ELECTROLUBE
THE SOLUTIONS PEOPLE

LFCC
Lead Free Conformal Coating

LFCC has been specifically designed for the protection of electronic circuitry processed with lead-free soldering products. It offers excellent adhesion properties to a variety of substrates including no-clean, lead-free flux resides.

- Ideal for use with no-clean, lead-free flux residues that can cause issues with coating adhesion
- High degree of flexibility; suitable for applications requiring a wide and variable operating temperature
- Fast coating application; ready to use, can be cured under ambient conditions or accelerated using heat
- Can be reworked using specialist removal product, Electrolube CCRG

Approvals	**RoHS-2 Compliant (2011/65/EU):**	**Yes**
	DEF-STAN 59/47 (Issue 4):	**Meets approval**
	MIL Approval (MIL-1-46058C):	**Meets approval**
	IPC-CC-830:	**Meets approval**
Liquid Properties	Appearance:	Clear Pale Straw
	Density @ 20°C (g/ml):	0.78 (Aerosol)
	VOC Content:	83% (Aerosol)
	Flash Point:	<23°C (Aerosol)
	Solids content:	27% (Aerosol)
	Touch Dry:	50 - 55 minutes
	Recommended Drying Schedule:	24 hours @ 20°C Or 1 hour @ 20°C followed by 2 hours at 90ºC
	Coverage @ 25 µm:	4.32m² (400ml Aerosol)
Cured Film Coating	Colour:	Colourless
	Operating Temperature Range:	-50°C to +150°C
	Flammability:	Meets UL94 V-1
	Thermal Cycling:	Meets MIL 1-46058C Approval
	Coefficient of Expansion:	85ppm
	Dielectric Strength:	80 kV/mm
	Dielectric Constant:	3.5 @ 1 MHz
	Surface Insulation Resistance:	1×10^{15} Ω
	Dissipation Factor (@1 MHz, 25°C):	0.034
	Moisture Resistance (MIL-1-46058C):	Meets approval

Ashby Park, Coalfield Way,
Ashby de la Zouch,
Leicestershire LE65 1JR
T +44 (0)1530 419 600
F +44 (0)1530 416 640
BS EN ISO 9001:2008
Certificate No. FM 32082

Description	Packaging	Order Code	Shelf Life
LFCC Conformal Coating	400ml Aerosol	LFCC400ML	36 Months
Conformal Coating Removal Gel	1 Litre Bulk	CCRG01L	36 Months

Directions for Use

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 LFCC. 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 - Aerosol

When applying LFCC in aerosol form care must be taken to ensure the can is not shaken before use. Shaking the can will introduce excessive air bubbles and will give a poor coating finish.

The can should be held at 45° and 200mm from the substrate to be coated. The valve should then be depressed when the can is pointing slightly off target and moved at about 100mm/s across the target. To ensure the best coating results are achieved try to use a smooth sweeping motion with small overlap for successive rows.

To ensure penetration of the coating beneath the components and in confined spaces, spray the assembly from all directions to give an even coating. After spraying, the boards should be placed in an air-circulating drying cabinet and left to dry.

Inspection

LFCC 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. Fluorescence emission will occur between 400-500nm; peak emission is around 440nm.

Revision 1: Oct 2013

Ashby Park, Coalfield Way,
Ashby de la Zouch,
Leicestershire LE65 1JR
T +44 (0)1530 419 600
F +44 (0)1530 416 640
BS EN ISO 9001:2008
Certificate No. FM 32082