

PSR-4000BN Series *(UL Name: PSR-4000BN / CA-40 BN)*

LIQUID PHOTOIMAGEABLE SOLDER MASK

- ③ **Screen or Spray Application**
- ③ **Available in Green or Dark Green**
Semi- Gloss Finish
- ③ **RoHS Compliant**
- ③ **High Viscosity version for improved edge coverage on High Traces**
- ③ **Compatible with Lead-Free Processing**
- ③ **Best In Class for Small Hole Clearing**
- ③ **Wide Processing Window**
- ③ **Fine Dam Resolution**
- ③ **Withstands ENIG & Immersion Tin**

PROCESSING PARAMETERS FOR PSR-4000BN SERIES

PSR-4000BN Series includes **PSR-4000BN**, **PSR-4000BN (HV)**, and **PSR-4000BN (DG)**. They are two-component, alkaline developable LPI solder mask products for flood screen and spray application methods. The products are designed to be user friendly with wide processing latitudes, low odor, fast developing and good resistance to alternate metal finishes such as ENIG and immersion Tin while maintaining dams of 3 mils or less. The **PSR-4000 BN (HV)** provides improved edge coverage over high circuits while the **PSR-4000BN (DG)** provides the same benefit in a Dark Green color. **PSR-4000BN Series** meets or exceeds the requirements of IPC SM-840E Class H and Class T, Bellcore GR-78-CORE Issue 1, and has a UL flammability rating of 94V-0. All Taiyo America products comply with the Directive 2002/95/EC of the European Parliament and of the Council of 27 January 2003 on the Restriction of the use of certain Hazardous Substances (RoHS) in electrical and electronic equipment.

PSR-4000BN SERIES COMPONENTS	PSR-4000BN Series/ CA-40BN		
	Mixing Ratio	100 parts	43 parts
Color	Green		White
Mixed Properties	BN	HV	DG
Solids	77%	77%	77%
Viscosity	135-165ps	175-225ps	175-225ps
Specific Gravity	1.39	1.39	1.39

MIXING

PSR-4000BN Series is supplied in pre-measured containers with a mix ratio by weight of 100 parts **PSR-4000BN** and 43 parts **CA-40BN**. **PSR-4000BN** can be mixed by hand with a mixing spatula for 10 – 15 minutes. Mixing can be done with a mechanical mixer at low speeds to minimize shear thinning for 10 – 15 minutes. Also, mixing can be done with a paint shaker for 10 – 15 minutes.

Pot life after mixing is 72 hours when stored in a dark place at $\leq 20^{\circ}\text{C}$ (68°F).

PRE-CLEANING

Prior to solder mask application, the printed circuit board surface needs to be cleaned. Various cleaning methods include Pumice, Aluminum Oxide, Mechanical Brush, and Chemical Clean. All of these methods will provide a clean surface for the application of **PSR-4000BN Series**. Hold time after cleaning the printed circuit board should be held to a minimum to reduce the oxidation of the copper surfaces.

PROCESSING PARAMETERS FOR PSR-4000BN SERIES

- SCREEN PRINTING** Method: Single Sided and Double Sided Screening
- Screen Mesh: 83 – 110
 - Screen Mesh Angle: 22.5° Bias
 - Screen Tension: 20 - 28 Newtons
 - Squeegee: 60 – 80 durometer
 - Squeegee Angle: 27 – 35°
 - Printing Mode: Flood / Print / Print
 - Flood Pressure: 20 – 30 psi
 - Printing Speed: 2.0 – 9.9 inches/sec
 - Printing Pressure: 65 – 100 psi
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- TACK DRY CYCLE** The Tack Dry step is required to remove solvent from the solder mask film and produce a firm dry surface. The optimum dwell time and oven temperature will depend on oven type, oven loading, air circulation, exhaust rate, and ramp times. Excessive tack dry times and temperature will result in difficulty developing solder mask from through holes and a reduction in photo speed. Insufficient tack dry will result in artwork marking and/or sticking. Typical tack dry conditions for **PSR-4000BN Series** are as follows:
- Oven Temperature: 150 - 185°F (65 - 85°C)
 - For Single-Sided (Batch Oven)
 - 1st Side: Dwell Time: 15 - 20 minutes
 - 2nd Side: Dwell Time: 25 - 45 minutes
 - For Double-Sided (Conveyorized or Batch Oven)
 - Dwell Time: 40 - 65 minutes
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- EXPOSURE** **PSR-4000BN Series** requires UV exposure to define solder mask dams and features. The spectral sensitivity of **PSR-4000BN Series** is in the area of 365 nm. Exposure times will vary by bulb type and age of the bulb. Below are guidelines for exposing **PSR-4000BN Series**.
- Exposure Unit: 5 kW or higher
 - Stouffer Step 21: Clear 10 minimum (on metal / under phototool)
 - Energy: 250mJ / cm² minimum (under phototool)

TECHNICAL DATA SHEET



PROCESSING PARAMETERS FOR PSR-4000BN SERIES

DEVELOPMENT **PSR-4000BN Series** is developed in an aqueous sodium or potassium carbonate solution. Developing can be done in either a horizontal or vertical machine.

- Solution: 1% by wt. Sodium Carbonate or 1.2% Potassium Carbonate
- pH: 10.6 minimum, to
- Temperature: 85 - 105°F (29 - 41°C)
- Spray Pressure: 25 - 45 psi
- Dwell Time in developing chamber: 45 - 90 seconds
- Water rinse is needed to remove developer solution followed by a drying step

FINAL CURE **PSR-4000BN** requires a thermal cure to insure optimal final property performance. Thermal curing can be done in a batch oven or conveyORIZED oven.

- Temperature: 275 – 300°F (135 – 149°C)
- Time at Temperature: 45 – 60 minutes

For Process Optimization please contact your local Taiyo America Representative

Taiyo America, Inc. (TAIYO) warrants its products to be free from defects in materials and workmanship for the specified warranty period (**PSR-4000BN / CA-40BN Warranty period is 12 Months**) provided the customer has, at all times, stored the ink at a temperature of 68°F(20°C) or less. TAIYO accepts no responsibility or liability for damages, whether direct, indirect, or consequential, resulting from failure in the performance of its products. If a TAIYO product is found to be defective in material or workmanship, its liability is limited to the purchase price of the product found to be defective. TAIYO MAKES NO OTHER WARRANTY, EXPRESS OR IMPLIED, AND MAKES NO WARRANTY OF MERCHANTABILITY OR OF FITNESS FOR ANY PARTICULAR PURPOSE. TAIYO'S obligation under this warranty shall not include any transportation charges or costs of installation or any liability for direct, indirect, or consequential damages or delay. If requested by TAIYO, products for which a warranty claim is made are to be returned transportation prepaid to TAIYO'S factory. Any improper use or any alteration of TAIYO'S product by the customer, as in TAIYO'S judgment affects the product materially and adversely, shall void this limited warranty.

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FINAL PROPERTIES FOR PSR-4000BN

IPC-SM-840E, Class H & T, Solder Mask Vendor Testing Requirements

TEST	SM-840 PARAGRAPH	REQUIREMENT	RESULT
Visual	3.3.1	Uniform in Appearance	Pass
Curing	3.2.5.1	Ref: 3.6.1.1, 3.7.1 and 3.7.2	Pass
Non-Nutrient	3.2.6	Does not contribute to biological growth	Pass
Pencil Hardness	3.5.1	Minimum "F"	Pass – 8H
Adhesion	3.5.2	Rigid – Cu, Ni, FR-4	Pass
Machinability	3.5.3	No Cracking or Tearing	Pass
Resistance to Solvents and Cleaning Agents	3.6.1.1	Table 3 Solvents	Pass
Hydrolytic Stability and Aging	3.6.2	No Change after 28 days of 95-99°C and 90-98% RH	Pass
Solderability	3.7.1	No Adverse Effect J-STD-003	Pass
Resistance to Solder	3.7.2	No Solder Sticking	Pass
Resistance to Solder	3.7.3	No Solder Sticking	Pass
Simulation of Lead Free Reflow	3.7.3.1	No Solder Sticking	Pass
Dielectric Strength	3.8.1	500 VDC / mil Minimum	2800 VDC/mil
Thermal Shock	3.9.3	No Blistering, Cracking or De-lamination	Pass

Specific Class "H" Requirements

TEST	SM-840 PARAGRAPH	REQUIREMENT	RESULT
Flammability	3.6.3	UL 94V-0	Pass – File #E166421
Insulation Resistance Before Soldering	3.8.2	5 x 10 ⁸ ohms minimum	Pass (1.29 x 10 ¹³ ohms)
Insulation Resistance After Soldering	3.8.2	5 x 10 ⁸ ohms minimum	Pass (3.31 x 10 ¹³ ohms)
Moisture & Insulation Resistance Before Soldering–In Chamber	3.9.1	5 x 10 ⁸ ohms minimum	Pass (6.61 x 10 ¹⁰ ohms)
Moisture & Insulation Resistance Before Soldering–Out of Chamber	3.9.1	5 x 10 ⁸ ohms minimum	Pass (2.50 x 10 ¹² ohms)
Moisture & Insulation Resistance After Soldering–In Chamber	3.9.1	5 x 10 ⁸ ohms minimum	Pass (1.89 x 10 ¹⁰ ohms)
Moisture & Insulation Resistance After Soldering–Out of Chamber	3.9.1	5 x 10 ⁸ ohms minimum	Pass (1.07 x 10 ¹³ ohms)
Electrochemical Migration	3.9.2	>2.0 x 10 ⁶ ohms, no dendritic growth	Pass (1.35 x 10 ¹² ohms)

Specific Class "T" Requirements

TEST	SM-840 PARAGRAPH	REQUIREMENT	RESULT
Flammability	3.6.3	Bellcore O ₂ Index – 28 minimum	Pass – 74
Insulation Resistance Before Soldering	3.8.2	5 x 10 ⁸ ohms minimum	Pass (2.23 x 10 ⁹ ohms)
Insulation Resistance After Soldering	3.8.2	5 x 10 ⁸ ohms minimum	Pass (1.14 x 10 ¹³ ohms)

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FINAL PROPERTIES FOR PSR-4000BN

Specific Class “T” Requirements

TEST	SM-840 PARAGRAPH	REQUIREMENT	RESULT
Moisture & Insulation Resistance Before Soldering–In Chamber Before Soldering–Out of Chamber After Soldering-In Chamber After Soldering-Out of Chamber	3.9.1	5 x 10 ⁸ ohms minimum 5 x 10 ⁸ ohms minimum 5 x 10 ⁸ ohms minimum 5 x 10 ⁸ ohms minimum	Pass (1.77 x 10 ⁹ ohms) Pass (1.80 x 10 ¹³ ohms) Pass (2.78 x 10 ¹⁰ ohms) Pass (2.31 x 10 ¹³ ohms)
Electrochemical Migration	3.9.2	< 1 decade drop, no dendritic growth	Pass

Additional Tests / Results

TEST	REQUIREMENT	RESULT	
CTI (Comparative Tracking Index)	ASTM-D-3638-07	450 Volts	
Dielectric Constant	Internal Test at 1 GHz	3.9	
Dissipation Factor	Internal Test at 1 GHz	0.0270	
Tg	Internal Test	125°C	
CTE	Internal Test (α1 / α2)	70/140 ppm	
Outgassing Test ASTM E-595-90 A 2 J/cm ² UV Cure was done after thermal cure	TML ≤ 1 % CVCM ≤ 0.10%	TML-0.51% CVCM-0.02%	
Electroless Nickel / Immersion Gold Resistance	Nickel (85C/30 min) Tape Test Adhesion	Pass	
Solvent Resistance	Acetone: MEK: IPA: PMA:	No attack – 24 hours No attack – 24 hours No attack – 24 hours No attack – 24 hours	Pass Pass Pass Pass
Acid Resistance	HCl – 10%: H ₂ SO ₄ – 10%:	No attack – 30 Minutes No attack – 30 Minutes	Pass Pass
Base Resistance	NaOH – 10%: Boiling Water Resistance:	No attack – 30 Minutes No attack – 15 Minutes	Pass Pass
Solder / Flux Resistance (Alphametals)	Alpha 857 water soluble: NR060 no-clean: 3355-NB rosin-based: NR-3000A4 no-clean:	No attack – 1 x 10 sec float (260C) No attack – 1 x 10 sec float (260C) No attack – 1 x 10 sec float (260C) No attack – 1 x 10 sec float (260C)	Pass Pass Pass Pass
Solder / Flux Resistance (Multicore)	X32-10M no-clean: X32-06I no-clean:	No attack – 1 x 10 sec float (260C) No attack – 1 x 10 sec float (260C)	Pass Pass
Solder/Flux Resistance-(Sanwa)	SR-270 rosin-based:	No attack – 1 x 10 sec float (260C)	Pass
Conformal Coating Adhesion: Humiseal 1 B31 acrylic: Humiseal 1A20 urethane: Dow Corning 3-1753 silicone:	Crosscut (10/10) after tape Crosscut (10/10) after tape Crosscut (10/10) after tape	100/100 100/100 100/100	
Glue Dot Adhesion – Loctite 3609	Adhesion of Glue Dot to PSR-4000BN	Excellent	