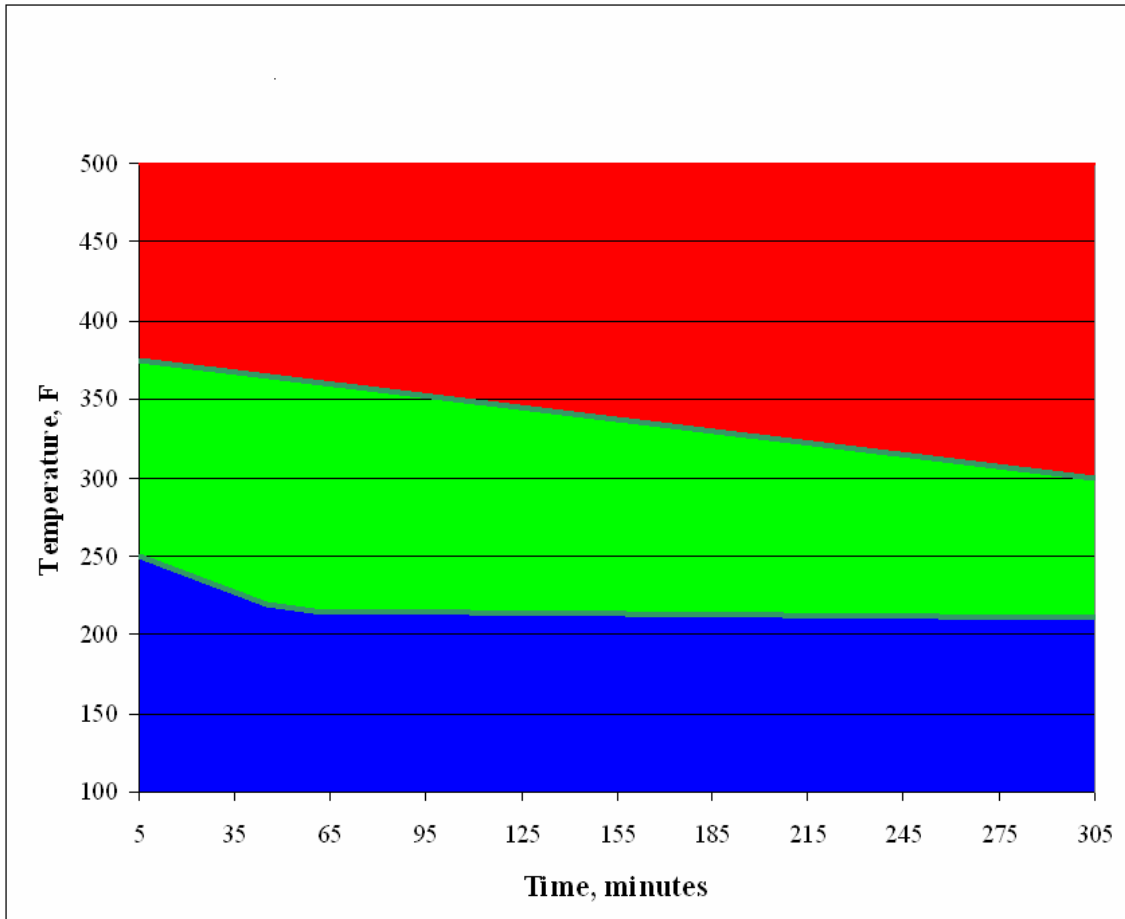




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99990A### Press Cycle Guide



Press Cycle Guide

KEY:

The GREEN zone covers combinations of press cycle process temperature and time which are expected to produce satisfactory adhesive crosslinking and bond strength.

The RED zone covers combinations of press cycle process temperature and time which are expected to cause polymer reversion, which may lead to unacceptable adhesive crosslinking and bond strength.

The BLUE zone covers combinations of press cycle process temperature and time which are expected to lead to inadequate adhesive crosslinking and bond strength.

The Press Cycle Guide displays press cycle parameters of process temperature and time for laminating components with the 99990A### Thermabond® adhesive. The guide assumes that the adhesive is under platen pressure. The units of temperature are in degrees Fahrenheit and the units of time are in minutes. The guide defines whether the 99990A### adhesive's crosslink density and bond strength will be satisfactory after a given press cycle.



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Arlon's standard recommended processing parameters for achieving optimum crosslink density and bond strength for the 99990A### silicone adhesive are 15 minutes at 250°F under pressure.

This Process Guide is based on experimental laboratory results and should therefore be considered for reference purposes only. Specifically, we ask that this process guide not be used in establishing process and product parameters and specifications without confirmation and validation studies conducted with actual production processes.