



Sheldahl T9024

Low-Flow Flame Retardant Adhesive on Nomex® Film

Description

T9024 tapes join Sheldahl’s low flow self-extinguishing adhesive with Nomex film and are designed for dielectric applications such as flexible ribbon cables, jumpers, and buss-bars. The material’s unique electrical properties, dynamic flexibility, and high temperature tolerance provide end-users with solutions that are unattainable with other products.

- Unique low flow adhesive makes T9024 ideal for uses in connector technologies in which 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 125°C
- T9024 is registered UL 94 VTM-0 (E39696)

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 ^A
Peel Strength, minimum, (lb./in. – width)	IPC-TM-650, Method 2.4.9	4.0
Flammability 94 UL VTM-0	UL Test Method 94 VTM-0	Pass ^(C)
Volatile Content (maximum %)	IPC-TM-650, Method 2.3.37	1.5
Glass Transition Temperature		20°C
Chemical Resistance	IPC-TM-650, Method 2.3.2	70% ^(D)
Adhesive Tack Temperature	Clarkston Bar	150 - 250°F
Flow, maximum, (mils)	IPC-TM-650, Method 2.3.17.1	1.5 ^(B)
Dimensional Stability, (maximum, %)	IPC-TM-650, Method 2.2.4	0 ± .50
Tensile Strength, (minimum lb./in. width)	ASTM-D-882	15
Initiation Tear Strength, (lbs. minimum average)	IPC-TM-650, 2.4.16, Method A	1.3 ^(E)
Dielectric Constant, maximum (at 1MHz)	IPC-TM-650, Method 2.5.5.3	3.4 ^(E)
Dissipation Factor, maximum (at 1 GHz)	IPC-TM-650, Method 2.5.5.3	0.03 ^(E)
Volume Resistivity, (minimum ohm-cm)	IPC-TM-650, Method 2.5.17	1 x 10 ¹³ ^(E)
Surface Resistance, (minimum, ohms/sq.)	IPC-TM-650, Method 2.5.17	1 x 10 ¹⁵ ^(E)
Dielectric Strength, (minimum volts/mil)	ASTM-D-149	400 ^(E)
(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) Based on standard constructions using flame retardant adhesives, consult factory for data on specific constructions.		
(D) Except chlorinated solvents and ketones.		
(E) Based on Film alone at 2 mil thickness.		

Storage and Shelf Life

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