Multi-Cure® 9-20676-F
Thermal Shock Resistant Conformal Coating

APPLICATIONS
- Conformal Coatings

FEATURES
- UV/Visible Light Cure
- Secondary Moisture Cure
- Solvent Free
- Low VOCs
- Blue Fluorescing

OTHER FEATURES
- Mil-I-46058C Listed
- IPC-CC-830-B Approved
- Excellent Shock and Vibrational Performance

Multi-Cure® 9-20676-F forms a tough clear coating upon exposure to light. 9-20676-F is excellent for conformal coating. This coating has performed well through vibration, impact, and thermal shock testing. The coating exhibits excellent adhesion to most solder masks. 9-20676-F has secondary heat-cure capability. 9-20676-F contains a UV tracer for fluorescing capabilities. Dymax Multi-Cure materials contain no nonreactive solvents and cure upon exposure to light. Their ability to cure in seconds enables faster processing, greater output, and lower processing costs. When cured with Dymax lightcuring spot lamps, focused-beam lamps, or flood lamps, they deliver optimum speed and performance for bonding. Dymax lamps offer the ideal balance of UV and visible light for the fastest, deepest cures. This product is in full compliance with RoHS directives 2015/863/EU.

UNCURED PROPERTIES *

Property	Value	Test Method
Solvent Content	No Nonreactive Solvents	N/A
Chemical Class	Acrylated Urethane	N/A
Appearance	Colorless Transparent Liquid	N/A
Soluble in	Organic Solvents	N/A
Density, g/ml	1.06	ASTM D1875
Viscosity, cP	400 (nominal)	ASTM D1084
Shelf Life at Recommended Conditions from Date of Manufacture	18 months	N/A

CURED MECHANICAL PROPERTIES ¥

Property	Value	Test Method
Durometer Hardness	D45	ASTM D2240
Tensile at Break, MPa [psi]	9.0 [1,300]	ASTM D638
Elongation at Break, %	250	ASTM D638
Modulus of Elasticity, MPa [psi]	13.7 [2,000]	ASTM D638

OTHER CURED PROPERTIES ¥

Property	Value	Test Method
Refractive Index (20°C)	1.50	ASTM D542
Boiling Water Absorption, % (2 h)	2.6	ASTM D570
Water Absorption, % (25°C, 24 h)	0.9	ASTM D570
Linear Shrinkage, %	2.1	ASTM D2566
CTEα_1, µm/m/°C	98	ASTM E831
CTEα_2, µm/m/°C	268	ASTM E831
Thermal Shock, -65°C to 125°C	50 Cycles	MIL-I-46058C
Moisture Resistance	Passes	MIL-I-46058C

ELECTRICAL PROPERTIES ¥

Property	Value	Test Method
Dielectric Constant (1 MHz)	3.27	ASTM D-1304
Dissipation Factor (1 MHz)	0.046	ASTM D-1304
Volume Resistivity, ohm-cm	555E+12	ASTM D-1304
Surface Resistivity, ohm	6,300E+12	ASTM D-1304
Dielectric Strength, kV/mm	500	ASTM D-1304

ADHESION

Substrate	Recommendation
Lead Frame	✓
Ceramic	✓
PCB	✓
Flex	✓
Silicon	✓

✓ Recommended o Limited Applications
st Requires Surface Treatment (e.g. plasma, corona treatment, etc.)

* Not Specifications
N/A Not Applicable
¥ Measured after UV cure followed by 15 days at 25°C/50% RH

Technical Data Collected 2016 Rev.02/14/2024

CURING GUIDELINES

Fixture time is defined as the time to develop a shear strength of 0.1 N/mm2 [10 psi] between glass slides. Actual cure time typically is 3 to 5 times fixture time.

Dymax Curing System (Intensity)	Fixture Time or Belt Speed
2000-EC (50 mW/cm^2)[B]	1s
5000-EC (200 mW/cm^2)[B]	1s
BlueWave® 75 (5.0 W/cm^2)[B]	2s
BlueWave® 200 (10 W/cm^2)[B]	2s
UVCS Conveyor with one 5000-EC (200 W/cm^2)[C]	8.2 m/min [27 ft/min]
UVCS Conveyor with Fusion F300S (2.5 W/cm^2)[C]	8.2 m/min [27 ft/min]

A Intensity was measured over the UVA range (320-395 nm) using a Dymax ACCU-CAL™ 50 Radiometer.

B Intensity was measured over the UVA range (320-395 nm) using a Dymax ACCU-CAL™ 160 Radiometer.

C At 53 mm [2.1 in] focal distance. Maximum speed of conveyor is 8.2 m/min [27 ft/min]. Intensity was measured over the UVA range (320-395 nm) using a Dymax ACCU-CAL™ 100 Radiometer.

Full cure is best determined empirically by curing at different times and intensities, and measuring the corresponding change in cured properties such as tackiness, adhesion, hardness, etc. Full cure is defined as the point at which more light exposure no longer improves cured properties. Higher intensities or longer cures (up to 5x) generally will not degrade Dymax light-curable materials.

SECONDARY HEAT CURE

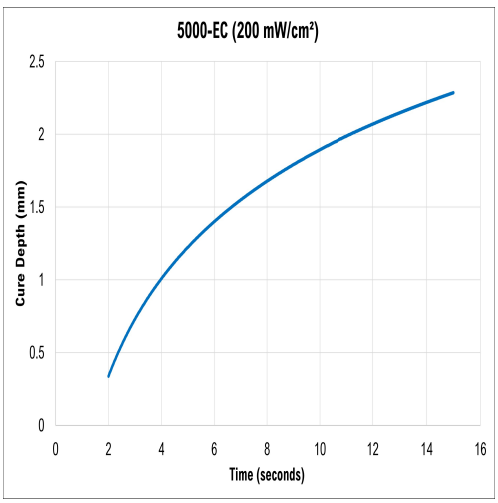
Heat can be used as a secondary cure mechanism where the adhesive cannot be cured with light. Light curing must be done prior to heat cure.

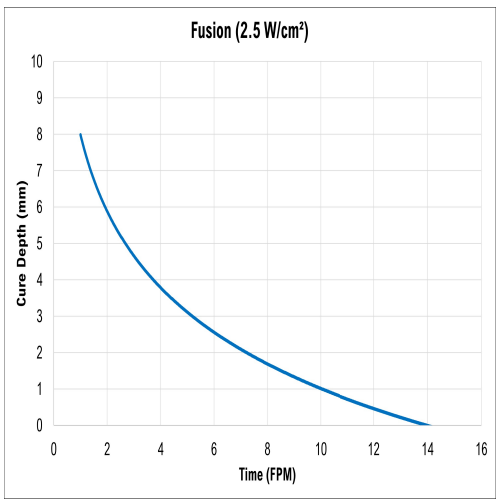
*Note: Actual heat-cure time may vary due to part configuration, volume of adhesive applied, and oven efficiency.

Dymax recommends that customers employ a safety factor by curing longer, at higher intensity, and/or at higher temperature than required for full cure. Although Dymax Application Engineering can provide technical support and assist with process development, each customer ultimately must determine and qualify the appropriate curing parameters required for their unique application.

DEPTH OF CURE

The graph below shows the increase in depth of cure as a function of exposure time. A 9.5 mm [0.37 in] diameter specimen was cured in a polypropylene mold and cooled to room temperature. It was then released from the mold and the cure depth was measured.





OPTIMIZING PERFORMANCE AND HANDLING

1. This product cures with exposure to UV and visible light as well as moisture. Exposure to ambient and artificial light and moisture should be kept to a minimum before curing. Dispensing components including needles and fluid lines should be 100% light blocking, not just UV blocking.
2. All bond surfaces should be clean and free from grease, mold release, or other contaminants prior to dispensing the adhesive.
3. Cure speed is dependent upon many variables, including lamp intensity, distance from the light source, required depth of cure, bond gap, and percent light transmission of the substrate.
4. Oxygen in the atmosphere may inhibit surface cure. Surfaces exposed to air may require high-intensity UV light to produce a dry surface cure. Flooding the bond area with an inert gas, such as nitrogen, can also reduce the effects of oxygen inhibition.
5. Parts should be allowed to cool after cure before testing and subjecting to any loads.
6. In rare cases, stress cracking may occur in assembled parts. Three options may be explored to eliminate this problem. One option is to heat anneal the parts to remove molded-in stresses. A second option is to open the gap between mating parts to reduce stress caused by an interference fit. The third option is to minimize the amount of time the liquid adhesive remains in contact with the substrate(s) prior to curing.
7. Light curing generally produces some heat. If necessary, cooling fans can be placed in the curing area to reduce the heating effect on components.
8. At the point of curing, an air exhaust system is recommended to dissipate any heat and vapors formed during the curing process.
9. Resealing opened container under a dry, inert gas, such as nitrogen, can help to prolong the shelf life.
10. Light cure is recommended prior to moisture cure. Full cure develops after both light and moisture cure, not one or the other.

DISPENSING SUPPORT

The Dymax Application Engineering team is ready to discuss your application requirements to provide the most appropriate dispensing and/or spraying solution. Visit our current dispensing equipment portfolio here or consult our global contact phone numbers and online chat feature (available in North America only) during normal business hours for instant support.

STORAGE AND SHELF LIFE

Store the material in a low humidity, cool, and dark place when not in use. This product may polymerize upon prolonged exposure to ambient and artificial light as well as moisture. This material shelf life noted on page 1 of this document, when stored between 10°C (50°F) and 32°C (90°F) in the original, unopened container.

Resealing large containers under dry inert gas, such as nitrogen, can help maintain the shelf life. Smaller syringes and cartridges should be kept in moisture barrier bags with desiccant when not in use.

CLEAN UP

Uncured Dymax dual-cure materials may be removed from dispensing components and parts with non-alcoholic solvents. Alcoholic solvents (such as IPA or ethanol) that contain moisture activate the curing process. Therefore, it is recommended that non-alcohols such as Butyl Acetate Acetone or MEK be used to cleanup uncured material and purge wetted dispensing lines.

Cured material will be impervious to many solvents and difficult to remove. Cleanup of cured material may require mechanical methods such as ultrasonic bath, water jet, vacuum tweezers, air knife and/or warming to aid in the removal.

GENERAL INFORMATION

This product is intended for industrial use only. Keep out of the reach of children. Avoid breathing vapors. Avoid contact with skin, eyes, and clothing. Wear impervious gloves. Repeated or continuous skin contact with uncured material may cause irritation. Remove material from skin with soap and water. Never use organic solvents to remove material from skin and eyes. For more information on the safe handling of this material, please refer to the Safety Data Sheet before use.

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