


Multifunctional High Tg Epoxy Low-Flow Prepreg



51N is a non-DICY multifunctional epoxy low-flow prepreg system designed to provide high reliability through lead-free solder operations. The high decomposition temperature and high thermal stability of this material is ideal for use in complex rigid-flex fabrication and assembly operations where minimum resin flow is required.

Features:

- Decomposition temperature $> 350^{\circ}\text{C}$ is ideally suited for lead-free solder processing and offers significant improvement over traditional FR-4 Epoxy systems.
- Multifunctional epoxy resin system with a Glass transition temperature (T_g) of 170°C for optimized thermal cycling PTH reliability
- Improved bond adhesion over multiple thermal excursions results in better reliability through reflow and rework operations.
- Best-in-class thermal performance for an epoxy system with $T_{260} > 60$ minutes, $T_{280} > 30$ minutes and $T_{300} = 15$ minutes
- Electrical and mechanical properties meet the requirements of IPC-4101/126 prepreg, modified to be “Low-Flow”
- Compatible with lead-free solder processing
- RoHS/WEEE compliant

Typical Applications:

- Bonding multilayer rigid-flex boards
 - Finished PCB assemblies requiring excellent thermal stability
 - Dielectric insulators
 - Other applications where minimal and uniform resin flow is required
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Typical Properties:

Property	Units	Value	Test Method
Electrical Properties			
Dielectric Constant @ 1 MHz	-	4.2	IPC TM-650 2.5.5.3
@ 1 GHz	-	4.1	IPC TM-650 2.5.5.9
Dissipation Factor @ 1 MHz		0.02	IPC TM-650 2.5.5.3
@ 1 GHz		0.02	IPC TM-650 2.5.5.9
Volume Resistivity			
C96/35/90	MΩ-cm	2.6×10^7	IPC TM-650 2.5.17.1
E24/125	MΩ-cm	3.3×10^7	IPC TM-650 2.5.17.1
Surface Resistivity			
C96/35/90	MΩ	2.9×10^7	IPC TM-650 2.5.17.1
E24/125	MΩ	4.0×10^6	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	>120	IPC TM-650 2.5.1
Thermal Properties			
Glass Transition Temperature (Tg)			
TMA	°C		IPC TM-650 2.4.24C
DSC	°C	170	IPC TM-650 2.4.25D
Decomposition Temperature			
Initial	°C	354	IPC TM-650 2.4.24.6
5% weight loss	°C	368	IPC TM-650 2.4.24.6
T260	min	>60	IPC TM-650 2.4.24.1
T288	min	>30	IPC TM-650 2.4.24.1
T300	min	15	IPC TM-650 2.4.24.1
CTE (X,Y)	ppm/°C	15	IPC TM-650 2.4.41
CTE (Z)			
< Tg	ppm/°C	44	IPC TM-650 2.4.24C
> Tg	ppm/°C	245	IPC TM-650 2.4.24C
z-axis Expansion (50-260°C)	%	2.6	IPC TM-650 2.4.24C
Mechanical Properties			
Peel Strength to Copper (1 oz/35 micron)			
After Thermal Stress	lb./in (N/mm)	6.7 (1.2)	IPC TM-650 2.4.8C
At Elevated Temperatures	lb./in (N/mm)	6.7 (1.2)	IPC TM-650 2.4.8.2A
After Process Solutions	lb./in (N/mm)	6.4 (1.1)	IPC TM-650 2.4.8C
Young's Modulus CD/MD	Mpsi (GPa)	2.6 (18)	ASTM E111
Tensile Strength CD/MD	kpsi (MPa)	84 (578)	ASTM D3039
Poisson's Ratio	-	6.5 (45)	ASTM E13204
Physical Properties			
Water Absorption (0.062")	%	0.15	IPC TM-650 2.6.2.1A
Density	g/cm ³	1.65	ASTM D792 Method A
Thermal Conductivity	W/mK	0.25	ASTM E1461
Flammability	class	Meets V0	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 (%)	Thickness	Flow Range
51N0672	106	72	0.0022"	60 - 120 mils
51N0666	106	65	0.0017"	60 - 120 mils
51N8065	1080	65	0.0032"	60 - 120 mils
51N8060	1080	60	0.0027"	60 - 120 mils

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 about 8°F - 12°F per minute (4.5°C - 6.5°C) between 210°F and 300°F (100°C and 150°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 = 90 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 51N

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



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For samples, technical assistance and customer service, please contact Arlon Electronic Materials at the following locations:

NORTH AMERICA:

Arlon EMD, 9433 Hyssop Drive, Rancho Cucamonga, CA
Tel: (909) 987-9533 • Fax: (909) 987-8541

FRANCE:

CCI Eurolam
9, rue Marcelin Bertholet
92160 Antony, France

Phone: (33) 146744747
Fax: (33) 146666313

GERMANY:

CCI Eurolam
Otto-Hahn-Str. 46 63303
Dreiech Germany

Phone: (49) 610339920
Fax: (49) 610339929

UK & SCANDINAVIA:

CCI Eurolam – UK
Ulness Walton Lane
Leyland, PR26 8NB, UK

Phone: (44) 1772452236
Fax: (44) 1772456859

ISRAEL:

Tech Knowledge, Ltd. 159 Yigal
Alon Street,
Tel Aviv 6744367, Israel

Phone: (972) 36958117
Fax: (972) 36917117

ITALY:

Dralmi, SAS
X... 20129 Milano Italy

Phone: (39) 025460507
Fax: (39) 0255013199

H5-K 5B.

90... 193 Wen-zhong
V... County
V...
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SINGAPORE:

C.T.S. Industries Pte Ltd
47 Kaki Bukit Place
Singapore 416225

Phone: (65) 6276 3328
Fax: (65) 6276 3336

JAPAN:

Nakao Corp.
12-8 Nihonbashi Hisamatsu-Cho Tokyo
103-0005 Japan

Phone: (81) 336623201
Fax: (81) 336617118

KOREA

UniMicrotek Co. Ltd.
478 Baekbeom-Ro, Bupyeong-Gu
Incheon, Korea

Phone: (82) 32-424-1776
Fax: (82) 505-720-1785

CHINA:

Zack Peng
Room 6A, Unit 2, Bldg 2
Jin Cheng Shi Dai, Tian Road
Shenzhen, China 518103

Phone: (86) 75528236491
Fax: (86) 75528236463

INDIA:

Synertec
301 Raheja Chambers, 12 Museum Rd
Bangalore, India 560001

Phone: (91) 80-25585432
Fax: (91) 80-25588565