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**TECHNICAL DATA SHEET
ELECTRAMASK
EP 4040**

2-COMPONENT HI – SLIP SOLDERMASK RANGE

PRODUCT DESCRIPTION

EP4040 Series is a high definition, 2-component soldermask based on modern epoxy technology noted for its extremely fast cure speed and superior chemical/electrical resistance. It is formulated for use on copper and tin-lead substrates and is designed to withstand the hardest environmental conditions.

FEATURES & ADVANTAGES:

- **Long pot life.** 2-component mixture remains useable for at least 48 hrs at room temperature.
- **Increased screen stability.** No mid-shift wash-ups or staining of screen mesh.
- **High solids.** EP4040 Series has a solids content of 85% enabling thick coatings of up to 25µm to be produced with 1 layer.
- **Thixotropic.** EP4040 Series is extremely thixotropic, allowing excellent print definition with no bleed.
- **No bleed.** Resin systems have been carefully selected to give no bleed, even during racking of panels.
- **Fast curing.** EP4040 Series cures to give an exceptionally hard surface which is resistant to scratching during all subsequent processes.
- **NO aromatic amines.** Contains no DDM/MDA



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PROCESSING

Mixing:

EP4040 is supplied pre-weighed in 1Kg packs for safe and easy mixing. If smaller quantities are required EP4040 should be mixed in the ratio 9:1, paste:hardener, by weight.

Important: Mix paste and hardener until homogenous. Incomplete mixing will impair performance. E.g. Poor adhesion to substrate, Poor chemical resistance, Patchy colour/finish.

Pot-life:

EP4040	72 hrs after mixing.
EP4040 +H-1413	48 hrs after mixing.

Viscosity adjustment:

Viscosity may be adjusted using Electrareducer ER1. No more than 5% reducer should be added or deterioration of printing and curing properties may occur.

Board surface preparation:

Copper boards should be brushed or micro etched to give a water-break free surface.
Tin/lead Boards should be thoroughly degreased using detergent/water or solvent cleaning methods.

Printing: Mesh: 43 - 77T polyester Squeegee: 65- 75 Shore



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EP4040 should be printed using a 43-55T polyester mesh when printing over tin/lead boards. When printing over copper, finer meshes are normally recommended, typically 55-77T, depending on film weight required. When printing over high-tracks, use a soft squeegee of 65 Shore hardness made of polyurethane or rubber. Best results are obtained by setting the squeegee blade at an angle of 10 - 20 degrees to the vertical, variable according to desired paste deposit on the board against decline in definition sharpness. Capillary stencils and emulsions have been found to give best results both for durability and definition, when printing the uneven profile of plated boards.

Both definition sharpness and desired heavy filmweight may be achieved by supporting the back of the squeegee with a strip of rigid metal or plastic to prevent the squeegee blade bending during the print stroke. Using as slow a squeegee speed as is practicable and turning the board under the screen so that the majority of the tracks are at an angle of 10 - 20 degrees to the direction of printing will enable the soldermask to flow into the track edges and corners avoiding air entrapment, and ensuring encapsulation of the tracks. If the printing machine has a scoop option it should be used in favour of a flood stroke as this will aid filling between tracks.

Curing:

(1) EP4040 range (2.1) **H-1413 hardener**

Convection oven:	10 mins at 150°C
Infra red oven	1 - 2 mins at 160-180°C

Important: **All stated cure cycles are time at board temperature. Oven checks should be carried out to determine the time taken for boards to reach the desired temperature.**

Tin/lead boards may require longer cure times under IR to ensure complete cure on FR4 substrate.

Infra red: IR drying is dependent on coating deposit, IR wavelength and IR intensity. Please contact Electra Technical Service Department for recommendations.

SHELF LIFE:

Minimum 12 months from date of manufacture, when stored in cool dry conditions



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CLEAN-UP:

After printing the screen and stencil should be cleaned of residual soldermask using Universal Screenwash SW100.

STORAGE:

Store between 10°C - 25°C in a dry store. Avoid subjecting containers to temperatures below 5°C because of risk of splitting.

FINAL PROPERTIES

Physical properties

Pencil Hardness: 5-6H
Solder resistance: >20s @ 260°C
(IPC SM840A III) >30s @ 274°C
Flux resistance: No degradation
(IPC SM840A III)
Solvent resistance: No degradation
against CFCs &
alcohols.
(IPC SM840A III)

Flammability: E95722

Electrical properties

Dielectric strength: 45kvmm⁻¹
Dielectric loss factor: 0.02 @ 1MHz
Surface resistivity: 10¹⁴ Ω
Volume resistivity: 10¹⁶ Ωcm⁻¹
Moisture & insulation
resistance (IPC SM840A): >10¹⁰ Ω
Dielectric constant: 3.4 @ 1MHz

UL 94 V0



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