

## MP313C

MP313C is a one component, air-drying Urethane based conformal coating. MP313C has been designed for application by dipping. Best results will be obtained by use of PCB dipping machine, such as that produced by Robnor Resinlab. Coating of suitable, even thickness requires a slow steady withdrawal from the dipping bath - thus difficult to achieve by hand dipping. If the PCB has several large standoff units this may necessitate a draining step in the dipping cycle. The thickness of conformal coating applied may be varied with the limits by altering the speed of withdrawal from the bath - the slower the withdrawal, the thinner the coat. Attempting to apply too thick a coat in one stage may result in sagging or wrinkling. If a thick coat is required, this is best achieved via two thin coats - the first coat must be thoroughly cured before the second is applied. In all cases before the application of the coating thorough cleaning and drying is essential. Immediately before PCB assemblies are conformally coated all flux residues and other surface contaminants should be removed. If practicable, a cleanliness level better than 1.5µgNaCl/cm<sup>2</sup> salt weight equivalents should be achieved. The material will dry to give a tough hard-working insulating conformal coating when cured at room temperature; however, superior properties will be obtained if cured at elevated temperatures. A suggested cure schedule is 8 hours @ 80°C. This material is normally supplied at a dilution that should give a coating thickness in the region of 35µm, however this can be altered by changes to application procedures. In some applications thinning of the material may be required e.g. spraying. In such instances TS109 Thinners should be used.

**NOTE:** To avoid dispersion of MP313C as an aerosol (i.e. fine spraying or mist) in the workroom atmosphere, spraying application should not be carried out except in a properly equipped spraying booth.

### Key Properties

- Operating temperature range -50 to +130°C
- 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.
- 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)

Typical Properties	Result	Unit
Colour	Amber	
Non-volatile Content	40	%
Viscosity (@ 20°C)	150-250	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 (@ 20°C)	0.028	100Hz
Volume Resistivity	1 x 10 <sup>15</sup>	ohm.cm
Insulation resistance	1 x 10 <sup>12</sup>	ohms
Temperature range	-60 to +160	°C
Drying time (@ 25°C)	20-30	Minutes
Coating Thickness	1 coat = 25 – 45 2 coats = 50 – 90	micron 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.

Drying times	Touch dry time	Initial cure time	Full Cure time	Post cure*
Temperature (°C)	(minutes)	(minutes)	(hours)	(hours)
20	<20	60	24	-
60	5	20	12	-
80	3	5	4	12
100	-	-	2	6
120	-	-	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.

## Processing

MP313C 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. MP313C 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

MP313C is supplied ready use for dipping or brushing. 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 TS109 thinners. The TS109 thinners is normally added at increments of approximately 10% by volume until the desired viscosity is achieved. After blending with TS109 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

To spray MP313C the material must be diluted with 2-parts TS109. 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  $27.6 \times 10^6 \text{ kN/m}^2$  to  $34.5 \times 10^6 \text{ kN/m}^2$  (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.

## Plastic Compatibility

Please note the solvent system in MP313C may affect components containing polystyrene and polycarbonate.

## Approvals

RoHS compliant	Yes
DEF STAN 59/47	Yes
UL94-V0	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 Numbers

MP313C/NC/1LT  
MP313C/NC/5LT

## 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 MP313C Health and Safety data or our Technical Service Department for individual/specific advice.

## Copyright & Warranty - Robnor Resinlab Limited

The results and information above does not constitute a specification and is given in good faith and without warranty. The information is derived from test/or extrapolations believed to be reliable and is quoted for guidance only. The product is offered for evaluation on the understanding the customer satisfies himself that the product is suitable for the intended application by proper evaluation and testing.

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