

SILICONE RUBBER PRESS PADS

Multilayer, Flexible Circuitry, Rigid/Flex Laminations

Saint-Gobain® Norseal® Silicone Rubber Press Pads are manufactured by **Saint-Gobain** Performance Plastics Corporation, Tape Solutions business, and are available to meet the full range of lamination requirements in today's multiple or high-temperature resin systems, including both low- and high-pressure lamination in hydraulic and vacuum-assisted hydraulic presses as well as autoclave operations. In order to conform to the highest traces and multiwire, this rubber-over-fabric product line is offered in a range of thicknesses.

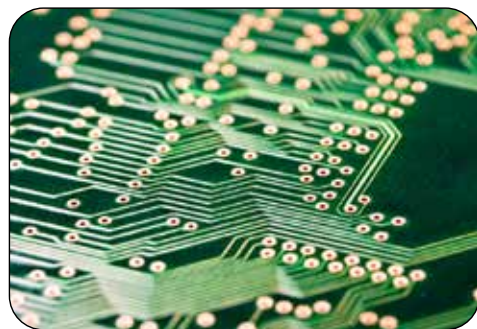
Saint-Gobain brings decades of experience with PTFE and thermoplastic bonding films to this product line. Our knowledge of this technology enables us to produce **Norseal** Press Pads that provide substantial cycle life without silicone reversion.

Norseal Press Pads products are specially intended to provide the following features:

- Unsurpassed cycle life
- Equal pressure over laminate surface
- Consistent thermal lagging from cycle to cycle
- Reduced inventory by eliminating paper
- Reduce labor cost of paper handling and disposal
- Reversion-resistant compounds handle high temperature and pressure
- Static-free compound keeps laminate clean
- Helps prevent voids in finished laminate

Available Sizes

Standard thickness: see roll size chart on following page.



APPLICATIONS

- Flexible circuit boards
- Printed circuit boards
- Release sheets for bonding applications
- High-strength gasketing

Norseal Silicone Rubber Press Pads — Properties

(Formerly known as COHRLastic Silicone Rubber Press Pads)

Performance tests are run using standard test procedures. The values presented are typical values and should not be used for specification purposes.

Property	Test Method	3320	4420	4444	4480	555
Durometer: Shore A	ASTM D2240	.063 = 74 .094 = 66 .125 = 65	.045 = 78 .063 = 74	.063 = 79 .094 = 72 .125 = 67	.063 = 81 .125 = 70	60
Reinforcement	—	Fiberglass	Fiberglass	Fiberglass	Fiberglass	Unsupported
Weight by Thickness (lb/yd ²)	—	.063 = 4.1 .094 = 5.9 .125 = 7.8	.045 = 3.0 .063 = 4.1	.063 = 4.5 .094 = 6.5 .125 = 9.0	.063 = 3.9 .125 = 9.4	15
Color	—	Red	Brown	Red	Dark Gray	Charcoal Gray
Temperature °F	—	350 Max	400 Max	400 Max	575 Max	575 Max
Width in. (mm)	—	36 (914.4)	36 (914.4), 40 (1016)	36 (914.4)	38 (965.2)	36 (914.4) × 36 (914.4) sheets

Norseal Silicone Rubber Press Pads

Product No.	Thickness in. (mm)
3320	.063, .094, and .125 (1.59, 2.38, and 3.18)
4420	.045 and .063 (.115 and 1.59)
4444	.063, .094, and .125 (1.59, 2.38, and 3.18)
4480	.063 and .125 (1.59 and 3.18)
555	.250 (6.35)

Layers of Kraft Paper* Replaced by One Silicone Pad

Pad Thickness (in./mm)	Layers of Kraft
.045/1.15	3-4
.062/1.59	4-6
.078/1.98	5-7
.093/2.38	6-7
.125/3.18	9-10

* 90 lb. (40.8 kg)

Options (subject to minimum order requirements)

- Powder-free interleaf liner for ease in winding.
- Acrylic (or silicone) pressure-sensitive adhesive (PSA) available in sheet format only (See **Norseal** Silicone Elastomer adhesive option data page for details).

Important Instructions

Because **Saint-Gobain** cannot anticipate or control every potential application, we strongly recommend testing of this product under individual application conditions prior to commercial use.

When using PSA option, surfaces must be clean and free of oil, grease, moisture, dust and dirt. Isopropyl alcohol is good for cleaning the surface. Do not remove liner until tape is in proper position. Avoid touching adhesive surface before application.

Recommended service temperature of the silicone elastomer is -100°F to 500°F (-73°C to 260°C).

Shelf Life

120 months from date of shipment for base material when stored in original packaging at temperatures up to 70°F (21°C), < 50% relative humidity, and away from direct sources of heat and direct sunlight. (See the applicable data sheets for pressure sensitive adhesive options).

IMPORTANT: It is the user's responsibility to ensure the suitability and safety of Saint-Gobain products for all intended uses and that the materials to be used comply with all applicable regulatory requirements. Saint-Gobain assumes no responsibility for any product failures that occur due to your actions or inactions, including your use, design, fabrication or application of the products into which the materials are incorporated.

WARRANTY: This document should not be considered a warranty or a guarantee. The descriptions of the Product provided hereinabove may vary based on specifications requested and testing protocols. Typically, Saint-Gobain warrants that product(s) will meet mutually agreed specifications at delivery and Saint-Gobain honors any breach of warranty claims for six (6) months from delivery of the products. If a product is determined to be nonconforming with its warranty, Saint-Gobain's sole obligation is, at its option, to either replace the nonconforming products or reimburse the purchase price for the same.

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