



PROCESSING INFORMATION FOR ARLON'S 99ML THERMALLY CONDUCTIVE MULTIFUNCTIONAL EPOXY

1. Vacuum @ 29" Hg.....30-45 minutes
2. Heat-up rate.....9-12°F
3. Heat-up rate temperature.....150-250°F
4. Optional Kiss pressure.....50 psi
5. Kiss Low to high pressure.....190-210°F
6. Cure temperature.....360°F
7. Cure time.....90 minutes
8. High pressure @ 29" Hg.....See Notes

Notes:

- Critical heat up rate is 9-12°F (5-7°C)/minute between 150-250°F (66-121°C).
- Apply full pressure from KISS to high pressure between 170-200°F (76.7 to 93.3°C).
- Total time at temperature may vary due to stack up, cure a minimum of 90 minutes at temperature.
- Rack and bake innerlayers at 250°F (121.1°C) for two hours prior to lamination.
- Higher than normal pressures may be needed during lamination for filling heavy copper traces, Arlon recommends the following as a suggested starting point for vacuum hydraulic lamination: 12 X 18= 250-300 psi, 18 X 24= 300-350 psi.
- Scale flow thickness for 106 is 5 mils ply and for 1080, 5.8 mil per ply.