**Technical Information**

**Description**
Sheet adhesive in the DuPont™ Pyralux® product line is a proprietary B-staged modified acrylic adhesive coated on release paper. Sheet adhesive is used primarily to bond flexible innerlayers or rigid cap layers in multilayer lamination. It is also widely used to bond flexible circuits to rigid boards during the fabrication of rigid-flex circuits, as well as to bond stiffeners and heat sinks.

**Construction**
Sheet adhesive is available in a variety of thicknesses; see Table 1. The product code must be used when ordering sheet adhesive from DuPont.

**Table 1**

<table>
<thead>
<tr>
<th>Product Code*</th>
<th>Adhesive (Mil/µm)</th>
<th>Certification*</th>
</tr>
</thead>
<tbody>
<tr>
<td>LF0100</td>
<td>1 (25)</td>
<td>Yes</td>
</tr>
<tr>
<td>LF0200</td>
<td>2 (51)</td>
<td>Yes</td>
</tr>
<tr>
<td>LF0300</td>
<td>3 (76)</td>
<td>Yes</td>
</tr>
<tr>
<td>LF0400</td>
<td>4 (102)</td>
<td>Yes</td>
</tr>
<tr>
<td>LF1500</td>
<td>1/2 (13)</td>
<td>Yes</td>
</tr>
<tr>
<td>LF1700</td>
<td>.7 (18)</td>
<td>Yes</td>
</tr>
</tbody>
</table>

*Certified to IPC-4203/18: “Adhesive Coated Dielectric Films for Use as Cover Sheets for Flexible Printed Circuitry and Flexible Adhesive Bonding Films.”

**Packaging**
Sheet adhesive is supplied on 24 inch (610 mm) wide by 250 feet (76 m) long rolls, on nominal 3 inch (76 mm) cores. Narrower widths or cut sheets are also available by special order.

**Typical Data**
Each manufactured lot of sheet adhesive is certified to IPC specifications and tested according to IPC Test Method TM-650. See Table 2.

**Table 2**

<table>
<thead>
<tr>
<th>Sheet Adhesive Properties vs IPC Specifications</th>
</tr>
</thead>
<tbody>
<tr>
<td>Adhesive Property</td>
</tr>
<tr>
<td>Peel Strength*, min., lb/in (kg/cm)</td>
</tr>
<tr>
<td>As received</td>
</tr>
<tr>
<td>After solder</td>
</tr>
<tr>
<td>Solder Resistance 10 sec at 288°C (550°F)</td>
</tr>
<tr>
<td>Adhesive Flow, max. mil/mil adhesive (µm/µm)</td>
</tr>
<tr>
<td>Dielectric Constant, max. (at 1 MHz)</td>
</tr>
<tr>
<td>Dissipation Factor, max. (at 1 MHz)</td>
</tr>
<tr>
<td>Dielectric Strength volts/mil (kV/mm)</td>
</tr>
<tr>
<td>Insulation Resistance megarhm</td>
</tr>
<tr>
<td>Volume Resistivity, min., megarhm·cm (ambient)</td>
</tr>
<tr>
<td>Surface Resistivity, min., megarhm·cm (ambient)</td>
</tr>
</tbody>
</table>

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A Certificate of Analysis is available with every batch. Complete material and manufacturing records for each lot, with samples of finished laminate, are retained for reference purpose. The roll labels contain the lot number, DuPont order number, customer order number, IPC specification, customer specification, and customer part number; save these labels for reference in case of inquiries.

**Processing**
Laminating conditions for Pyralux® flexible composites are typically in the following ranges:

- **Part Temperature:** 182–199°C (360–390°F)
- **Pressure:** 14–28 kg/cm² (200–400 psi)
- **Time:** 1–2 hours, at temperature

For further processing information contact your DuPont representative to receive a Pyralux® Technical Manual.
Storage Conditions and Warranty
DuPont™ Pyralux® LF flexible laminates should be stored in the original packaging at temperatures of 4–29°C (40–85°F) and below 70% humidity. The product should not be frozen and should be kept dry, clean and well protected. Subject to compliance with the foregoing handling and storage recommendations, DuPont’s warranties as provided in the DuPont Standard Conditions of Sale shall remain in effect for a period of two years following the date of shipment.

Safe Handling
Pyralux® sheet adhesive contains a B-staged adhesive. Because B-staged adhesive contains trace quantities (parts per million) of unreacted monomers, precautions and recommendations should be taken to minimize contact.

DuPont is not aware of anyone developing contact dermatitis, or suffering any other medical discomforts, when using Pyralux® products. The uncured acrylic monomers in the bond ply adhesive may impart a mild odor. However, these products have been extensively tested under operating conditions (drilling and lamination conditions) and found to liberate measurable volatiles only well below1 accepted safe limits (e.g., PEL).

For more information on DuPont™ Pyralux® flexible circuit materials, please contact your local representative, or visit our website:

Americas
DuPont Electronic Technologies
14 T. W. Alexander Drive
Research Triangle Park, NC 27709
Tel: 800-243-2143

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Sanno Park Tower
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Chiyoda-ku, Tokyo 100-6111
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DuPont Taiwan Hsinchu Branch.
#2, Li-Hsin 4th Rd., Hsinchu Science Park,
Hsinchu 30078, Taiwan
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To eliminate contact between the skin and the adhesive, wear lint-free gloves or fingerpads. Anyone handling Pyralux® should wash their hands with soap before eating, smoking, or using restroom facilities. Gloves and fingerpads should be changed daily, and wash other protective clothing frequently.

Adequate ventilation and exhaust is recommended in press rooms to prevent the buildup of potentially harmful vapors, to remove disagreeable odors, and to dissipate heat. Drill rooms should be furnished with standard equipment recommended by drill vendors and required by OSHA standards.

For further information on safe handling, refer to DuPont publication H-46862, “Pyralux® LF and FR Safe Handling,” and refer to “Industrial Ventilation,” 18th Edition or latest available from the American Conference of Governmental Industrial Hygienists, 6500 Glenway, Building D-5, Cincinnati, OH 45211.

1Values for all materials monitored were well below 10% of their accepted limits (PEL or TLV). In only one case, did the concentration reach approximately 40% of its limit. This was an oven used to dry the uncured acrylic material. This oven drying is not normally used in the process and during the exposure the oven was unventilated. Adequate ventilation is normally recommended for any heating process.