

## 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	Result	Unit
Colour	Clear	
Non-volatile Content	27	%
Viscosity (@ 25°C)	160-200	cPs
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	micron
2 coats	50 – 90	micron
Flow cup viscosity (No 4 @25°C)	65	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 more than 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 most 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 more 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	Touch dry time	Initial cure time	Full Cure time	Post cure*
Temperature	(minutes)	(minutes)	(hours)	(hours)
20°C	<20	60	24	-
60°C	5	20	12	-
80°C	3	5	4	12
100°C	-	-	2	6
120°C	-	-	1	3

\* 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)	Refer to SDS

## Availability

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

## Part number(s)

MP400C-1/NC/20LT – 20lt Bulk – other sizes available on request

## 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

Please refer to MP400C-1 Health and Safety data or our Technical Service Department for individual/specific advice.

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