

## DCA-FD

### Fast Drying Modified Silicone Conformal Coating (SCC3)

DCA-FD is fast drying modified silicone conformal coating specifically designed for the protection of electronic circuitry. It has been formulated to meet the highest defence standards in both Europe and the United States. It meets the British Ministry of Defence (MOD) DEF-STAN 59/47 Issue 4, and Underwriters Laboratories UL746C-QMJU2.

- Increases production efficiency; coating is touch dry in 20 minutes at room temperature
- Increased solids content gives 35% greater coverage per litre compared to standard bulk DCA
- Heat-cured coating is resistant to many solvents used within aerospace and automotive industries
- Can be reworked using specialist removal product, Electrolube CCRG

#### Approvals

**RoHS-2 Compliant (2011/65/EU):**  
**UL746C-QMJU2:**  
**DEF-STAN 59/47 (Issue 4):**  
**IPC-CC-830:**

**Yes**  
**Meets Approval**  
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#### Liquid Properties

Appearance:	Clear Pale Straw
Density @ 20°C (g/ml):	0.97
VOC Content:	50%
Flash Point:	27°C
Solids content:	50%
Viscosity @ 23°C (mPa s):	300-600
Touch Dry (20°C):	20 minutes
Recommended Curing Schedule*:	2 Hours @ 20°C followed by: 2 - 24 Hours @ 90°C to 120°C
* (Maximum Solvent Resistance Achieved @ 120°C; Ambient Curing Schedule: 24 Hours @ 20-25°C)	
Coverage @ 25 µm:	20m <sup>2</sup> per litre

#### Cured Film Coating

Colour:	Colourless
Operating Temperature Range:	-70°C to +200°C
Flammability:	Meets UL94 V-1
Thermal Cycling (MIL 1-46058C):	Meets approval
Coefficient of Expansion:	90ppm
Dielectric Strength:	90 kV/mm
Dielectric Constant:	3.95 @ 1 MHz
Surface Insulation Resistance:	1 x 10 <sup>15</sup> Ω
Dissipation Factor @ 1MHz, 25°C:	0.037
Moisture Resistance (MIL-1-46058C):	Meets approval

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Electrolube cannot be held responsible for the performance of its products within any application determined by the customer, who must satisfy themselves as to the suitability of the product.

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<u>Description</u>	<u>Packaging</u>	<u>Order Code</u>	<u>Shelf Life</u>
<u>DCA-FD Conformal Coating</u>	5 Litre Bulk	DCA05LFD	12 Months
<u>Conformal Coating Thinners</u>	1 Litre 5 Litre Bulk	DCT01L DCT05L	36 Months 36 Months
<u>Conformal Coating Removal Gel</u>	1 Litre Bulk	CCRG01L	36 Months

### **Directions for Use**

DCA-FD can be sprayed, dipped or brushed. The thickness of the coating depends on the method of application (typically 25-75 microns). Temperatures of less than 16°C or relative humidity in excess of 75% are unsuitable for the application of DCA-FD. As is the case for all solvent based conformal coatings, adequate extraction should be used (refer to MSDS for further information).

Substrates should be thoroughly cleaned before coating. This is required to ensure that satisfactory adhesion to the substrate is achieved. Also, all flux residues must be removed as they may become corrosive if left on the PCB. Electrolube manufacture a range of cleaning products using both hydrocarbon solvent and aqueous technology. Electrolube cleaning products produce results within Military specification.

### **Spraying – Bulk**

DCA-FD needs to be diluted with the appropriate thinners (DCT) before spraying. The optimum viscosity to give coating quality and thickness depends on the spray equipment and conditions, but normally a dilution ratio of 2:1 (DCA-FD:DCT) is required. Suitable spray viscosity is typically 50-80mPa s. If bulk coating material has been agitated, allow to stand until air bubbles have dispersed. DCA-FD is suitable both for use in manual spray guns and selective coating equipment.

The selected nozzle should enable a suitable even spray to be applied in addition to suiting the prevailing viscosity. The normal spray gun pressure required is 274 to 413 kPa (40 - 60 lbs/sq.inch). After spraying, the boards should be placed in an air-circulating drying cabinet following the curing schedule highlighted on page 3.

### **Dip Coating**

Ensure that the coating material in the container has been agitated thoroughly and has been allowed to stand for at least 2 hours for all the air bubbles to disperse. Conformal Coating Thinners (DCT) should be used to keep the DCA-FD coating at a suitable viscosity for dipping (180 – 250mPa s @ 20°C). DCT is added periodically as the solvent evaporates. The viscosity should be checked using a viscosity meter or "flow cup". The board assemblies should be immersed in the DCA-FD dipping tank in the vertical position, or at an angle as close to the vertical as possible. Connectors should not be immersed in the liquid unless they are very carefully masked. Electrolube Peelable Coating Masks (PCM/PCS) are ideal for this application.

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Leave submerged for approximately 10 seconds until the air bubbles have dispersed. The board or boards should then be withdrawn slowly (1 to 2s/mm) so that an even film covers the surface. After withdrawing, the boards should be left to drain over the tank or drip tray 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 following the curing schedule (shown below).

### **Brushing**

Ensure that the coating material has been agitated thoroughly and has been allowed to settle for at least 2 hours. The coating should be kept at ambient temperature. When the brushing operation is complete, the boards should be placed in an air-circulating drying cabinet following the curing schedule (shown below).

### **Drying Times and Curing Conditions**

The properties gained from DCA-FD are dependent on the curing schedule employed. It is essential that the coating be allowed a minimum of two hours drying time at ambient temperature prior to any heat curing. This is necessary to allow the solvent system to evaporate.

#### **Ambient**

Ambient curing is via solvent evaporation only. Eliminating the heat curing step will reduce solvent resistance. Other properties, such as resistance to humid and corrosive environments, may also reduce but still meet the requirements of many industry standards. Coated boards should be left at room temperature for the solvent to evaporate; extraction is required in the curing area.

#### **Commercial**

Most commercial users will gain satisfactory performance from this coating by curing for two hours at 90°C after the two-hour ambient cure. This will give limited resistance to solvents.

#### **Military**

If the assemblies are to be used under conditions of high temperature or be exposed to extremes of thermal cycling, the coating should be cured for 12 hours at ambient followed by 24 hours at 90°C. For maximum solvent resistance cure at 2 hours at ambient following by 24 hours @ 120°C. This curing schedule will give resistance to the more aggressive solvents.

It is recommended that the coating be thoroughly cured on circuits, which have design areas of very high impedance that require adjustment after application.

### **Inspection**

DCA-FD contains a UV trace, which allows inspection of the PCB after coating to ensure complete and even coverage. The stronger the reflected UV light, the thicker the coating layer is. UV light in the region of 375nm should be used for inspection.

Revision 2: Jan 2014