



## Multi-Cure<sup>®</sup> 9451 True Black Conformal Coating

### APPLICATIONS

- Conformal Coating
- Thin Protective Black Coating
- Tamper-Evident Coating

### FEATURES

- UV/Visible Light Cure
- Secondary Heat Cure
- True Black Protective Coating
- Uniform Matte Finish
- UL94 V0 Flammability

### OTHER FEATURES

- Designed for Thin Coatings
- One-Part Coating – No Mixing Needed
- Covers Sensitive Information
- Optimized for Single Pass Coating Up to 0.004”
- Can be Coated Thicker in Multiple Passes

Dymax Multi-Cure<sup>®</sup> 9451 cures upon exposure to light and is designed for conformal coating of printed circuit boards. 9451 is a 100% solids, true black Multi-Cure material specially formulated with a secondary heat cure for applications where shadow areas exist. It is excellent for hiding components and board features, and adheres well to a variety of materials. 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 light-curing spot lamps, focused-beam lamps, or flood lamps, they deliver optimal speed and performance. 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	Black Opaque Liquid	N/A
Soluble in	Organic Solvents	N/A
Density, g/ml	1.10	ASTM D1875
Viscosity, cP (20 rpm)	6,000 (nominal)	DSTM 502‡
Shelf Life at Recommended Conditions from Date of Manufacture	7 months	N/A

### CURED MECHANICAL PROPERTIES \*

Property	Value	Test Method
Durometer Hardness	D80	ASTM D2240
Tensile at Break, MPa [psi]	42.7 [6,200]	ASTM D638
Elongation at Break, %	4.4	ASTM D638
Modulus of Elasticity, MPa [psi]	717 [104,000]	ASTM D638
Glass Transition T <sub>g</sub> , °C	78	ASTM D5418
CTE <sub>α1</sub> , μm/m/°C	59	ASTM E831
CTE <sub>α2</sub> , μm/m/°C	193	ASTM E831

### OTHER CURED PROPERTIES \*

Property	Value	Test Method
Boiling Water Absorption, % (2 h)	0.3	ASTM D570
Water Absorption, % (25°C, 24 h)	1.6	ASTM D570
Flammability	V0	UL 94

### ELECTRICAL PROPERTIES \*

Property	Value	Test Method
Dielectric Constant (1 MHz)	2.86	ASTM D1304
Dissipation Factor (1 MHz)	0.02	ASTM D1304
Dielectric Withstand Voltage, V/mil	47 [1,200]	ASTM D1304
Volume Resistivity, ohm-cm	4.35E+15	ASTM D1304
Surface Resistivity, ohm	1.20E+11	ASTM D1304

### ADHESION

Substrate	Recommendation
FR4	✓
Glass	✓
Stainless Steel	✓

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

\* Not Specifications

N/A Not Applicable

‡ DSTM Refers to Dymax Standard Test Method

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## CURING GUIDELINES

UV-curing guidelines for 9451 at 0.003 in (0.076 mm):

Dymax Curing System (Intensity)	Exposure Time or Belt Speed <sup>A</sup>
BlueWave <sup>®</sup> 200 (10 W/cm <sup>2</sup> ) <sup>A</sup>	3 s
5000-EC (225 mW/cm <sup>2</sup> ) <sup>A</sup>	10 s
UVCS Conveyor with Fusion D lamp (2.5 W/cm <sup>2</sup> ) <sup>B</sup>	2.1 m/min [7 ft/min]
BlueWave <sup>®</sup> LED Flood RediCure <sup>®</sup> 365 nm (580 mW/cm <sup>2</sup> ) <sup>C</sup>	25 s
BlueWave <sup>®</sup> LED Flood PrimeCure <sup>®</sup> 385 nm (850 mW/cm <sup>2</sup> ) <sup>C</sup>	25 s
BlueWave <sup>®</sup> LED Flood VisiCure <sup>®</sup> 405nm (700 mW/cm <sup>2</sup> ) <sup>C</sup>	25 s

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

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

<sup>C</sup> Intensity was measured over the UVA/Visible range (350-3450 nm) using a Dymax ACCU-CAL<sup>™</sup> 50-LED Radiometer.

## 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. The following heat-cure schedule may be used:

Temperature	Time*
110°C [230°F]	60 minutes
120°C [250°F]	30 minutes
150°C [300°F]	15 minutes

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

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 adhesives.

Dymax recommends that customers employ a safety factor by curing longer and/or at higher intensities 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.

## OPTIMIZING PERFORMANCE AND HANDLING

1. This product cures with exposure to UV and visible light. Exposure to ambient and artificial light 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 surfaces in contact with the material should be clean and free from flux residue, grease, mold release, or other contaminants prior to dispensing the material.
3. Cure speed is dependent upon many variables, including lamp intensity, distance from the light source, required depth of cure, thickness, and percent light transmission of components between the material and light source.
4. Oxygen in the atmosphere may inhibit surface cure. Surfaces exposed to air may require high-intensity (>100 mW/cm<sup>2</sup>) UV light to produce a dry surface cure. Flooding the curing 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 or electrical testing.
6. Light curing generally produces some heat. If necessary, cooling fans can be placed in the curing area to reduce the heating effect on components.
7. At the point of curing, an air exhaust system is recommended to dissipate any heat and vapors formed during the curing process.

## 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 cool, dark place when not in use. Do not expose to light. This product may polymerize upon prolonged exposure to ambient and artificial light. Keep covered when not in use. 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.

## CLEAN UP

Uncured material may be removed from dispensing components and parts with organic solvents. 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.

The data provided in this document are based on historical testing that Dymax performed under laboratory conditions as they existed at that time and are for informational purposes only. The data are neither specifications nor guarantees of future performance in a particular application. Dymax does not guarantee that this product's properties are suitable for the user's intended purpose.

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