

INTERNATIONAL STANDARD

IEC
61249-4-5

First edition
2005-09

**Materials for printed boards and
other interconnecting structures –**

Part 4-5:

**Sectional specification set for prepreg materials,
unclad – Polyimide, modified or unmodified,
woven E-glass prepreg of defined flammability**



Reference number
IEC 61249-4-5:2005(E)

Publication numbering

As from 1 January 1997 all IEC publications are issued with a designation in the 60000 series. For example, IEC 34-1 is now referred to as IEC 60034-1.

Consolidated editions

The IEC is now publishing consolidated versions of its publications. For example, edition numbers 1.0, 1.1 and 1.2 refer, respectively, to the base publication, the base publication incorporating amendment 1 and the base publication incorporating amendments 1 and 2.

Further information on IEC publications

The technical content of IEC publications is kept under constant review by the IEC, thus ensuring that the content reflects current technology. Information relating to this publication, including its validity, is available in the IEC Catalogue of publications (see below) in addition to new editions, amendments and corrigenda. Information on the subjects under consideration and work in progress undertaken by the technical committee which has prepared this publication, as well as the list of publications issued, is also available from the following:

- **IEC Web Site** (www.iec.ch)

- **Catalogue of IEC publications**

The on-line catalogue on the IEC web site (www.iec.ch/searchpub) enables you to search by a variety of criteria including text searches, technical committees and date of publication. On-line information is also available on recently issued publications, withdrawn and replaced publications, as well as corrigenda.

- **IEC Just Published**

This summary of recently issued publications (www.iec.ch/online_news/justpub) is also available by email. Please contact the Customer Service Centre (see below) for further information.

- **Customer Service Centre**

If you have any questions regarding this publication or need further assistance, please contact the Customer Service Centre:

Email: custserv@iec.ch
Tel: +41 22 919 02 11
Fax: +41 22 919 03 00

INTERNATIONAL STANDARD

IEC
61249-4-5

First edition
2005-09

Materials for printed boards and other interconnecting structures –

Part 4-5:

**Sectional specification set for prepreg materials,
unclad – Polyimide, modified or unmodified,
woven E-glass prepreg of defined flammability**

© IEC 2005 — Copyright - all rights reserved

No part of this publication may be reproduced or utilized in any form or by any means, electronic or mechanical, including photocopying and microfilm, without permission in writing from the publisher.

International Electrotechnical Commission, 3, rue de Varembé, PO Box 131, CH-1211 Geneva 20, Switzerland
Telephone: +41 22 919 02 11 Telefax: +41 22 919 03 00 E-mail: inmail@iec.ch Web: www.iec.ch



Commission Electrotechnique Internationale
International Electrotechnical Commission
Международная Электротехническая Комиссия

PRICE CODE

M

For price, see current catalogue

CONTENTS

FOREWORD.....	3
1 Scope.....	5
2 Normative references	5
3 Materials and construction.....	6
3.1 Reinforcement.....	6
3.2 Resin system.....	6
4 Properties.....	6
4.1 Properties related to the appearance of the prepreg	6
4.2 Properties related to B-stage prepreg	7
4.3 Properties related to prepreg after curing	8
5 Delivery form	9
5.1 Rolls.....	9
5.2 Sheets.....	9
5.3 Cut panels.....	10
6 Quality assurance.....	10
6.1 Quality system.....	10
6.2 Responsibility for inspection	10
6.3 Qualification inspection	10
6.4 Quality conformance inspection.....	10
6.5 Certificate of conformance.....	10
6.6 Safety data sheet	10
7 Packaging and marking	11
8 Shelf life	11
9 Ordering information.....	11
Bibliography.....	13
Table 1 – Flammability.....	9

INTERNATIONAL ELECTROTECHNICAL COMMISSION

MATERIALS FOR PRINTED BOARDS AND OTHER INTERCONNECTING STRUCTURES –

Part 4-5: Sectional specification for prepreg materials, unclad – Polyimide, modified or unmodified, woven E-glass prepreg of defined flammability

FOREWORD

- 1) The International Electrotechnical Commission (IEC) is a worldwide organization for standardization comprising all national electrotechnical committees (IEC National Committees). The object of IEC is to promote international co-operation on all questions concerning standardization in the electrical and electronic fields. To this end and in addition to other activities, IEC publishes International Standards, Technical Specifications, Technical Reports, Publicly Available Specifications (PAS) and Guides (hereafter referred to as "IEC Publication(s)"). Their preparation is entrusted to technical committees; any IEC National Committee interested in the subject dealt with may participate in this preparatory work. International, governmental and non-governmental organizations liaising with the IEC also participate in this preparation. IEC collaborates closely with the International Organization for Standardization (ISO) in accordance with conditions determined by agreement between the two organizations.
- 2) The formal decisions or agreements of IEC on technical matters express, as nearly as possible, an international consensus of opinion on the relevant subjects since each technical committee has representation from all interested IEC National Committees.
- 3) IEC Publications have the form of recommendations for international use and are accepted by IEC National Committees in that sense. While all reasonable efforts are made to ensure that the technical content of IEC Publications is accurate, IEC cannot be held responsible for the way in which they are used or for any misinterpretation by any end user.
- 4) In order to promote international uniformity, IEC National Committees undertake to apply IEC Publications transparently to the maximum extent possible in their national and regional publications. Any divergence between any IEC Publication and the corresponding national or regional publication shall be clearly indicated in the latter.
- 5) IEC provides no marking procedure to indicate its approval and cannot be rendered responsible for any equipment declared to be in conformity with an IEC Publication.
- 6) All users should ensure that they have the latest edition of this publication.
- 7) No liability shall attach to IEC or its directors, employees, servants or agents including individual experts and members of its technical committees and IEC National Committees for any personal injury, property damage or other damage of any nature whatsoever, whether direct or indirect, or for costs (including legal fees) and expenses arising out of the publication, use of, or reliance upon, this IEC Publication or any other IEC Publications.
- 8) Attention is drawn to the Normative references cited in this publication. Use of the referenced publications is indispensable for the correct application of this publication.
- 9) Attention is drawn to the possibility that some of the elements of this IEC Publication may be the subject of patent rights. IEC shall not be held responsible for identifying any or all such patent rights.

International Standard IEC 61249-4-5 has been prepared by IEC technical committee 91: Electronics assembly technology.

The text of this standard is based on the following documents:

FDIS	Report on voting
91/527/FDIS	91/537/RVD

Full information on the voting for the approval of this standard can be found in the report on voting indicated in the above table.

This publication has been drafted in accordance with the ISO/IEC Directives, Part 2.

IEC 61249-4 consists of the following parts, under the general title *Materials for printed boards and other interconnecting structures – Part 4: Sectional specification set for prepreg materials, unclad*:

- Part 4-1: Epoxide woven E-glass prepreg of defined flammability¹
- Part 4-2: Multifunctional epoxide woven E-glass prepreg of defined flammability
- Part 4-5: Polyimide, modified or unmodified, woven E-glass prepreg of defined flammability
- Part 4-11: Non-halogenated epoxide, woven E-glass prepreg of defined flammability
- Part 4-12: Non-halogenated multifunctional epoxide woven E-glass prepreg of defined flammability

The committee has decided that the contents of this publication will remain unchanged until the maintenance result date indicated on the IEC web site under "<http://webstore.iec.ch>" in the data related to the specific publication. At this date, the publication will be

- reconfirmed;
- withdrawn;
- replaced by a revised edition, or
- amended.

A bilingual version of this publication may be issued at a later date.

¹ Under consideration.

MATERIALS FOR PRINTED BOARDS AND OTHER INTERCONNECTING STRUCTURES –

Part 4-5: Sectional specification set for prepreg materials, unclad – Polyimide, modified or unmodified, woven E-glass prepreg of defined flammability

1 Scope

This part of IEC 61249 gives requirements for properties of prepreg that is mainly intended to be used as bonding sheets in connection with laminates according IEC 61249-2-11 when manufacturing multilayer boards according to IEC 62326-4. This material may be also used to bond other types of laminates.

Prepreg according to this standard is of defined flammability (vertical burning test). The flammability rating on fully cured prepreg is achieved through the use of brominated fire retardants contained as an integral part of the polymeric structure. After curing according to the supplier's instructions, the glass transition temperature is defined to be 170 °C minimum.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

IEC 61189-2:1997, *Test methods for electrical materials, printed boards and other interconnecting structures and assemblies – Part 2: Test methods for materials for interconnection structures*

Amendment 1 (2000)

IEC 61249-2-11, *Materials for printed boards and other interconnecting structures – Part 2-11: Sectional specification set for reinforced base materials clad and unclad – Polyimide woven E-glass laminated sheet of defined flammability copper-clad*

IEC 61249-6-3, *Material for printed boards and other interconnecting structures – Part 6-3: Sectional specification set for reinforcement materials – Woven E-glass (for the manufacture of prepregs and copper-clad base materials)²*

IEC 62326-4:1996, *Printed boards – Part 4: Rigid multilayer printed boards with interlayer connections - Sectional specification*

ISO 9000:2000, *Quality management systems – Fundamentals and vocabulary*

ISO 11014-1:1994, *Safety data sheet for chemical products – Part 1: Content and order of sections*

ISO 14001:2004, *Environmental management systems – Requirements with guidance for use*

² In preparation.

3 Materials and construction

The prepreg consists of a reinforcing E-glass fabric which is impregnated with polyimide resin and partially cured to the B-stage.

3.1 Reinforcement

Woven E-glass as specified in IEC 61249-6-3: Woven E-glass fabric (for the manufacture of prepreg and copper-clad laminate).

3.2 Resin system

Polyimide, modified or unmodified, resulting in a cured laminate with a glass transition temperature of 170 °C minimum.

Contrast agents may be added to enhance processing such as automated optical inspection.

Its flame resistance is defined in terms of the flammability requirements of 4.3.2.

4 Properties

4.1 Properties related to the appearance of the prepreg

The prepreg shall be substantially free from defects that may have an impact on the material's fitness for use for the intended purpose.

For the following specific defects, the requirements given shall apply when inspection is made in accordance with IEC 61189-2 method 2V01 (under consideration).

4.1.1 Dewetted areas (fish eyes)

Dewetted areas with a diameter >10 mm are not permissible.

Dewetted areas with a diameter ≤10 mm are permitted to an extent of a maximum 10 fish eyes in any 300 × 300 mm area of the prepreg.

4.1.2 Broken filaments

When judging the presence of broken filaments their sizes and frequency of occurrence are important for assessing acceptability but also the flow characteristic of the prepreg must be taken into consideration. The acceptance conditions for broken filaments shall be as agreed upon between the user and supplier.

4.1.3 Distortion

When the prepreg is tested in accordance with test method 2M29 (under consideration) of IEC 61189-2, the distortion or non-perpendicular orientation of the fill or weft yarns in the glass fabric shall not exceed 10 % measured over any 300 mm test distance.

4.1.4 Creases

Creases caused by handling of the prepreg where only a negligible loss of resin has occurred are permitted.

Creases where the glass yarns are exposed due to loss of resin are not permitted.

4.1.5 Edge conditions

Cut-to-size panels shall have even edges and shall not show loss of resin at the edge due to the cutting process more than 2 mm. Excessive occurrence of resin dust released during the cutting shall be removed before packaging for shipment.

4.2 Properties related to B-stage prepreg

A number of characteristics can describe thickness, reactivity and rheology of B stage prepreg. The choice of characteristics to be used as qualification and quality conformance testing as well as the nominal performance levels are as agreed upon between the user and supplier.

Several of the characteristics shown below are interrelated and should not be specified individually. Ordering requirements should preferably be restricted to the glass style, one characteristics marked (a) in combination with one characteristic marked (b). A maximum of one optional characteristic (c) of B stage prepreg may be included.

Glass style

Thickness parameter

- Resin content (a)
- Treated weight (a)

Reactivity/rheology parameter

- Resin flow (b)
- Scaled flow thickness (b)
- Melt viscosity (b)
- Cured thickness (b)

Optional parameter

- Volatile content (c)
- Gel time (c)

4.2.1 Resin content

When tested in accordance with test method 2C03 or 2C10 of IEC 61189-2, the nominal resin content shall be as agreed upon between the user and supplier.

The tolerance around the ordered nominal value shall be ± 3 %, e.g. (45 ± 3) %.

4.2.2 Treated weight

When tested in accordance with test method 2C03 of IEC 61189-2, the nominal treated weight shall be as agreed upon between the user and supplier.

The tolerance around the ordered nominal value shall be ± 3 %, e.g. $(350 \pm 10,5)$ g.

4.2.3 Resin flow

When tested in accordance with test method 2M09 of IEC 61189-2, the nominal resin flow shall be as agreed upon between the user and supplier.

The tolerance around the ordered nominal value shall be ± 5 %, e.g. (25 ± 5) %.

4.2.4 Scaled flow thickness

When tested in accordance with test method 2M26 of IEC 61189-2, the nominal scaled flow and the tolerance shall be as agreed upon between the user and supplier.

4.2.5 Melting viscosity

When tested in accordance with test method 2C09 of IEC 61189-2, the nominal melt viscosity shall be as agreed upon between the user and supplier.

The tolerance around the ordered nominal value shall be ± 20 mPa s, e.g. (240 ± 20) mPa s.

4.2.6 Gel time

When tested in accordance with test method 2C02 of IEC 61189-2, the nominal gel time shall be as agreed upon between the user and supplier.

The tolerance around the ordered nominal value shall be ± 20 s, e.g. (160 ± 20) s.

4.2.7 Volatile content

When tested in accordance with test method 2C04 of IEC 61189-2, the volatile content shall be 2 % maximum.

4.3 Properties related to prepreg after curing

4.3.1 Electric strength

A total of 2 plies of prepreg of minimum size $300 \text{ mm} \times 300 \text{ mm}$ shall be bonded together and cured in accordance with the manufacturer's recommendations whereupon the thickness shall be determined using a micrometer.

When tested in accordance with test method 2E11 (à l'étude) of IEC 61189-2, the minimum electric strength shall be $25 \text{ V}/\mu\text{m}$.

4.3.2 Flammability

A number of plies of minimum size $300 \text{ mm} \times 300 \text{ mm}$ of the prepreg under test shall be bonded together and cured in accordance with the manufacturer's recommendations. The number of plies shall be chosen so that a specimen thickness of approximately 0,4–0,5 mm is obtained as measured with a micrometer.

When tested in accordance with test method 2C06 of IEC 61189-2, the flammability shall meet the requirements as shown in Table 1.

Table 1 – Flammability

Property	Test method (IEC 61189-2)	Requirement	
		Designation	
		FV 0	FV 1
Flammability:			
Flaming combustion time after each application of the flame for each test specimen	2C06	≤ 10 s	≤ 30 s
Total flaming combustion time for the 10 flame applications for each set of five specimens		≤ 50 s	≤ 250 s
Glowing combustion time after the second removal of the test flame		≤ 30 s	≤ 60 s
Flaming or glowing combustion up to the holding clamp		None	None
Dripping flaming particles that ignite the tissue paper		None	None

4.3.3 Relative permittivity and dissipation factor

A total of 2 plies of prepreg of minimum size 300 mm × 300 mm shall be bonded together and fully cured in accordance with the manufacturer's recommendations whereupon the thickness shall be determined using a micrometer.

When tested in accordance with test method 2E10 (under consideration) of IEC 61189-2, the relative permittivity and dissipation factor at 1 MHz shall be 5,4 and 0,035 maximum, respectively.

4.3.4 Cured thickness

The nominal thickness and the tolerance of the cured prepreg using the user's lamination cycle shall be as agreed upon between the user and supplier.

4.3.5 Glass Transition Temperature (T_g)

A total of 5 plies of prepreg of minimum size 300 mm × 300 mm shall be bonded together and fully cured in accordance with the manufacturer's recommendations, whereupon the thickness shall be determined using a micrometer.

When tested in accordance with test method 2M10 of IEC 61189-2, the glass transition temperature shall be 150–190 °C.

5 Delivery form

Prepreg may be ordered and delivered as rolls, sheets or cut panels.

5.1 Rolls

Roll sizes shall be as agreed upon between the user and supplier. For rolls ≥50 m in length, cut outs from quality conformance inspection are allowed. The size of the roll delivered by the supplier shall not deviate more than $^{+20}_0$ mm in the width and ±5 m in the length from the ordered size. Extra linear meters shall be added to compensate for any cut-outs for quality conformance testing.

5.2 Sheets

Sheet sizes shall be as agreed upon between the user and supplier. The size of the sheet delivered shall not deviate more than $^{+20}_0$ mm from the ordered size.

5.3 Cut panels

Cut panel sizes shall be as agreed upon between the user and supplier. The size of the cut panels delivered shall not deviate more than ± 3 mm from the ordered size.

6 Quality assurance

6.1 Quality system

The supplier shall operate a quality system, ISO 9000 or similar, to support quality conformance inspection.

The supplier shall operate a quality system, ISO 14001 or similar, to support environmental considerations.

6.2 Responsibility for inspection

The supplier is responsible for all inspection of the manufactured material. Inspection is auditable by the purchaser or an appointed third party.

6.3 Qualification inspection

Prepregs furnished under this standard shall be qualified. Qualification testing shall be performed to demonstrate the manufacturer's ability to meet the requirements of this standard. Qualification testing shall be conducted at a laboratory compliant with IEC laboratory requirements. The manufacturer shall retain on file the data which supports that the materials meet this standard and shall be readily available for review upon request.

6.4 Quality conformance inspection

The supplier shall operate a quality plan to assure product conformance to this standard. Such a quality plan, when appropriate, should utilize statistical methods rather than lot-by-lot inspection. It is the responsibility of the supplier based on the quality plan to determine the frequency of test to assure conforming products.

A combination of the following techniques may be used to show compliance with the requirements which can be used to reduce the frequency of testing. The data supporting the reduction of testing frequency shall be available for review upon request:

- in process parameter control;
- in process inspection;
- periodic final inspection;
- final lot inspection.

6.5 Certificate of conformance

The supplier shall on request from the purchaser, issue a certificate of conformance to this standard in electronic or paper format.

6.6 Safety data sheet

A safety data sheet in accordance with ISO 11014-1 shall be available for products manufactured and delivered against this standard.