

**Process Guidelines**

**MEGTRON7**

**Laminate R-5785**

**Prepreg R-5680**

High Speed, Low Loss Multi-layer Materials

## General

### Material Storage

Laminate should be stored flat in a cool dry environment. Avoid bending or scratching the laminate surface.

When possible store the laminate in the original container.

Prepreg should be stored flat in a cool dry controlled environment, 73 F (23 C) or less and 50% RH or less.

Extended storage of prepreg should be at a reduced temperature of 41 F (5 C). Open bags of prepreg must be resealed. Prepreg should not be exposed to open environments for more than 8 hours total cumulatively under the above conditions or as agreed upon between user and supplier.

### Laminate Surface Preparation

Regular Shiny Copper can be cleaned using industry standard chemical clean or mechanical clean.

Reverse Treat Copper should be cleaned using industry standard chemical clean.

### Inner Layer Bond Treatment

Alternative Oxide Treatment with organic coating using a Peroxide/Sulfuric etch technology is preferred. In the case of using Black Oxide, please check whether peel strength is acceptable for the usage.

### Drying

Dry finished inner layers completely to remove any absorbed moisture or surface moisture. A racked bake at 225 F (105 C) for 20-30 minutes is preferred. For conveyORIZED alternative oxide processing, some equipment may have sufficient drying capability. However, a racked bake is suggested.

**Note**

The following guidelines are provided as general recommendations. Process optimization may be necessary.

## Drilling (1) Drilling parameters in general condition

Drilling parameters should be adjusted depending on hole size, layer count, panel thickness, stack count and stack height etc.

Diameter	Spindle speed	velocity	min		max		bit life
			infeed	chipload	infeed	chipload	
mm	k rpm	m/min	m/min	$\mu$ /rev	m/min	$\mu$ /rev	hits
0.20	160	100	1.6	10	2.4	15	700-1,000
0.25	160	126	1.8	11	2.8	18	700-1,000
0.30	160	151	1.9	12	3.2	20	700-1,000
0.35	137	151	1.8	13	3.0	22	700-1,000
0.40	120	151	1.8	15	2.9	24	700-1,000
0.45	107	151	1.8	17	2.7	25	700-1,000
0.50	96	151	1.8	19	2.7	28	1,400-2,000
0.55	87	150	1.8	21	2.6	30	1,400-2,000
0.60	80	151	1.7	21	2.6	33	1,400-2,000
0.65	74	151	1.7	23	2.6	35	1,400-2,000
0.70	68	149	1.7	25	2.6	38	1,400-2,000
0.75	64	151	1.6	25	2.6	41	1,400-2,000
0.80	60	151	1.6	27	2.5	42	1,400-2,000
0.85	56	149	1.6	29	2.4	43	1,400-2,000
0.90	53	150	1.6	30	2.4	45	1,400-2,000

### Note:

- 1) Spindle speed should be adjusted to make velocity 100 – 150 m/min.
- 2) To use lubricant sheets like LE sheets as entry sheets is recommendable.
- 3) To use drilling bits with high helix angle is recommendable.
- 4) Peck drilling is recommendable for thin drilling bits.
- 5) Please adjust drilling parameters after checking qualities of through holes.

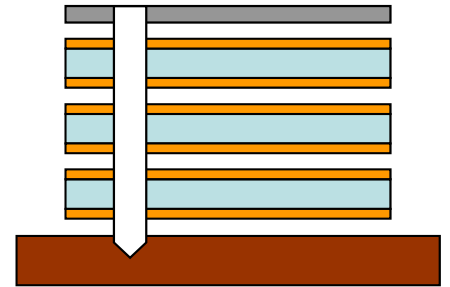


### Note

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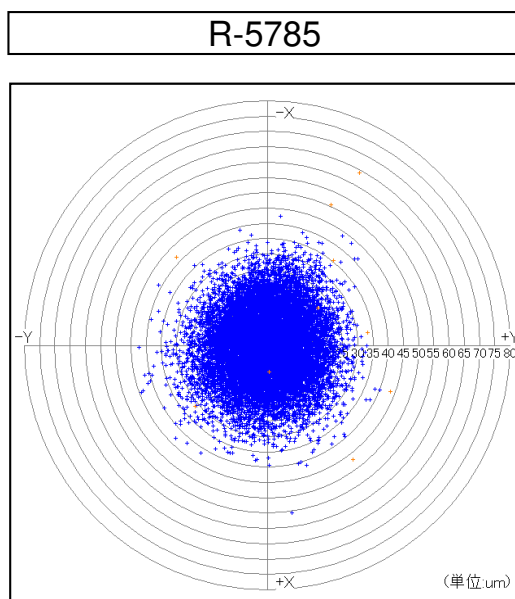
## Drilling (2) Positioning accuracy

Drill size	mm	$\phi$ 0.30
Velocity	m/min	151
Spindle Speed	krpm	160
Chip load	micron/rev	20
Hit count		5000
Entry board		0.15 Aluminum (lubricated is preferred)
Panel thickness	mm	1
Copper thickness	micron	18 / 18
Stack count		3

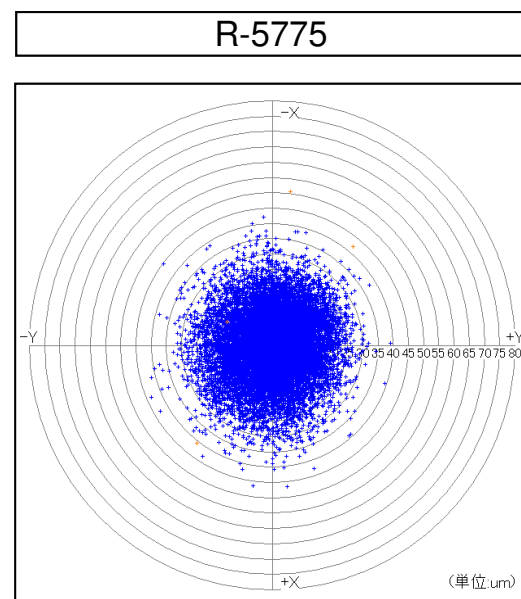


\* No peck drilling

Positioning accuracy map of R-5785 and R-5775 (MEGTRON6).



positioning accuracy : 35.1 micron



positioning accuracy : 34.4 micron



### Note

The following guidelines are provided as general recommendations.  
Process optimization may be necessary.

## Laminate

Curing temperature time will be determined by the thickness of multilayer package being laminated.

Laminate parameters should be adjusted depending on board thickness, stack count and stack thickness etc.

**Please Note** : below is NOT a press control program. The graph represents the recommended pressure/temperature profile of actual panels subjected to during the lamination program cycle.

### Points

#### 1. Product temperature

- Product temperature should be kept at higher 195C for more than 75 minutes.

#### 2. Press pressure

- It's a guide line that Ramping up of pressure is started after 90C of material temp. at the platen side and finished before 110C of material temp. at the platen side.

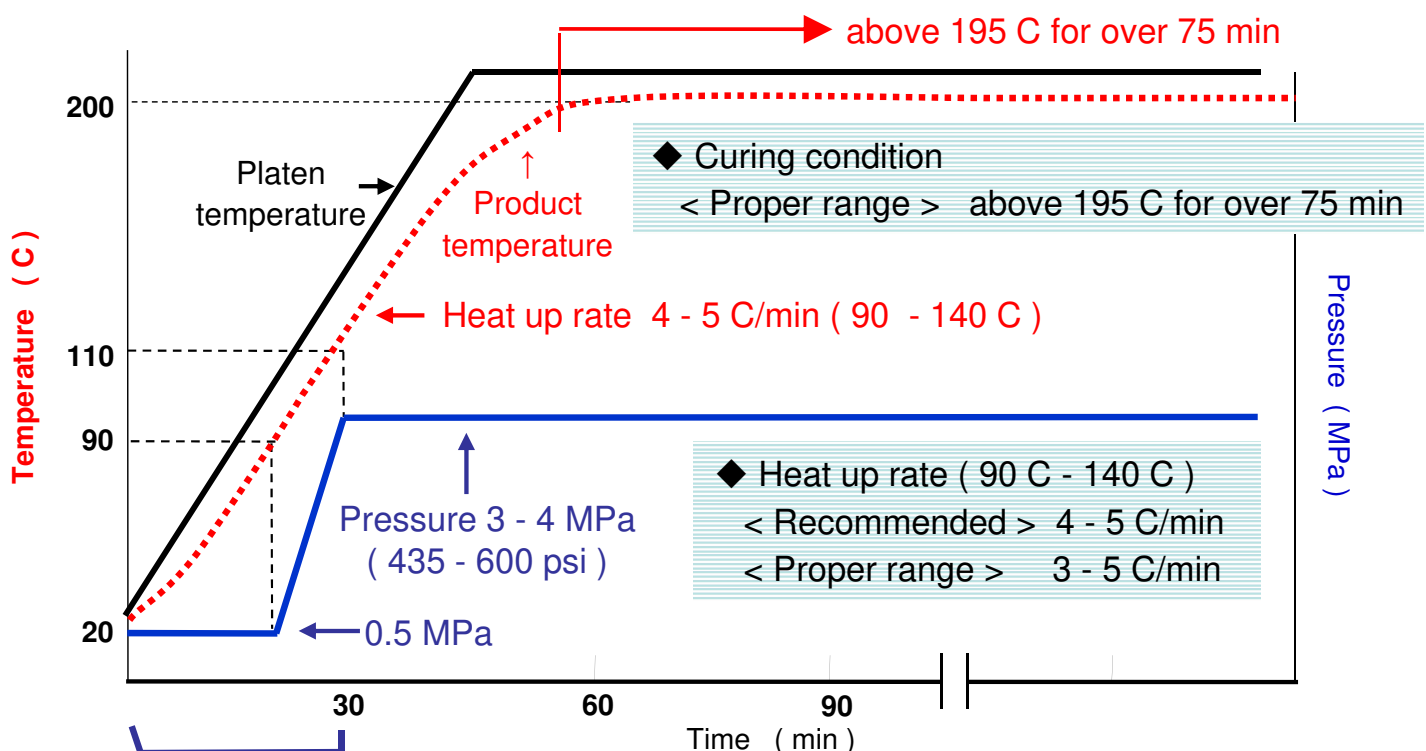
\* Pressure is optimized according to Circuit Pattern by our customers.

#### 3. Vacuum

- Stop at 30minute from start ( at 90- 130C of material temp. at the platen side ).

#### 4. Cushion

- Cushion for Pressure evenness is needed. ( Sheets of kraft paper etc. )



Vacuum : 100 Torr ( 13.3 kPa ) or less, Stop at 30 min from start ( at 90 - 130 C )



### Note

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## Desmear

### 1) Permanganate Desmear

The weight loss of R-5785 laminate and R-5680 prepreg is less than that of R-1766 as our conventional FR-4 material. Twice of FR-4 condition is recommendable.

Desmear parameters should be adjusted depending on board thickness, stack count and stack thickness etc.

process	reagent type	temp. (C)	time (min)
Swelling	alkaline	65-85	5-10
Etching	permanganate	70-85	10-15

process	reagent type	temp. (C)	time (min)
Swelling	organic solvent	35-40	6-10
Etching	permanganate	70-85	10-15

Part number	Weight loss ratio (%)
R-5785	0.2 - 0.4
R-5775	0.2 - 0.4
R-1766	1.0

### 2) Plasma Desmear

Half time of FR-4 conditions is recommendable.

### 3) Combined Desmear for Hybrid construction with FR-4 materials

First, Plasma Desmear for the half time of FR-4 condition is done and Permanganate Desmear without swelling process for the half time of FR-4 condition is done continuously.



#### Note

The following guidelines are provided as general recommendations. Process optimization may be necessary.

**++Before purchase++**

## 【Notes before you use】

- Please verify the suitability and fitness for intended application by quality testing, evaluation or other means at your own option before any adoption, use or change of use conditions of a product listed in the Process Guideline.
- We would like to have a delivery specifications mutually agreed for the product that you have decided to use.  
The agreements defined in the delivery specifications are assigned higher priority.
- Please note that images shown may somewhat differ from the actual product in color.
- Please note that specifications and external design are subject to change for product improvement without notice.
- For details on products in the Process Guideline, please contact your distributor or our sales department.

## 【Safety Information】

- Before using the product, please read the delivery specifications carefully or contact the distributor from which you purchased the product or our sales department in order to use the product correctly.
- The products in the Process Guideline are Electronic circuit board materials for electronic and electrical devices. Please do not use them for other than specified use.

**Please Contact us of more**

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