc. to UL 94
- temperature range of -65 to +130 °C [-85 to 266 °F]*
- depending on the coating thickness also suitable for coating flexible circuits ("flex-to-install", bend stress during assembly only)
- excellent edge coverage, wetting and underfilling of components ("micro-casting"), very good capillar-active behaviour, yet not suitable as underfill material
- excellent adhesion
- can be mechanically stripped for repair purposes (blasting method).

* Both at the lower and upper ends of this range the performance and reliability of the material can be negatively affected in some applications. In these cases, additional pre-trials and tests are required.

Characteristics

Colour/ appearance	colourless, fluorescent
Solids content	100 %
Viscosity* at 20 °C [68 °F], ISO 3219	100 ± 30 mPas
Density at 20 °C [68 °F], ISO 2811-1	1.08 ± 0.05 g/cm ³

* measured with Haake RS 600, C 35/1°, D = 100 s⁻¹
viscosity measuring unit supplied by Thermo Fisher Scientific, www.thermofisher.com

Indices: DSL = thick film coating, FLZ = fluorescent, /100 = viscosity of 100 mPas

Physical and mechanical properties

These values are achieved after UV curing and 14 days' storage at room temperature.

Property	Test method	Result
Adhesion	IPC-TM-650, 2.4.28.1	passed
Flexibility	IPC-CC-830B, 3.5.5	passed
Glass transition temperature T _g	TMA	≈ -13 °C
Coefficient of thermal expansion (CTE)	TMA	≈ 130 ppm/°C < T _g ≈ 320 ppm/°C > T _g

Electrical properties

These values are achieved after UV curing and 14 days' storage at room temperature.

Property	Test method	Result
Dielectric strength	IPC-TM-650, 2.5.6.1 DIN EN 60243-1	≥ 50 kV/mm
	IPC-CC-830B, 3.6.1	passed
Specific volume resistivity	DIN IEC 60093 IPC-TM-650, 2.5.17.1	≥ 1.0 x 10 ¹³ Ohm x cm
Surface resistance	DIN IEC 60093 IPC-TM-650, 2.5.17.1	≥ 1 x 10 ¹⁴ Ohm
Moisture and insulation resistance	IPC-CC-830B, 3.7.1 (65 °C [149 °F]/90 % r.h.)	100 MOhm
Thermal shock resistance	IPC-CC-830B, 3.7.2 -65 to +125 °C	passed (< 100 µm)
Comparative Tracking Index (CTI, tracking resistance)	DIN EN 60 112, on base material with CTI of 275	CTI > 600
Resistance to condensation	based on ISO 6270-2 (BIAS 12 V, 40 °C [104 °F], 100% r. F.)	> 500 MOhm

Electrical properties immediately after UV LED curing

After UV curing, electrically insulating properties are already present; however, they may not yet reach the values stated above. Please consider this when performing functional tests directly after UV curing where the electrical values of the thick film coating **Twin-Cure®** are demanded. The final properties are only achieved after about 8-14 days.

Processing



Please read this technical report and the publications listed below carefully before using the product. These sheets are enclosed with the first shipment of product or sample

MSDS

The corresponding material safety data sheet contains detailed information and characteristics on safety precautions, environmental protection, transport, storage, handling and waste disposal.

AI

[Application information AI 1/2](#) "Processing instructions for the ELPEGUARD® thick film coatings of the series Twin-Cure®"

TI

[Technical information TI 15/3](#) "Protective measures when using chemicals including lacquers, casting compounds, thinners, cleaning agents"

The thick film coating **Twin-Cure® DSL 1604 FLZ/100** can be applied by automatic selective coating units – preferably spray coating – or by brushing or by means of dispensing.



Protect from UV light



Protect against humidity

Since the many different permutations make it impossible to evaluate the whole spectrum (parameters, reactions with materials used, chemical processes and machines) of processes and subsequent processes in all their variations, the parameters we recommend are to be viewed as guidelines only that were determined in laboratory conditions. We advise you to determine the exact process limitations within your production environment, in particular as regards compatibility with your specific follow-up processes, in order to ensure a stable fabrication process and products of the highest possible quality.

The specified product data is based upon standard processing conditions/test conditions of the mentioned norms and must be verified if necessary while observing suitable test conditions on processed products.

Feel free to contact our application technology department (ATD) if you have any questions or for a consultation.

Safety recommendations

- When using chemicals, the common precautions should be carefully noted.
- Ensure that the equipment used is in compliance with the requirements laid down in the material safety data sheet.
- Observe the safety instructions below as the acrylates contained in Twin-Cure® may have a sensitising effect on some users:



Wear protective gloves and safety goggles!

Avoid skin contact!

Ensure sufficient technical ventilation in the workplace.

Observe standard work hygiene measures (wash hands etc.).

Auxiliary products recommended

- [ELPESPEC® cleaning agent R 5817](#) and reactive thinner VR 1600
For cleaning work place and tools we recommend our cleaning agent **R 5817**. Clean equipment with **R 5817** and then rinse with reactive thinner **VR 1600**. Please see also our application information sheet **AI 1/2**, item “Cleaning equipment”.
- [ELPESPEC® cleaning agent R 5888](#)
water-soluble, biodegradable cleaning agent for product carriers and tools

Drying/Curing

The curing process is based on two complementary chemical cross-linking mechanisms of different time lengths: UV LED curing and humidity curing.

UV LED curing

Curing is effected in UV LED curing units at a wavelength of 395 nm.

- Cure the **ELPEGUARD®** thick film coating **Twin-Cure®** by applying an **energy of 1500 ± 500 mJ/cm² and an energy output of 1500 ± 500 mW/cm²**. The distance between lamp and assembly should be as low as possible.

UV curing with suitable UV LED lamps is mandatory. The specified final properties cannot be achieved by humidity curing alone.

Immediately after UV curing the surface is slightly tacky. 1-3 h after UV curing the UV LED cured assemblies can already be packed or encapsulated.

Humidity curing

In shadow zones, the coating will cure by reacting with atmospheric humidity. Depending on the layout and assembly of the printed circuit board, this reaction is completed after 8-14 days. Only after this time the final properties are achieved.

Packaging

The packing units available are indicated in our offer which we will send you upon request.

Shelf life and storage conditions



Shelf life: In sealed original containers at least 4 months



Storage conditions: +5 °C to +25 °C [+41 °F to +77 °F]



Protect from UV light



Protect against humidity

For warehousing reasons, isolated cases may occur where the shelf life upon shipment is less than the shelf life indicated in this technical report. However, it is ensured that our products have **at least** two-thirds of their shelf life remaining when they leave our company. Labels on containers show shelf life and storage conditions.

Disclaimer

All descriptions and images of our goods and products contained in our technical literature, catalogues, flyers, circular letters, advertisements, price lists, websites, data sheets and brochures, and in particular the information given in this literature are non-binding unless expressly stated otherwise in the Agreement. This shall also include the property rights of third parties if applicable.

The products are exclusively intended for the applications indicated in the corresponding technical data sheets. The advisory service does not exempt you from performing your own assessments, in particular as regards their suitability for the applications intended. The application, use and processing of our products and of the products manufactured by you based on the advice given by our Application Technology Department are beyond our control and thus entirely your responsibility. The sale of our products is effected in accordance with our current terms of sale and delivery.

Any questions? We would be pleased to offer you advice and assistance in solving your problems. Samples and technical literature are available upon request.