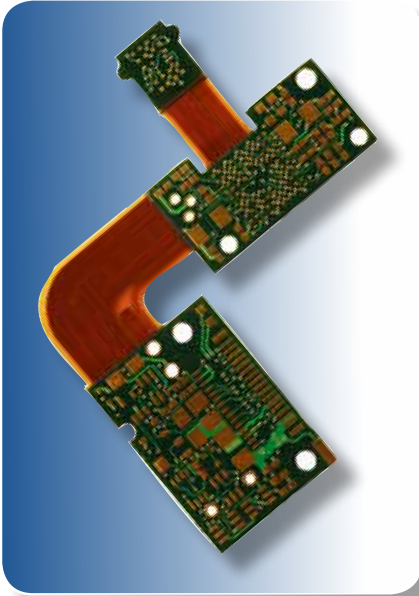
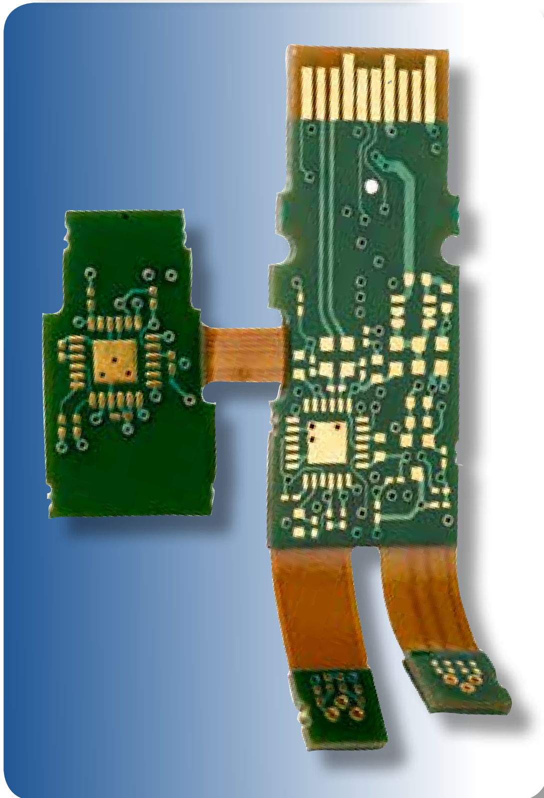
49N

Multifunctional Epoxy Low-Flow Prepreg



49N is a low-flow epoxy prepreg engineered for bonding multilayer epoxy rigid-flex or attaching heat- sinks to multilayer epoxy PCBs. With a high Tg, the prepreg can be used in high-performance or high- temperature applications compared to a standard difunctional epoxy low-flow.



Features:

- Multifunctional epoxy resin system with a Tg of 170°C offers improved high-temperature and PTH reliability
- Engineered with discrete low ranges and various fiberglass styles to optimize flexibility
- Electrical and mechanical properties meeting the requirements of IPC-4101/24, modified to be "Low-Flow"
- RoHS/WEEE compliant
- Short cure (45 minutes at 360°F) for improved manufacturing productivity

Typical Applications:

- Bonding multilayer epoxy rigid-flex
- Bonding adhesiveless epoxy rigid-flex
- Attaching heat sinks to multilayer PCBs

Typical Properties:

Property	Units	Value	Test Method
1. Electrical Properties			
Dielectric Constant			
@ 1 MHz	-	4.3	IPC TM-650 2.5.5.3
@ 1 GHz	-		IPC TM-650 2.5.5.9
Dissipation Factor			
@ 1 MHz	-	0.022	IPC TM-650 2.5.5.3
@ 1 GHz	-		IPC TM-650 2.5.5.9
Volume Resistivity			
C96/35/90	MΩ-cm	5.1×10^7	IPC TM-650 2.5.17.1
E24/125	MΩ-cm	7.4×10^7	IPC TM-650 2.5.17.1
Surface Resistivity			
C96/35/90	MΩ	8.8×10^6	IPC TM-650 2.5.17.1
E24/125	MΩ	1.5×10^6	IPC TM-650 2.5.17.1
Electrical Strength	Volts/mil (kV/mm)	1000 (39.4)	IPC TM-650 2.5.6.2
Dielectric Breakdown	kV		IPC TM-650 2.5.6
Arc Resistance	sec		IPC TM-650 2.5.1
2. Thermal Properties			
Glass Transition Temperature (Tg)			
TMA	°C		IPC TM-650 2.4.24
DSC	°C	130	IPC TM-650 2.4.25
Decomposition Temperature (Td)			
Initial	°C	295	IPC TM-650 2.3.41
5%	°C	315	IPC TM-650 2.3.41
T260	min	18	IPC TM-650 2.4.24.1
T288	min		IPC TM-650 2.4.24.1
T300	min		IPC TM-650 2.4.24.1
CTE (X,Y)	ppm/°C	15-17	IPC TM-650 2.4.41
CTE (Z)			
< Tg	ppm/°C	85	IPC TM-650 2.4.24
> Tg	ppm/°C		IPC TM-650 2.4.24
z-axis Expansion (50-260°C)	%		IPC TM-650 2.4.24
3. Mechanical Properties			
Peel Strength to Copper (1 oz/35 micron)			
After Thermal Stress	lb/in (N/mm)	9.0 (1.6)	IPC TM-650 2.4.8
At Elevated Temperatures	lb/in (N/mm)		IPC TM-650 2.4.8.2
After Process Solutions	lb/in (N/mm)		IPC TM-650 2.4.8
Young's Modulus	Mpsi (GPa)	2.6 (17.9)	IPC TM-650 2.4.18.3
Tensile Strength CD/MD	kpsi (MPa)	6.5 (45)	IPC TM-650 2.4.18.3
Poisson's Ratio	-	0.17	ASTM D-3039
4. Physical Properties			
Water Absorption (0.062")	%	0.1	IPC TM-650 2.6.2.1
Specific Gravity	g/cm3	1.35	ASTM D792 Method A
Thermal Conductivity	W/mK	0.25	ASTM E1461
Flammability	class	V-O	UL-94

Results listed above are typical properties, provided without warranty, expressed or implied, and without liability. Properties may vary, depending on design and application. Arlon reserves the right to change or update these values.

Availability:

Arlon Part Number	Glass Style	Resin %	Flow	Thickness
49N067201	106	72	0.030” – 0.090”	0.0023”
49N806501	1080	65	0.030” – 0.090”	0.0034”
49N067202	106	72	0.060” – 0.120”	0.0023”
49N806502	1080	65	0.060” – 0.120	0.0034”

Recommended Process Conditions:

Process inner-layers through develop, etch, and strip using standard industry practices. Bake inner layers in a rack for 60 minutes at 225°F - 250°F (107°C - 121°C) immediately prior to lay-up. Vacuum desiccate the prepreg for 8 - 12 hours prior to lamination.

Lamination Cycle:

1) Pre-vacuum for 30 - 45 minutes

2) Control the heat rise to 8°F - 12°F (4°C - 6°C) per minute between 150°F and 250°F (65°C and 121°C)

3) Lamination Pressure: 150-300 PSI (11-21 Kg/cm2) depending on complexity

4) Product temperature at start of cure = 360°F (182°C).

5) Cure time at temperature = 45 minutes

6) Cool down under pressure at ≤ 10°F/min (6°C/min)

Drill at 350-400 SFM. Undercut bits are recommended for vias 0.023” (0.9cm) and smaller

De-smear using alkaline permanganate or plasma with settings appropriate for epoxy;
plasma is preferred for positive etchback

Conventional plating processes are compatible with 49N

Standard profiling parameters may be used; chip breaker style router bits are not recommended

Bake for 1 - 2 hours at 250°F (121°C) prior to solder reflow or HASL

Optimal processing requirements may vary depending on specific equipment and operating conditions. These recommendations are offered only as a starting point.

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For samples, technical assistance, customer service or for more information, please contact Arlon Materials for Electronics Division at the following locations:

NORTH AMERICA:

Arlon LLC
Electronic Substrates
9433 Hyssop Drive
Rancho Cucamonga, CA 91730
Tel: (909) 987-9533
Fax: (909) 987-8541

Arlon LLC
Microwave Materials
1100 Governor Lea Road
Bear, DE 19701
Tel: (800) 635-9333
Outside U.S. & Canada: (302) 834-2100
Fax: (302) 834-2574

NORTHERN EUROPE:

Arlon LLC
44 Wilby Avenue
Little Lever
Bolton, Lancashire BL31QE
United Kingdom
Tel: (44) 120-457-6068
Fax: (44) 120-479-6463

SOUTHERN CHINA:

Arlon LLC
Room 601, Unit 1, Bldg 6
Liyuan, Xincun Shahe
Shenzhen, China 518053
Tel: (86) 755-269-066-12
Fax: (86) 755-26910475

NORTHERN CHINA:

Arlon LLC
Room 11/401, No. 8
Hong Gu Road
Shanghai, China 200336
Tel/Fax: (86) 21-6209-0202

SOUTHERN EUROPE:

Arlon LLC
6 cours des Juilliottes
94700 Maisons-Alfort France
Phone : (33) 1 84 23 41 51
Fax: (33) 9 55 62 43 26

www.arlon-med.com

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