

HumiSeal® 1A33 Gel

Technical Data Sheet

HumiSeal® 1A33 Gel is a single component thixotropic polyurethane paste, suitable for general printed circuit board applications. HumiSeal® 1A33 Gel contains no free isocyanates. HumiSeal® 1A33 Gel fluoresces under UV light for easy inspection. HumiSeal® 1A33 Gel is in full compliance with the RoHS 2011/65/EU Directive.

Properties of HumiSeal® 1A33 Gel

Solids Content, % by weight per Fed-Std-141, Meth. 4044	44 ± 2 %
VOC	521 grams/litre
Optional Curing Conditions to Reach Optimum Properties	30 days at RT
	30 hours @ 76°C
	20 hours @ 87°C
Dielectric Withstand Voltage, per MIL-I-46058C (mod.)	> 5000V
Dielectric Breakdown	42 KV/mm
Recommended Stripper	HumiSeal® Stripper 1063
Shelf Life at Room Temperature, DOM	12 months

Application of HumiSeal® 1A33 Gel

HumiSeal 1A33 Gel can be successfully applied to substrates that have been cleaned prior to application and to substrates with low residue, “no clean” assembly materials. Users should perform adequate testing to confirm compatibility between HumiSeal 1A33 Gel and their particular assembly, materials, process conditions and cleanliness levels. Please contact HumiSeal for additional information.

Syringe Application

HumiSeal® 1A33 Gel is intended for automated needle dispensing, but may also be applied manually.

Syringe Filling Process

If using the HumiSeal® 1A33 Gel in an automated or semi-automated needle dispensing system, the bulk material should be placed into syringes before use. For best results, it is recommended that the syringes be centrifuged after filling from the bulk container. This will ensure the material inside the syringe is free of bubbles.

The basic syringe filling process is as follows:

- Using a micro-spatula or similar tool, transfer small amounts of HumiSeal® 1A33 Gel at a time into a new syringe with the piston removed. Fill to approximately two thirds of the volume of the syringe.
- Insert the piston into the syringe and seat until the piston is flush with the HumiSeal® 1A33 Gel.
- Centrifuge the syringes for a minimum of 5 minutes @ 3500 rpm.
- Upon completion of the centrifuge cycle, gently reseat the piston by applying even downward pressure on the piston until it mates with the HumiSeal® 1A33 Gel.

For further information or assistance on the syringe filling or centrifuge process please contact HumiSeal Technical Support.

Storage

HumiSeal® 1A33 Gel should be stored away from excessive heat or cold, in tightly closed containers. HumiSeal® products may be stored at temperatures of 0 to 35°C. Prior to use, allow the product to equilibrate for 24 hours at a room temperature of 18 to 32°C.

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Caution

Application of HumiSeal® 1A33 Gel should be carried out in accordance with local and National Health and Safety regulations.

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