



## Sheldahl T900198

Low-Flow Flame Retardant Adhesive on Black Polyester Film

### Description

T900198 tapes join Sheldahl’s low-flow, self-extinguishing adhesive with black-polyester film and are designed for dielectric applications such as flexible ribbon cables, coverlays, and buss-bars. The material’s opacity characteristics, chemical resistance, dynamic flexibility, and high temperature tolerance provide end-users with solutions that are unattainable with other products.

- Unique low flow adhesive makes T900198 ideal for use in connector technologies where adhesive “squeeze-out” is a problem
- High bond strength provides superior adhesion to copper, tin, and standard FFC/FPC materials
- Low variation in adhesive thickness ( $\pm .1$  mil) simplifies production
- Elimination of post bake shortens production time, cuts costs, prevents copper oxidation, and eliminates a major cause of dimensional change
- Finished products have a UL minimum continuous use temperature rating of 105°C

### Processing Recommendations

#### Roll-to-roll Laminating

	SAE	Metric
Hot Roll Temperature	330 - 390°F	160 - 195°C
Pressure (minimum)	200 PSI	14 bar
Line Speed	12-20 FPM	2-8 M/min.
Exit Temperature	295°F (2.5 in. from nip point)	145°C (6cm from nip point)

#### Platen Press

Platen Temperature	275-300°F	135-160°C
Pressure	100-200 PSI	7-14 bar
Time (cool under pressure)	10 min to 120°F	10 min to 50°C

*\*Please note, actual values will depend on many factors including but not limited to: number of rollers, number of heated rollers, copper thickness and cable pitch, wrap angle of tape on heated rollers prior to lamination, run speed etc. Sheldahl suggests use of standard industry tests to confirm encapsulation and adhesion quality. Post curing of finished cables is not needed to achieve temperature resistance. Contact Sheldahl for assistance enhancing product performance.*

PROPERTY	Test Method	TYPICAL DATA <sup>A</sup>
Peel Strength, minimum, (lb./in. – width)	IPC-TM-650, 2.4.9	6.0
Flow, maximum, (mils)	IPC-TM-650, Method 2.3.17.1	1.5 <sup>(B)</sup>
Volatile Content (maximum %)	IPC-TM-650, Method 2.3.37	1.5
Chemical Resistance	IPC-TM-650, 2.3.2, Method A	90% <sup>(C)</sup>
Fungus Resistance	IPC-TM-650, Method 2.6.1	Non-Nutrient
Specific Gravity		1.68
Glass Transition Temperature		20°C
Adhesive Tack Temperature	Clarkston Bar	190 - 200°F
(A) Sheldahl does not guarantee, nor will it accept obligation or liability based on the use of this data. Data subject to change without notice.		
(B) Based on 1.5 mil adhesive.		
(C) Except chlorinated solvents and ketones.		

### Storage and Shelf Life

Guaranteed shelf life is six months from date of shipment when stored at ≤20°C and ≤50% RH.