



**LOCTITE**

Technical Data Sheet



# LOCTITE STYCAST UV 7993

April 2021

## PRODUCT DESCRIPTION

LOCTITE STYCAST UV 7993 provides the following product characteristics:

<b>Technology</b>	Urethane
<b>Appearance</b>	Translucent yellow
<b>Components</b>	One-component
<b>Product Benefits</b>	<ul style="list-style-type: none"> <li>• UV curable</li> <li>• Room temperature moisture cure for shadowed areas</li> <li>• One component</li> <li>• Solvent-free</li> <li>• Good moisture resistance</li> <li>• Excellent chemical resistance</li> </ul>
<b>Cure</b>	Ultraviolet (UV) light activation followed by room temperature moisture cure
<b>Application</b>	Conformal coating
<b>Operating Temperature</b>	-40 to 130 °C
<b>Typical Assembly Applications</b>	Printed circuit board

LOCTITE STYCAST UV 7993 is a conformal coating designed to provide rugged protection from moisture and harsh chemicals. It is compatible with industry standard solder masks, no-clean fluxes, metallization, components and substrate materials.

## TYPICAL PROPERTIES OF UNCURED MATERIAL

Brookfield Viscosity mPa·s (cP)	120
Specific Gravity	1.04
Shelf Life @ 25°C, days	365
Flash Point - See SDS	

## TYPICAL CURING PERFORMANCE

### Recommended UVC Cure Condition for a Tack-free Surface

Medium pressure mercury vapor lamp:	
Exposure Time, seconds	5 to 10
Light Intensity, mW/cm <sup>2</sup>	>60
UVC Cure Energy, mJ/cm <sup>2</sup>	>300

### Recommended UVA Cure Condition

Medium pressure mercury vapor lamp:	
Wavelength, nm	365
Exposure Time, seconds	10 to 20
Light Intensity, mW/cm <sup>2</sup>	150 to 300
UVA Cure Energy, mJ/cm <sup>2</sup>	>1,500

### Moisture Cure for Shadowed Areas

Relative humidity 50%	100 hours @ 25°C
Relative humidity >70%	50 hours @ 25°C

Areas hidden or shadowed from the UV light source will moisture cure at ambient temperature and humidity. No further processing is necessary.

The above cure profiles are guideline recommendations. Cure conditions (time and temperature) may vary based on customers' experience and specific application requirements, as well as

customer curing equipment, oven loading and actual oven temperatures.

## TYPICAL PROPERTIES OF CURED MATERIAL

### Physical Properties

Hardness, Shore A	80
Hardness, Shore D	60
Modulus	N/mm <sup>2</sup> 1,150 (psi) (166,650)

### Electrical Properties

Volume Resistivity, ohm-cm @ 25°C	2.2×10 <sup>16</sup>
Dielectric Strength, kV/mm	50
Dielectric Constant	3.34
Dissipation Factor	0.0131

## TYPICAL PERFORMANCE OF CURED MATERIAL

### Miscellaneous

Tensile Strength	N/mm <sup>2</sup> 35 (psi) (5,005)
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## GENERAL INFORMATION

For safe handling information on this product, consult the Safety Data Sheet, (SDS).

### Directions for Use

1. Surface preparation of assembled boards prior to applying LOCTITE STYCAST UV 7993 is not required. However, improved adhesion and reliability performance can be achieved when contaminants such as ionics, dust, salts and oils are cleaned from the assembled board.

2. LOCTITE STYCAST UV 7993 has been applied successfully using dip, spray, brush, and flow coating equipment.

3. Final coating thickness is influenced by board size, part geometry and application method.

4. **Dip coat operations:** A withdrawal rate of 5 inches per minute results in a typical coating thickness of 3 mils. Time allowed for coating run-off before cure will also influence final coating thickness. Coating run-off time should be based on appropriate process factors including board size and component density.

5. **Spray and flow coating operations:** Solventless conformal coatings usually require modified operating procedures compared to solvent-based systems such as lower flow rate through the gun, increased atomization pressure to create a fine mist and spray gun location approximately 2 to 3 inches above the assembled board.

6. Equipment parameters such as nozzle design, nozzle orientation and number of passes will impact final coating thickness.

**Storage**

Store product in the unopened container in a dry location. Storage information may be indicated on the product container labeling.

**Optimal Storage : 25 °C**

Avoid heat, light and moisture.

Material removed from containers may be contaminated during use. Do not return product to the original container. Henkel Corporation cannot assume responsibility for product which has been contaminated or stored under conditions other than those previously indicated. If additional information is required, please contact your local Henkel Representative.

**Not for product specifications**

The technical data contained herein are intended as reference only. Please contact your local quality department for assistance and recommendations on specifications for this product.

**Conversions**

$(^{\circ}\text{C} \times 1.8) + 32 = ^{\circ}\text{F}$

$\text{kV/mm} \times 25.4 = \text{V/mil}$

$\text{mm} / 25.4 = \text{inches}$

$\text{N} \times 0.225 = \text{lb/F}$

$\text{N/mm} \times 5.71 = \text{lb/in}$

$\text{psi} \times 145 = \text{N/mm}^2$

$\text{MPa} = \text{N/mm}^2$

$\text{N}\cdot\text{m} \times 8.851 = \text{lb}\cdot\text{in}$

$\text{N}\cdot\text{m} \times 0.738 = \text{lb}\cdot\text{ft}$

$\text{N}\cdot\text{mm} \times 0.142 = \text{oz}\cdot\text{in}$

$\text{mPa}\cdot\text{s} = \text{cP}$

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Reference 1

