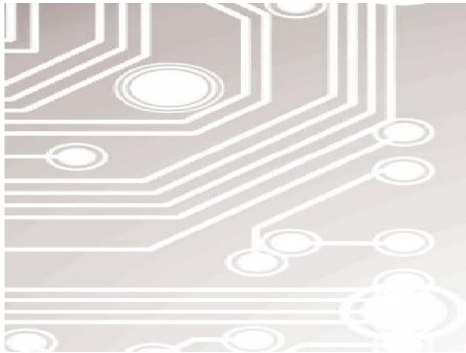
47N

ARLON ELECTRONIC MATERIALS

Epoxy Low-Flow Prepreg



47N is a low-flow epoxy prepreg engineered for bonding multilayer epoxy rigid-flex or attaching heat sinks to multilayer PCBs. An optional reduced lamination temperature protects components already mounted on the PCB.

Features:

- Tetrafunctional modified epoxy resin system with a Tg of 130°C
- Optimized bond to aluminum and copper heat sinks – typical lap shear 1000 PSI
- Cure temperature as low as 300°F (150°C)
- Engineered with discrete flow ranges and fiberglass styles for optimal process flexibility
- Electrical and mechanical properties meeting the requirements of IPC-4101/21, modified to be "Low-Flow"
- Cost competitive for high volume commercial applications
- RoHS/WEEE compliant

Typical Applications:

- Bonding multilayer epoxy rigid-flex
- Attaching heat sinks to polyimide MLBs
- Dielectric insulators

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Typical Properties:

Property	Units	Value	Test Method
Electrical Properties			
Dielectric Constant @ 1 MHz	-	4.3	IPC TM-650 2.5.5.3
Dissipation Factor @ 1 MHz		0.02	IPC TM-650 2.5.5.3
Volume Resistivity			
C96/35/90	MΩ-cm	5.7×10^7	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
Arc Resistance	sec	125	IPC TM-650 2.5.1
Thermal Properties			
Glass Transition Temperature (Tg)			
DSC	°C	135	IPC TM-650 2.4.25D
Decomposition Temperature			
Initial	°C	305	IPC TM-650 2.4.24.6
5% weight loss	°C	315	IPC TM-650 2.4.24.6
T260	min	18	IPC TM-650 2.4.24.1
CTE (X,Y)	ppm/°C	16	IPC TM-650 2.4.41
CTE (Z)			
< Tg	ppm/°C	85	IPC TM-650 2.4.24C
Mechanical Properties			
Peel Strength to Copper (1 oz/35 micron)			
After Thermal Stress	lb./in (N/mm)	9.0 (1.6)	IPC TM-650 2.4.8C
Young's Modulus CD/MD	Mpsi (GPa)	2.6 (17.9)	ASTM E111
Tensile Strength CD/MD	kpsi (MPa)	6.5 (45)	ASTM D3039
Poisson's Ratio	-	0.17	ASTM E13204
Physical Properties			
Water Absorption (0.062")	%	0.1	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	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.

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Availability:

Arlon Part Number	Glass Style	Resin (%)	Mil/Ply	Flow
47N0672	106	72	0.0024	0.030" - 0.090"
47N8065	1080	65	0.0032	0.030" - 0.090"
47N067201	106	72	0.0024	0.050" - 0.100"
47N806501	1080	65	0.0032	0.050" - 0.100"

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 = 340°F (171°C).
5) Cure time at temperature = 60 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 47N
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) 6103399229

UK & SCANDINAVIA:
CCI Eurolam – UK
Ulness Walton Lane
Leyland, PR26 8NB, UK
Phone: (44) 1772452236
Fax: (44) 1772456859

ITALY:
CCI Eurolam
9, rue Marcelin Bertholet
92160 Antony, France
Phone: (33) 146744755
Fax: (33) 146666313

ISRAEL:
Tech Knowledge, Ltd. 159 Yigal Alon Street,
Tel Aviv 6744367, Israel
Phone: (972) 36958117
Fax: (972) 36917117

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[illegible]
493 Wen-zhong [illegible]
[illegible]ounty [illegible]
[illegible]
[illegible]

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

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