



## Turbo-Coat™ HV Acrylic Conformal Coating Product# 2109

### Product Description

Techspray's new Turbo-Coat™ HV Acrylic Conformal Coating is a high viscosity version of our popular Turbo-Coat. This coating is tested and approved in Asymtek and PVA selective spray systems, both atomized and airless models.

Turbo-Coat is designed to speed up board production throughput without additional investment of expensive UV systems or other capital equipment. Conformal coating cure time is often considered a production bottleneck for PCB assembly operations. Turbo-Coat HV dries tack-free in under 10 minutes, allowing manufactures to handle boards in 1/2 the time of the leading acrylic coating!

Turbo-Coat Thinner is available to reduce the viscosity to fit ideal process parameters. Turbo-Coat, Turbo-Coat HV, and Turbo-Coat Thinner are all HAPs (Hazardous Air Pollutants) free, so do not contain common coating solvents like Toluene, Xylene, and MEK. This makes these coating more user friendly and safe.

Turbo-Coat HV uses the same acrylic resin as the original Turbo-Coat, so coatings can be mixed-and-matched through the process, e.g. using the faster curing Turbo-Coat in the rework area, Turbo-Coat HV in the assembly area, and Turbo-Coat pen for QC touch-up.

### Features / Benefits

- Dry to Touch in Under 10 Minutes!
- Designed for selective sprayers
- Low toxicity
- No Toluene, Xylene or MEK
- Meets IPC-CC-830B
- UL94 V-0 – nonflammable final coat
- UV indicator for black light inspection

### Applications

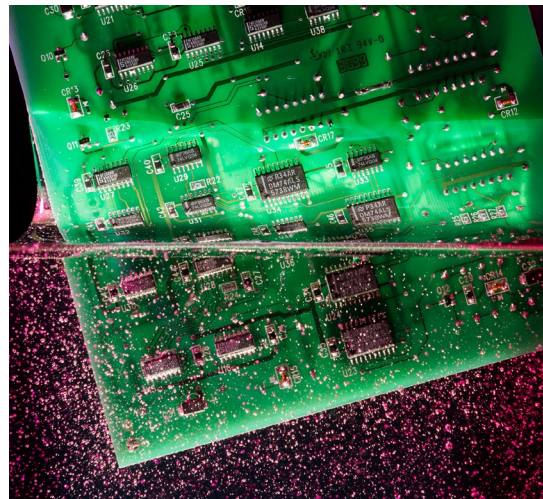
Electronic Assemblies for...

- Automotive
- Aviation
- Consumer Electronics
- Appliances
- Industrial Meters & Control

### Thinning/Removal

Techspray® coatings can be thinned to meet production requirements using Conformal Coating Thinner (2105). Conformal Coating Remover (2510) is also available for rework and repair, although coating is often just burnt through in the soldering process for spot repairs.

Techspray coatings contain Opti/Scan to allow quality control inspection of coverage and evenness of the coating on a PCB. A board can be passed under a standard, low-cost long-wave UV (black) light, and the coated areas glow. The brighter the glow, the thicker the coating.



### Typical Product Data and Physical Properties

<b>Physical State:</b>	Liquid
<b>Odor:</b>	Sweet ester odor
<b>Color:</b>	Clear, colorless
<b>Percent Volatile:</b>	75.5 at 68°F (25°C)
<b>Vapor pressure:</b>	1.12 mmHg @ 20°C
<b>Vapor density:</b>	>1 (Air=1)
<b>Boiling Point:</b>	Not Determined
<b>Flashpoint and method:</b>	41°F (5°C)
<b>Solubility in water:</b>	Negligible
<b>Evaporation rate:</b>	>1 (n-Butyl Acetate=1)
<b>Density:</b>	0.91 at 68°F (25°C)
<b>Viscosity #1:</b>	52 to 60 Centipoise at 68°F (25°C)
<b>VOC:</b>	7.200% by weight
<b>Shelf life:</b>	2 years

## Turbo-Coat™ HV Acrylic Conformal Coating Product# 2109

### Usage Instructions

For industrial use only. Read SDS carefully prior to use. Before applying Turbo-Coat™ conformal coating, clean circuit boards to remove contamination and allow to dry. Cleaning is recommended for optimal adhesion, and may be performed with Techspray G3, E-LINE™ and Precision-V defluxers.

**Spray Application:** Apply top to bottom, allowing coating to flow evenly around components. Repeat application 3 additional times from varying directions to prevent component shadowing. Then allow board to cure. If additional thickness is desired, apply additional coatings. When using liquid spray with automatic dispensing equipment, adjustments may be required in application rate and viscosity.

**Dip Application:** Using automatic equipment or hand immersion technique, slowly immerse PCB into the coating and remove slowly. Use an average rate of approximately 1 foot per minute. After allowing the board to cure, process may be repeated to achieve desired thickness.

**Brush Application:** Evenly apply coating to areas desired at thickness required. Allow time for curing before reapplying to achieve a thick coating. Use WonderMASK to protect components during conformal coating process. After application, cured Fine-L-Kote™ may be removed using Techspray Conformal Coating Removal Pen (2510-N or 2510-P).

### Coverage

(1 mil dry film)                      1 gal. liquid = 391ft<sup>2</sup> (36.3M<sup>2</sup>)

### Cure Profile

**Accelerated Cure:**                      55 minutes @ 131°F / 55°C  
**Ambient Cure:**                            15 hours @ 74°F / 23°C (ambient temp)  
**Tack-Time (dry to touch):**            9 minutes @ 74°F / 23°C (ambient temp)

Cure time depends on a number of factors, including the method and thickness of application. Dilution will also change the cure profile. 131°F / 55°C is recommended as the best accelerated temperature to optimize leveling, providing the smoothest possible finish. A faster cure may be achieved, but should be thoroughly tested first.

### Test Data

#### Application

Application Method	Test Method*	2108 Test Results
Application Method		Spray system, dip, or brush
Cure time	TS-053	<15 hours
Accelerated cure time	TS-054	55 min @55°C
Dry time to touch	TS-055	9 min
Quality inspection method of coverage		UV (long-wave black) light
Removal method		Alkane, Acetone or Acetate, Solder iron burn through

### Characteristics

As Supplied:	Test Method	2108 Test Results
Visual appearance	TS-050	Clear
Density (25 C)	TS-019-1	0.91
Viscosity (25 C)	Instrument (Brookefield RVT) guide	53 to 60 Centipoise
Solids %	TS-015	24-26
Flash point	ASTM D-56 (TAG CC)	5°C (41°F)
Vapor pressure (20 C) (VOC composite)	Calculated	1.12 mmHg
Initial boiling point	TS-051	Not Determined
Stability (30-day test @ 37 C/100 F)	TS-052	Stable
Stability (30-day test @ 6.1 C/21 F)	TS-052-1	Stable
Resin T g	provided by supplier	50-55C
Resin mol wt	provided by supplier	60,000

**Certified Testing - pending, stated results based on 2108, which contains the same resin**

As Cured - Physical	Test Method	2108 Test Results
Dielectric strength	ASTM D-149, IPC-TM-650 2.5.6.1, Rev. A	1000 volts
Adhesion	ASTM D-3359	5B
Film hardness	ASTM D-3363	2B
Film thickness (1 dip)	ASTM D-1005	1 mil (0.001")
UL Qualification	Test Method	2108 Test Results
Coating flammability	UL94/746E	V-0
IPC-CC-830B Qualification	Test Method	2108 Test Results
Appearance	IPC-CC-830B 3.5.2	pass
Fluorescence	IPC-CC-830B 3.5.3	pass
Flammability	IPC-CC-830B 3.5.6	pass
Fungus resistance	IPC-TM-650 2.6.1.1	pass
Flexibility	IPC-TM-650 2.4.5.1	pass
Dielectric withstand voltage	IPC-TM-650 2.5.7.1	pass
Moisture & insulation resistance	IPC-TM-650 2.6.3.4	pass
Thermal shock	IPC-TM-650 2.6.7.1	pass
Temperature humidity ageing	IPC-TM-650 2.6.11.1	pass

\*Final results for 2109 pending. Results based on 2108, which uses the same resin. All other specification testing is complete.

## Turbo-Coat™ HV Acrylic Conformal Coating Product# 2109

### Chemical Compatibility – Industrial Chemicals

INDUSTRIAL CHEMICALS	EFFECT	CAS #
Methanol	Soften	67-56-1
Ethanol	Dissolution	64-17-5
IPA	Dissolution	67-63-0
70% IPA	Dissolution	67-63-0
50% Ethanol	No effect	64-17-5
DPM	Dissolution	34590-94-8
Glycol ether EB	Dissolution	111-76-2
THF	Dissolution	109-99-9
Acetone	Dissolution	67-64-1
n-propyl acetate	Dissolution	109-60-4
t-butyl acetate	Dissolution	540-88-5
Hexane	Dissolution	110-54-3
Heptane	Soften	142-82-5
Cyclopentane	Dissolution	287-92-3
Cyclohexane	Dissolution	110-82-7
Toluene	Dissolution	108-88-3
Trans-dce	Dissolution	156-60-5

### Chemical Compatibility – Household Chemicals

HOUSEHOLD CHEMICALS	EFFECT	EXAMPLE OF US BRAND NAME
5% Acetic acid	No effect	Heinz Vinegar
0.1N Hydrochloric acid	No effect	Lime-A-Way Toilet Bowl Cleaner
50% Nitric acid	No effect	
Parson's solution	No effect	Windex
0.1N Potassium hydroxide	No effect	10% Liquid Plumber
45% Potassium hydroxide	No effect	Liquid Plumber
d-limonene	Dissolution	Orange Glo
Chlorox neat	No effect	Chlorox
Chlorox 1:1	No effect	50% Chlorox
Chlorox 1:4	No effect	20% Chlorox
Pine-Sol Lemon	No effect	Pine-Sol Lemon
Pro 409	No effect	409 Professional

In most cases, Techspray corporate test methods (TS designation) correspond to standard ASTM Copies of Techspray corporate test methods are available upon request.

### Packaging and Availability

Turbo-Coat HV:

<b>2109-P</b>	1 Pint Liquid
<b>2109-G</b>	1 Gallon Liquid
<b>2109-5G</b>	5 Gallon Liquid
<b>2109-54G</b>	54 Gallon Liquid

### Environmental Policy

Techspray® is committed to developing products to ensure a safer and cleaner environment. We will continue to meet and sustain the regulations of all federal, state and local government agencies.

### Resources

Techspray® products are supported by global sales, technical and customer services resources.

For additional technical information on this product or other Techspray® products in the United States, call the technical sales department at 800-858-4043, email [tsales@techspray.com](mailto:tsales@techspray.com) or visit our web site at: [www.techspray.com](http://www.techspray.com).

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