Product Information
Electronics

DOW CORNING

Dow Corning® 1-2620 Low VOC Conformal Coating

One-part, transparent low viscosity conformal coating with firm, abrasion resistant surface after cure. Low VOC version of 1-2620.

FEATURES & BENEFITS

- Cures to tough, resilient, abrasion resistant surface
- Solvent-borne resin coating with lower odor
- Reduced VOC content as measured by certain U.S. state standards
- Room temperature cure
- UV indicator for inspection
- UL-94 V-0 flammability rating
- UL-746E Recognized
- IPC-CC-830 Qualified
- Mil-I-46058C Approved
- Low viscosity enhances flow and fill in narrow gaps and spaces
- No ovens required for cure
- Optional mild heat acceleration (after solvent flash-off) can speed in-line processing
- Good adhesion allows use with many low-solids (no clean) and no-lead solders
- May simplify VOC emissions recovery in some U. S. States
- UV indicator allows for automated inspection
- Can be good choice for applications requiring increased toughness and abrasion resistance after cure

COMPOSITION

- One-part silicone resin solution in reduced solvent

APPLICATIONS

Dow Corning® 1-2620 Low VOC Conformal Coating is an RTV elastoplastic suitable for:

- Electronic printed wiring board (PWB) applications and delicate components applications based upon the physical properties of the product
- Low stress protective coating for rigid and flexible circuit boards

TYPICAL PROPERTIES

Specification Writers: These values are not intended for use in preparing specifications. Please contact your local Dow Corning sales office or your Global Dow Corning Connection before writing specifications on this product.

Property	Unit	Result
One or Two-part	-	One
Color	-	Clear
Viscosity	cP Pa-sec	133 0.1
Specific Gravity (Uncured)	-	0.88
Specific Gravity (Cured)	-	1.12
Tack-Free Time at 25ºC	minutes	15
Tack-Free Time at 60ºC/15% RH	minutes	5
Durometer Shore A	-	80
Dielectric Strength	volts/mil kV/mm	400 16
Volume Resistivity	ohm*cm	1.05E15
Dielectric Constant at 100 Hz	-	2.49
Dielectric Constant at 100 kHz	-	2.48
Dissipation Factor at 100 hz	-	0.002
Dissipation Factor at 100 kHz	-	0.004
Agency Listing	-	IPC-CC-830A, (Amend.1) UL746E
UL Flammability Classification	NA	94 V-0
Mil Specification	NA	Mil-I-46058C Amend. 7

DESCRIPTION

RTV elastoplastic conformal coatings have firm, dry surfaces for better handling and abrasion resistance after cure. Various viscosity versions facilitate different application methods. They require atmospheric moisture to cure (no ovens) and their cure rates can be accelerated by mild heat. Conformal coatings are materials applied in thin layers onto printed circuits boards or other electronic substrates.

Dow Corning 1-2620 Low VOC Conformal Coating version is supplied with a lower VOC content compared to that of the *Dow Corning*® 1-2620 Dispersion and has equivalent Mil spec, IPC-CC-830A and UL recognitions.

APPLICATION METHODS

- Spray
- Brush
- Flow
- Dip
- Automated pattern coating

PROCESSING/CURING

The time required to reach a tack-free state can be reduced with heat. When using heat for this purpose, allow adequate time for the solvent to evaporate prior to exposing to elevated temperatures in an air circulating oven. A typical cure schedule for 3 mil (75 micron) coatings is 10 minutes at room temperature, followed by 10 minutes at 60°C. If the coating blisters or contains bubbles, allow additional time at room temperature for the solvent to flash off prior to oven cure.

POT LIFE AND CURE RATE

The pot life of *Dow Corning* RTV Conformal Coatings is dependent on the application method chosen. To extend pot life, minimize exposure to moisture by using dry air or dry nitrogen blanketing whenever possible.

ADHESION

With RTV cure coatings, adhesion typically lags behind cure and may take up to 72 hours to build in some coatings. *Dow Corning* Conformal Coatings are formulated to provide adhesion to most common electronic substrates and materials. It is recommended that the coatings be applied to clean and dry substrates prior to application. Due to the vast variety of substrates used, appropriate adhesion testing should be performed to insure the adhesion of the coating is adequate for the end use and should only be tested after 72 hours at room temperature. On certain difficult, low-surface energy surfaces, adhesion may be improved by priming or by special surface treatment such as chemical or plasma etching.

USABLE LIFE AND STORAGE

Special precautions must be taken to prevent moisture from contacting *Dow Corning* RTV Conformal Coatings. Containers should be kept tightly closed and head or air space minimized. Partially filled containers should be purged with dry air or other gases, such as nitrogen. The product should be stored in its original packaging with the cover tightly attached to avoid any contamination. Store in accordance with any special instructions listed on the product label. The product should be used by its Use Before date as indicated on the product label.

USEFUL TEMPERATURE RANGES

For most uses, silicone adhesives should be operational over a temperature range of -45 to 200 °C (-49 to 392 °F) for long periods of time. However, at both the low and high temperature ends of the spectrum, behavior of the materials and performance in particular applications can become more complex and require additional considerations. For low temperature performance, thermal cycling to conditions such as -55 °C (-67 °F) may be possible, but performance should be verified for your parts or assemblies. Factors that may influence performance are configuration and stress sensitivity of components, cooling rates and hold times, and prior temperature history. At the high temperature end, the durability of the cured silicone elastomer is time and temperature dependent. As expected, the higher the temperature, the shorter the time the material will remain useable.

REPAIRABILITY

In the manufacture of electronic devices, it is often desirable to salvage or reclaim damaged or defective units. *Dow Corning* Conformal Coatings offer excellent repairability because they can be removed from substrates and circuitry by scraping or cutting, or by using solvents or stripping agents. If only one circuit component is to be replaced, a soldering iron may be applied directly through the coating to remove the component. Proper ventilation of any fume should be employed. After the circuit board has been repaired, the area should be cleaned by brushing or by using solvent, then dried and recoated. Heat cure coatings can be repaired with RTV coatings, but heat cure coatings may not work well when used to repair RTV coatings.

PACKAGING INFORMATION

Multiple packaging sizes are available for this product. Please contact your local distributor or Dow Corning representative for information on packaging size and availability.

HANDLING PRECAUTIONS

PRODUCT SAFETY INFORMATION REQUIRED FOR SAFE USE IS NOT INCLUDED IN THIS DOCUMENT. BEFORE HANDLING, READ PRODUCT AND MATERIAL SAFETY DATA SHEETS AND CONTAINER

LABELS FOR SAFE USE, PHYSICAL AND HEALTH HAZARD INFORMATION. THE MATERIAL SAFETY DATA SHEET IS AVAILABLE ON THE DOW CORNING WEB SITE AT DOW CORNING.COM, OR FROM YOUR DOW CORNING SALES APPLICATION ENGINEER, OR DISTRIBUTOR, OR BY CALLING DOW CORNING CUSTOMER SERVICE.

LIMITATIONS

This product is neither tested nor represented as suitable for medical or pharmaceutical uses.

HEALTH AND ENVIRONMENTAL INFORMATION

To support Customers in their product safety needs, Dow Corning has an extensive Product Stewardship organization and a team of Product Safety and Regulatory Compliance (PS&RC) specialists available in each area.

For further information, please see our web site, dowcorning.com or consult your local Dow Corning representative.

LIMITED WARRANTY INFORMATION – PLEASE READ CAREFULLY

The information contained herein is offered in good faith and is believed to be accurate. However, because conditions and methods of use of our products are beyond our control, this information should not be used in substitution for customer's tests to ensure that our products are safe, effective, and fully satisfactory for the intended end use. Suggestions of use shall not be taken as inducements to infringe any patent.

Dow Corning's sole warranty is that our products will meet the sales specifications in effect at the time of shipment.

Your exclusive remedy for breach of such warranty is limited to refund of purchase price or replacement of any product shown to be other than as warranted.

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FOR MORE INFORMATION

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