

92ML™ Material

Quick Reference Processing Guide

Material Description:	Ceramic filled & thermally conductive multifunctional epoxy/glass core and bondply
Storage:	Ambient conditions for cores. The prepreg materials are certified to and should be stored in compliance with IPC-4101B or IPC-4103
INNER LAYER PREPARATION	
Tooling:	Compatible with most pinless, round and slotted pin systems
Surface Preparation for Photoresist Applications:	Chemical preparation is preferred
DES Processing:	Standard procedures apply
Oxide/Oxide Alternatives:	Compatible with most systems
MLB BONDING	
Final Preparation:	Pre-bake cores at 110C-120C, vacuum desiccate prepreg for 8-12 hours
Thermal Profile:	2C-4C per minute ramp to 185C, 90 minute dwell, 400 PSI
PTH AND OUTER LAYER PROCESSING	
Drilling:	Excessive wear of carbide drills. Diamond coated drills or laser processing preferred
Deburring:	Mechanical processing of thick MLBs, chemical processing of thin MLBs
Desmear:	Alkaline permanganate or CF4/O2 plasma
Metallization:	Compatible with direct deposit or electroless copper processes
PTH AND OUTER LAYER PROCESSING	
Plating/Imaging:	Compatible with acid copper, electrolytic tin plating, and standard SES processes
Soldermask:	Bake prior to solder mask application
Final Finish:	Compatible with OSP, HASL, and chemically electrolytically deposited finishes. Bake prior to reflow of HASL
Circuitization:	Aggressive wear of cutting tools. Improved results with diamond coated tools and laser cutting.

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