

## MP400C-1

MP400C-1 is a high performance one-component solvent based acrylic varnish.

### Application

- Protection of electronic circuitry

### Key Properties

- Fast room temperature drying
- Contains UV trace and antifungal agents
- Excellent adhesion to a wide variety of substrates
- Excellent resistance to mould growth, ultra violet light, prolonged exposure to tropical life and salt spray.
- High gloss finish and clarity
- Excellent dielectric properties at all frequencies
- Can be soldered through without fear of toxic gases being produced, e.g. isocyanate
- Non-corrosive to Cadmium and Zinc plate (contains no Phenol)

### Description

- One-part system

### Typical Properties

| Test                            | Result                            | Unit             |
|---------------------------------|-----------------------------------|------------------|
| Colour                          | Clear<br>Black                    |                  |
| Non-volatile Content            | 27                                | %                |
| Viscosity (@ 20°C)              | 240-280                           | mPa.s            |
| Specific gravity (@ 20°C)       | 0.91                              |                  |
| Flash point (closed cup)        | 4.5                               | °C               |
| Dielectric Strength             | 90                                | kV/mm            |
| Dielectric Constant (@ 20°C)    | 2.5                               | 100Hz            |
| Dissipation factor              | 0.028                             | 100Hz            |
| Volume Resistivity              | $1 \times 10^{15}$                | ohm.cm           |
| Insulation resistance           | $1 \times 10^{12}$                | ohm              |
| Hardness                        | 30                                | Shore D          |
| Temperature range               | -60 to +160                       | °C               |
| Drying time (@ 25°C)            | <20                               | minutes          |
| Coating Thickness               | 1 coat 25 – 45<br>2 coats 50 – 90 | micron<br>micron |
| Flow cup viscosity (No 4 @20°C) | 55 ±10                            | seconds          |

Contact: Technical Support on 01793 823741 or [support@robnor.co.uk](mailto:support@robnor.co.uk) for details.

### Processing

MP400C-1 can be dipped, sprayed, or brushed.

The thickness of the coating depends on the method of application, but a dip coater normally deposits a film thickness of about 25 microns (single coat).

Workshop temperatures of less than 16°C or relative humidity in excess of 75% are unsuitable for the coating.

MP400C-1 contains a UV trace that allows inspection of the PCB after coating to ensure complete and even coverage. The stronger the reflected light, the thicker the coating layer.

### PCB Cleanliness

It is essential that the PCB is thoroughly cleaned and dry before coating to ensure maximum adhesion and coating performance. No clean flux residues must also be removed as they inhibit adhesion of the coating.

### Dilution

During extended open times some solvent loss will be experienced and this will increase the viscosity and coating thickness. The solvent loss can be recovered by adding TS154 thinners. The TS154 thinners are normally added at increments of approximately 10% by volume until the desired viscosity is achieved. After blending with TS154 thinners the product should be allowed to stand for approximately 10 minutes or until all bubbles have been dispersed.

## Viscosity Control

The viscosity should be checked using a viscosity meter or "flow cup". Another method of controlling the viscosity is by measuring the cured coating thickness on a glass slide.

## Dip Coating

The board assemblies should be immersed in the dipping tank in the vertical position, or at an angle as close to vertical as possible. Connectors should not be immersed in the liquid unless they are very carefully masked. Leave the PCB submerged until the air bubbles have dispersed. The board or boards should then be withdrawn **VERY SLOWLY** so that an even film covers the surface. After withdrawing, the boards should be left to drain over the tank 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 for 2 hours at room temperature prior to any heat curing.

## Brushing

Gently apply the coating with a good quality brush so as not to leave brush marks and so that the components and wiring are not disturbed. When the brushing operation is complete, the boards should be placed in an air-circulating drying cabinet and left to dry for 30 minutes at room temperature prior to heat curing.

## Spraying

The material must be diluted with 2-parts TS154. Once modified with solvent the material will be suitable for use in manual spray guns and computer controlled airless spray equipment that only coats the required areas of the PCB, eliminating the need for masking. The nozzle of the spray gun requires to be selected to give an even spray to suit the prevailing viscosity of the coating material. The normal spray gun pressure required is  $27.6 \times 10^6$  kN/m<sup>2</sup> to  $34.5 \times 10^6$  kN/m<sup>2</sup> (40 –50lbs/sq. inch).

To ensure penetration of the coating beneath the components and in confined spaces, spray the assembly from all directions to give an even coating.

## Double coating

Coatings by their nature do not give 100% protection and contamination, poor coating and surface tension on components may lead to microscopic 'pin holes' in the coating. In most cases two coats are not usually required if the board is clean and the coating operation is controlled adequately. Two coats will generally give a greater degree of protection as the second layer can mask 'pin holes' created in the first coating layer and thus give greater protection. However, if two coats are required, the second coating should be applied within 30 minutes of the first to ensure that the two coats will bond satisfactorily.

## Drying times and curing conditions

| Temperature | Touch dry time | Initial cure time | Full Cure time | Post cure* |
|-------------|----------------|-------------------|----------------|------------|
| 20°C        | <20 minutes    | 60 minutes        | 24 hours       | -          |
| 60°C        | 5 minutes      | 20 minutes        | 12 hours       | -          |
| 80°C        | 3 minutes      | 5 minutes         | 4 hours        | 12 hours   |
| 100°C       | -              | -                 | 2 hours        | 6 hours    |
| 120°C       | -              | -                 | 1 hour         | 3 hours    |

\* For maximum performance and chemical resistance a post cure is recommended. In general the higher the post cure temperature the greater the chemical resistance. The above times will vary dependant on coating thickness, humidity and component density and are given as a guide only.

## Plastic compatibility

Please note the solvent system in MP400C-1 may affect components containing polystyrene and polycarbonate

## Approvals

|                            |     |
|----------------------------|-----|
| RoHS compliant             | Yes |
| UL94 V-0                   | No  |
| REACH (SVHC concentration) | 0%  |

## Availability

Available through distribution [www.resins-online.com](http://www.resins-online.com) and [sales@robnor.co.uk](mailto:sales@robnor.co.uk)

## Storage and Shelf Life

Material stored in the original unopened containers under cool dry condition between 10 and 25°C will have a shelf life of 18 months. Once used the containers must be kept sealed to prevent effects from water, air, or contaminants.

## Health and Safety

May cause sensitisation by skin contact or inhalation. It is therefore strongly recommended that skin and eye contact is avoided by the using of appropriate personal protective equipment such as gloves, safety glasses or goggles and overalls. Wash any contamination from the skin immediately and thoroughly and do not eat, smoke or drink in the working vicinity. Under normal working conditions a good source of ventilation is adequate, however if the material is heated, or where vapour levels are likely to exceed the occupational exposure limits appropriate respiratory protection must be worn. Local exhaust ventilation (LEV) may be required where large volumes of material are curing.

The above is given as a guide only; Please refer to MP400C-1 Health and Safety data or our Technical Service Department for individual/specific advice.

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## Contact Details

Robnor Resinlab Limited  
31 Athena Avenue  
Elgin Industrial Estate  
Swindon  
SN2 8EJ  
United Kingdom

Tel: +44 (0) 1793 823741  
Fax: +44 (0) 1793 827033  
Email: [support@robnor.co.uk](mailto:support@robnor.co.uk)  
Web: [www.robnor-resinlab.com](http://www.robnor-resinlab.com)  
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