

Novagard® 800 Series 800-400
UV Cure Silicone
Specification Data



DESCRIPTION

Novagard 800 Series 800-400 is a UV curable silicone sealant. This non-corrosive, single component silicone will cure to a solid elastomer in seconds upon exposure to ultraviolet (UV) light.

APPLICATIONS

- Printed circuit/wiring boards
- Flexible hybrid electronics
- Rigid electronics
- Sensitive components and harsh environments
- Gasketing, sealing

FEATURES & BENEFITS

- Electronics grade
- Exceptionally fast cure
- Room temperature cure
- Single component
- No oxygen inhibition
- 100% solids
- No solvents
- Non-corrosive, neutral cure
- Enhances reliability of delicate components
- Provides stress and shock relief
- Temperature stable from -40°F to 392°F (-40°C to 200°C)

APPLICATION METHOD

Novagard 800 Series 800-400 can be applied by automated needle dispensing, jetting, or hand dispensing.

UV CURE CONDITIONS

All laboratory experiments were conducted using a mercury vapor "H" bulb. A broad-spectrum UV source is strongly recommended. A tack-free surface requires 1,000 mJ/cm² (UVA) in 3-5 seconds at a minimum). Note, that longer exposure times are required for lower-intensity lamp conditions.

LED UV lamp systems may provide a sufficient cure if the output wavelength is near 365 nm and a high-power source is used. Users are responsible to test and validate cure efficacy.

PRODUCT SPECIFICATIONS*

Physical Property	Performance Range
Appearance	Translucent
Form	Paste
Cure Chemistry	UV Only
Shadow Area Cure	No
UV Tracer	No

TYPICAL PROPERTIES*

Physical Property	Test Method	Typical Value
Specific Gravity	ASTM D1875	1.11
Viscosity (cPs)	Brookfield HB #6 @ 10 rpm	300,000
Hardness (Shore A)	ASTM D2240	20
Tensile Strength (psi)	ASTM D412	370
Elongation (%)	ASTM D412	1,200
Extrusion Rate	1/8" orifice @50 psi	>200 g/min

ELECTRICAL PROPERTIES*

Electrical Property	Test Method	Typical Value
Dielectric Strength	ASTM D149	14.9 kV/mm 378 V/mil
Dielectric Constant at 100 Hz	ASTM D150	0.0011
Dielectric Constant at 100 kHz	ASTM D150	0.0021
Dissipation Factor at 100 Hz	ASTM D150	3.34
Dissipation Factor at 100 kHz	ASTM D150	3.33
Volume Resistivity (Ω cm)	ASTM D257	3.01 x 10 ¹³

* The values outlined reflect testing that was conducted under laboratory conditions, actual results may vary. Results are after UV cure.

(continued on page 2)

Depth of Cure

UV curable silicones require UV waves to penetrate the silicone in order to initiate a cure. Therefore, the depth of cure is limited by UV wave transmittance. Most of our UV cure silicones can be sufficiently cured to depths of ~9 mm at 1000 mJ/cm² depending on formulation ingredients.

TYPICAL SURFACE PREPARATION

Novagard 800 Series 800-400 can be applied to cleaned and “no clean” surfaces. It is recommended to test this product for compatibility with all contact surfaces.

Clean Up

Common solvents such as isopropyl alcohol (IPA), odorless mineral spirits (OMS), or acetone can be used to help with the cleanup of uncured silicone. For cured silicone, soften the silicone first with solvent and then brush or scrape away.

Repairability

Novagard UV-curable silicone conformal coatings and sealants are repairable and can be removed from substrates and circuitry by scraping or cutting. Additionally, one can use solvents to swell the silicone making it much easier to scrape or brush away from the surface. This method can be used for circuit boards where a component requires replacement. Once a component is replaced, fresh silicone can be brushed or poured on the bare component and then cured.

ADDITIONAL INFORMATION

Useful Temperature Ranges

Silicones withstand extremely high and low temperatures with little to no property change due to its non-reactive and stable structure. Most Novagard silicones have an operational temperature range of -40°F to 392°F (-40°C to 200°C) for long periods of time. This can vary, however, depending on the formulation, configuration, and stress sensitivity of components in the application, in addition to cooling rates, hold times, and prior temperature history.

Novagard believes that the information provided is a true and accurate description of the typical characteristics of the aforementioned product; however, it is the responsibility of the individual user to thoroughly test the product in their specific application to determine performance, efficacy, and safety.

PACKAGING

Novagard 800 Series 800-400 is available in 310 ml cartridges (10-ounce) and 5-gallon pails. Samples are typically provided in 30 cc hybrid syringes although larger sample sizes may be an option. If you require a different package size for a long-term commercial purchase, contact your Novagard representative.

STORAGE AND SHELF LIFE

Novagard 800 Series 800-400 when stored in its original, unopened container at or below 80°F (27°C) is usable for up to twelve (12) months. Refrigeration down to 37°F (3°C) may prolong the shelf life of the material in unopened, original packaging, and usefulness must be determined by the end user.

CUSTOMIZATION

As the largest R&D group in our class, we have significant expertise and experience in a wide array of technical disciplines. Our team includes experienced Ph.D. scientists and engineers along with subject matter experts who can customize our family of UV and UV dual cure silicone products to fit your exact needs.

Any of our UV or UV dual cure silicone products may be modified with adhesion promoters designed for specific substrates, even low-energy substrates like polyethylene terephthalate (PET). In addition to modifying the adhesion profiles of any of our UV or UV dual cure silicone products, we can also adjust any of the following physical properties as needed:

Uncured:	Cured:
• Viscosity	• Shore hardness
• Thixotropy	• Tensile strength
• Pot life	• Adhesion
• UV tracer	• Elongation

Contact us at (216) 881-8111 or products@novagard.com. We'd be happy to discuss your specific project.

COMPLIANCE INFORMATION

Novagard 800 Series 800-400 does not contain any substances included on the most recently published REACH “Candidate List of Substances of Very High Concern”.

Novagard 800 Series 800-400 does not contain any chemicals on the Prop65 list at a level requiring special labeling.

PRECAUTIONS

Consult and obey all applicable local, state, and federal regulations for the disposal of solvent and silicone waste. For additional information consult the product safety data sheet (S.D.S).