

INTERNATIONAL STANDARD

NORME INTERNATIONALE

**Materials for printed boards and other interconnecting structures –
Part 2-46: Reinforced base materials clad and unclad – Non-halogenated epoxide
non-woven/woven E-glass reinforced laminate sheets of thermal conductivity
1,5 W/(m•K) and defined flammability (vertical burning test), copper-clad for
lead-free assembly**

<https://standards.iteh.ai/catalog/standards/sist/e1720219-4a25-4a43-97c8-a62d56899a8d/iec-61249-2-46-2018>

**Matériaux pour circuits imprimés et autres structures d'interconnexion –
Partie 2-46: Matériaux de base renforcés, plaqués et non plaqués – Feuilles
stratifiées renforcées en verre de type E tissé/non tissé époxyde non halogéné,
de conductivité thermique 1,5 W/(m•K) et d'inflammabilité définie (essai de
combustion verticale), plaquées cuivre pour les assemblages sans plomb**



THIS PUBLICATION IS COPYRIGHT PROTECTED
Copyright © 2018 IEC, Geneva, Switzerland

All rights reserved. Unless otherwise specified, 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 either IEC or IEC's member National Committee in the country of the requester. If you have any questions about IEC copyright or have an enquiry about obtaining additional rights to this publication, please contact the address below or your local IEC member National Committee for further information.

Droits de reproduction réservés. Sauf indication contraire, aucune partie de cette publication ne peut être reproduite ni utilisée sous quelque forme que ce soit et par aucun procédé, électronique ou mécanique, y compris la photocopie et les microfilms, sans l'accord écrit de l'IEC ou du Comité national de l'IEC du pays du demandeur. Si vous avez des questions sur le copyright de l'IEC ou si vous désirez obtenir des droits supplémentaires sur cette publication, utilisez les coordonnées ci-après ou contactez le Comité national de l'IEC de votre pays de résidence.

IEC Central Office
3, rue de Varembe
CH-1211 Geneva 20
Switzerland

Tel.: +41 22 919 02 11
info@iec.ch
www.iec.ch

About the IEC

The International Electrotechnical Commission (IEC) is the leading global organization that prepares and publishes International Standards for all electrical, electronic and related technologies.

About IEC publications

The technical content of IEC publications is kept under constant review by the IEC. Please make sure that you have the latest edition, a corrigendum or an amendment might have been published.

IEC publications search - webstore.iec.ch/advsearchform

The advanced search enables to find IEC publications by a variety of criteria (reference number, text, technical committee,...). It also gives information on projects, replaced and withdrawn publications.

IEC Just Published - webstore.iec.ch/justpublished

Stay up to date on all new IEC publications. Just Published details all new publications released. Available online and once a month by email.

IEC Customer Service Centre - webstore.iec.ch/csc

If you wish to give us your feedback on this publication or need further assistance, please contact the Customer Service Centre: sales@iec.ch.

Electropedia - www.electropedia.org

The world's leading online dictionary on electrotechnology, containing more than 22,000 terminological entries in English and French, with equivalent terms in 16 additional languages. Also known as the International Electrotechnical Vocabulary (IEV) online.

IEC Glossary - std.iec.ch/glossary

67,000 electrotechnical terminology entries in English and French extracted from the Terms and Definitions clause of IEC publications issued since 2002. Some entries have been collected from earlier publications of IEC TC 37, 77, 86 and CISPR.

A propos de l'IEC

La Commission Electrotechnique Internationale (IEC) est la première organisation mondiale qui élabore et publie des Normes internationales pour tout ce qui a trait à l'électricité, à l'électronique et aux technologies apparentées.

A propos des publications IEC

Le contenu technique des publications IEC est constamment revu. Veuillez vous assurer que vous possédez l'édition la plus récente, un corrigendum ou amendement peut avoir été publié.

Recherche de publications IEC - webstore.iec.ch/advsearchform

La recherche avancée permet de trouver des publications IEC en utilisant différents critères (numéro de référence, texte, comité d'études,...). Elle donne aussi des informations sur les projets et les publications remplacées ou retirées.

IEC Just Published - webstore.iec.ch/justpublished

Restez informé sur les nouvelles publications IEC. Just Published détaille les nouvelles publications parues. Disponible en ligne et une fois par mois par email.

Service Clients - webstore.iec.ch/csc

Si vous désirez nous donner des commentaires sur cette publication ou si vous avez des questions contactez-nous: sales@iec.ch.

Electropedia - www.electropedia.org

Le premier dictionnaire d'électrotechnologie en ligne au monde, avec plus de 22 000 articles terminologiques en anglais et en français, ainsi que les termes équivalents dans 16 langues additionnelles. Egalement appelé Vocabulaire Electrotechnique International (IEV) en ligne.

Glossaire IEC - std.iec.ch/glossary

67 000 entrées terminologiques électrotechniques, en anglais et en français, extraites des articles Termes et Définitions des publications IEC parues depuis 2002. Plus certaines entrées antérieures extraites des publications des CE 37, 77, 86 et CISPR de l'IEC.

INTERNATIONAL STANDARD

NORME INTERNATIONALE

**Materials for printed boards and other interconnecting structures –
Part 2-46: Reinforced base materials clad and unclad – Non-halogenated epoxide
non-woven/woven E-glass reinforced laminate sheets of thermal conductivity
1,5 W/(m•K) and defined flammability (vertical burning test), copper-clad for
lead-free assembly**

**Matériaux pour circuits imprimés et autres structures d'interconnexion –
Partie 2-46: Matériaux de base renforcés, plaqués et non plaqués – Feuilles
stratifiées renforcées en verre de type E tissé/non tissé époxyde non halogéné,
de conductivité thermique 1,5 W/(m•K) et d'inflammabilité définie (essai de
combustion verticale), plaquées cuivre pour les assemblages sans plomb**

INTERNATIONAL
ELECTROTECHNICAL
COMMISSION

COMMISSION
ELECTROTECHNIQUE
INTERNATIONALE

ICS 31.180

ISBN 978-2-8322-9096-5

**Warning! Make sure that you obtained this publication from an authorized distributor.
Attention! Veuillez vous assurer que vous avez obtenu cette publication via un distributeur agréé.**

CONTENTS

FOREWORD.....	4
1 Scope.....	6
2 Normative references	6
3 Terms and definitions	6
4 Materials and construction.....	6
4.1 General.....	6
4.2 Resin system	7
4.3 Metal foil.....	7
4.4 Reinforcement	7
5 Electrical properties.....	7
6 Non-electrical properties of the copper-clad laminate	7
6.1 Appearance of the copper-clad sheet.....	7
6.1.1 General	7
6.1.2 Indentations (pits and dents)	8
6.1.3 Wrinkles	8
6.1.4 Scratches	8
6.1.5 Raised areas	8
6.2 Appearance of the unclad face.....	9
6.3 Laminate thickness	9
6.4 Bow and twist	9
6.5 Properties related to the copper foil bond.....	10
6.6 Punching and machining	11
6.7 Dimensional stability	11
6.8 Sheet sizes	11
6.8.1 Typical sheet sizes	11
6.8.2 Tolerances for sheet sizes	11
6.9 Cut panels	12
6.9.1 Cut panel sizes.....	12
6.9.2 Size tolerances for cut panels.....	12
6.9.3 Rectangularity of cut panels	12
6.10 Thermal conductivity	12
7 Non-electrical properties of the base material after complete removal of the copper foil	13
7.1 Appearance of the dielectric base material.....	13
7.2 Flexural strength.....	13
7.3 Flammability	13
7.4 Water absorption	14
7.5 Measling	14
7.6 Glass transition temperature and cure factor.....	15
7.7 Decomposition temperature	15
7.8 Time to delamination (TMA).....	15
7.9 Halogen content.....	15
8 Quality assurance.....	16
8.1 Quality system	16
8.2 Responsibility for inspection	16
8.3 Qualification inspection.....	16

8.4	Quality conformance inspection	16
8.5	Certificate of conformance	16
8.6	Safety data sheet	16
9	Packaging and marking	16
10	Ordering information	17
Annex A (informative)	Engineering information	18
A.1	General	18
A.2	Chemical properties	18
A.3	Electrical properties	18
A.4	Flammability properties	18
A.5	Mechanical properties	18
A.6	Physical properties	18
A.7	Thermal properties	19
Annex B (informative)	Common laminate constructions	20
Annex C (informative)	Guideline for qualification and conformance inspection	21
Bibliography	22
Table 1	– Electrical properties	7
Table 2	– Size of indentations	8
Table 3	– Nominal thickness and tolerance of metal-clad laminate	9
Table 4	– Bow and twist requirements	10
Table 5	– Pull-off and peel strength requirements	10
Table 6	– Dimensional stability	11
Table 7	– Size tolerances for cut panels	12
Table 8	– Rectangularity of cut panels	12
Table 9	– Thermal conductivity	12
Table 10	– Flexural strength requirements	13
Table 11	– Flammability requirements	14
Table 12	– Water absorption requirements	14
Table 13	– Measling requirements	14
Table 14	– Glass transition temperature and cure factor requirements	15
Table 15	– Decomposition temperature requirements	15
Table 16	– Time to delamination requirements	15
Table 17	– Halogen content	15
Table C.1	– Qualification and conformance inspection	21

INTERNATIONAL ELECTROTECHNICAL COMMISSION

—————

**MATERIALS FOR PRINTED BOARDS AND OTHER
INTERCONNECTING STRUCTURES –**

**Part 2-46: Reinforced base materials clad and unclad – Non-halogenated
epoxide non-woven/woven E-glass reinforced laminate sheets of
thermal conductivity 1,5 W/(m·K) and defined flammability
(vertical burning test), copper-clad for lead-free assembly**

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 itself does not provide any attestation of conformity. Independent certification bodies provide conformity assessment services and, in some areas, access to IEC marks of conformity. IEC is not responsible for any services carried out by independent certification bodies.
- 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 61249-2-46 has been prepared by IEC technical committee 91: Electronics assembly technology.

The text of this International Standard is based on the following documents:

CDV	Report on voting
91/1448/CDV	91/1484/RVC

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

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

A list of all parts of the IEC 61249 series, under the general title *Materials for printed boards and other interconnecting structures*, can be found on the IEC website.

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

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

iTeh STANDARD PREVIEW (standards.iteh.ai)

[IEC 61249-2-46:2018](https://standards.iteh.ai/catalog/standards/sist/e1720219-4a25-4a43-97c8-a62d56899a8d/iec-61249-2-46-2018)

<https://standards.iteh.ai/catalog/standards/sist/e1720219-4a25-4a43-97c8-a62d56899a8d/iec-61249-2-46-2018>

MATERIALS FOR PRINTED BOARDS AND OTHER INTERCONNECTING STRUCTURES –

Part 2-46: Reinforced base materials clad and unclad – Non-halogenated epoxide non-woven/woven E-glass reinforced laminate sheets of thermal conductivity 1,5 W/(m•K) and defined flammability (vertical burning test), copper-clad for lead-free assembly

1 Scope

This part of IEC 61249 gives requirements for properties of non-halogenated epoxide non-woven reinforced core/woven E-glass reinforced surface laminate sheets of thermal conductivity and defined flammability (vertical burning test), copper-clad for lead-free assembly in thicknesses of 0,60 mm up to 1,70 mm. The flammability rating is achieved through the use of non-halogenated fire retardants reacted as part of the epoxide polymeric structure. The glass transition temperature is defined to be 105 °C minimum. Thermal Conductivity is defined to be $(1,5 \pm 0,2)$ W/(m•K).

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements 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 61249-2-46:2018](https://standards.iteh.ai/catalog/standards/sist/e1720219-4a25-4a43-97c8-15c9a1e1c199/iec-61249-2-46-2018)

<https://standards.iteh.ai/catalog/standards/sist/e1720219-4a25-4a43-97c8-15c9a1e1c199/iec-61189-2-2006>

IEC 61189-2:2006, *Test methods for electrical materials, printed boards and other interconnection structures and assemblies – Part 2: Test methods for materials for interconnection structures*

IEC 61249-5-1, *Materials for interconnection structures – Part 5: Sectional specification set for conductive foils and films with and without coatings – Section 1: Copper foils (for the manufacture of copper-clad base materials)*

IEC/PAS 61249-6-3, *Specification for finished fabric woven from "E" glass for printed boards*

ISO 11014, *Safety data sheet for chemical products – Content and order of sections*

3 Terms and definitions

No terms and definitions are listed in this document.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- IEC Electropedia: available at <http://www.electropedia.org/>
- ISO Online browsing platform: available at <http://www.iso.org/obp>

4 Materials and construction

4.1 General

The sheet consists of an insulating base with metal foil bonded to one side or both.

4.2 Resin system

Non-halogenated epoxide, filled, resulting in a laminate with a glass transition temperature of 105 °C minimum.

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

Its flame resistance is defined in terms of the flammability requirements of 7.3.

4.3 Metal foil

Copper as specified in IEC 61249-5-1, copper foil (for the manufacture of copper-clad materials). The preferred foils are electrodeposited of defined ductility.

4.4 Reinforcement

Woven E-glass as specified in IEC/PAS 61249-6-3, woven E-glass fabric (for the manufacture of prepreg and copper-clad material) as the surface sheet on each side of a core reinforcement comprised of non-woven E-glass mat.

5 Electrical properties

The electrical property requirements are shown in Table 1.

Table 1 – Electrical properties

Property	Test method IEC 61189-2	Requirements
Surface resistance after damp heat while in the humidity chamber	2E04	≥5 000 MΩ
Surface resistance after damp heat and recovery (optional)	2E04	≥40 000 MΩ
Volume resistivity after damp heat while in the humidity chamber	2E04	≥5 000 MΩm
Volume resistivity after damp heat and recovery (optional)	2E04	≥10 000 MΩm
Relative permittivity after damp heat and recovery (1 MHz)	2E10	≤6,1
Dissipation factor after damp heat and recovery (1 MHz)	2E10	≤0,040
Arc resistance	2E14	≥60 s
Dielectric breakdown	2E15	≥40 kV
Surface resistance at 125 °C	2E04	≥1 000 MΩ
Volume resistivity at 125 °C	2E04	≥1 00 MΩm

6 Non-electrical properties of the copper-clad laminate

6.1 Appearance of the copper-clad sheet

6.1.1 General

The copper-clad face shall be substantially free from defects that can have an impact on the material's fitness for use for the intended purpose.

For the defects given in 6.1.2 to 6.1.6, the requirements given shall apply when inspection is made in accordance with IEC 61189-2, method 2M18.

6.1.2 Indentations (pits and dents)

The size of an indentation, usually the length, shall be determined and given a point value to be used as a measure of the quality as indicated in Table 2.

Table 2 – Size of indentations

Size mm	Point value for each indentation
0,13 to 0,25	1
0,26 to 0,50	2
0,51 to 0,75	4
0,76 to 1,00	7
Over 1,00	30

The total point count for any 300 mm × 300 mm area shall be calculated to determine the class of the material.

- Class A 29 maximum
- Class B 17 maximum
- Class C 5 maximum
- Class D 0
- Class X To be agreed upon by user and supplier

The required class of material shall be specified in the purchase order. Class A applies unless otherwise specified.

6.1.3 Wrinkles

There shall be no wrinkles in the copper surface.

The inspection area shall exclude a 13 mm border from the edge of the panel or sheet.

6.1.4 Scratches

Scratches deeper than 10 µm or 20 % of the nominal thickness of the foil thickness, whichever is lower, are not permitted.

Scratches with a depth of less than 5 % of the nominal thickness of the foil shall not be counted unless this depth is 10 µm or more.

Scratches with a depth of between 5 % and 20 % of the nominal thickness of the foil are permitted to a total length of 100 mm for a 300 mm × 300 mm area.

The inspection area shall exclude a 13 mm border from the edge of the panel or sheet.

6.1.5 Raised areas

Raised areas are usually impressions in the press plates used during manufacture but may also be caused by blisters or inclusions of foreign particles under the foil.

Raised areas caused by blisters or inclusions are not permitted.

Raised areas being impressions of defects in press plates are permitted to the following extent:

- Class A and X material maximum height 15 µm and maximum length 15 mm;
- Class B and C material maximum height 8 µm and maximum length 15 mm;
- Class D material maximum height 5 µm and maximum length 15 mm.

6.2 Appearance of the unclad face

The unclad face of single side clad sheet shall have the natural appearance resulting from the curing process. Small irregularities in colour are permitted. The gloss of the unclad face shall be that given by the press plate, release film, or release foil used. Variations of gloss due to the impact of the pressure of gases released during the curing are permitted.

6.3 Laminate thickness

If the copper-clad laminate is tested in accordance with test method 2D01 of IEC 61189-2, the thickness shall not depart from the nominal thickness by more than the appropriate value shown in Table 3. The fine tolerances shall apply unless the other tolerances are ordered.

Table 3 – Nominal thickness and tolerance of metal-clad laminate

Property	Test method IEC 61189-2	Nominal thickness including metal foil mm	Tolerance requirement ± mm		
			Coarse	Fine	Extra fine
Thickness	2D01	≥0,60 <0,80	0,08	0,06	0,05
		≥0,80 <1,00	0,17	0,10	0,08
		≥1,00 <1,70	0,19	0,13	0,08

The thickness and tolerances do not apply to the outer 25 mm of the trimmed master sheet or the outer 13 mm of the cut-to-size panel as manufactured and delivered by the supplier. At no point shall the thickness vary from the nominal by a value greater than 125 % of the specified tolerance.

6.4 Bow and twist

When the copper-clad laminate is tested in accordance with test method 2M01 of IEC 61189-2, the bow and twist shall not exceed the values given in Table 4.

Table 4 – Bow and twist requirements

Property	Test method IEC 61189-2	Nominal thickness mm	Panel dimension longest side mm	Requirements %	
				Copper foil on one side	Copper foil on both sides
Bow and twist	2M01	≥0,6 ≤1,3	≤350	≤2,5	≤2,0
			>350 ≤500	≤2,3	≤1,8
		>1,3 ≤1,7	>500	≤2,0	≤1,5
			≤350	≤2,0	≤1,5
		>350 ≤500	≤1,8	≤1,3	
		>500	≤1,5	≤1,0	

The requirements for bow and twist apply only to one sided copper-clad laminates with maximum foil thickness of 105 µm (915 g/m²) and double sided copper-clad laminates with maximum foil thickness difference of 70 µm (610 g/m²).

Requirements for laminates with copper foil configurations beyond these limits should be subject to agreement between purchaser and supplier.

6.5 Properties related to the copper foil bond

Pull-off and peel strength requirements are shown in Table 5. These requirements apply to copper foil with a normal profile depth.

Table 5 – Pull-off and peel strength requirements

Property	Test method IEC 61189-2	IEC 61249-2-46:2018 Requirement		
Pull-off strength	2M05	≥25 N		
		Thickness of the copper foil		
		18 µm (152 g/m ²)	≥35 µm (305 g/m ²)	≥70 µm (610 g/m ²)
Peel strength after heat shock 288 °C, 20 s	2M14	≥0,8 N/mm	≥1,0 N/mm	≥1,2 N/mm
		No blistering or delamination		
Peel strength after dry heat 125 °C	2M15	Under consideration	Under consideration	Under consideration
		No blistering or delamination		
Peel strength after exposure to solvent vapour. Solvents as agreed upon between purchaser and supplier	2M06	≥0,8 N/mm	≥1,0 N/mm	≥1,2 N/mm
		No blistering or delamination		
Peel strength after simulated plating	2M16	Under consideration	Under consideration	Under consideration
		No blistering or delamination		
Peel strength at high temperature Temperature 125 °C (optional)	2M17	≥0,6 N/mm	≥0,7 N/mm	≥0,9 N/mm
Blistering after 288 °C, 20 s heat shock	2C05	No blistering or delamination		

In case of difficulty due to breakage of the foil or reading range of the force measuring device, the measurement of peel strength at high temperature may be carried out using conductor widths of more than 3 mm.

6.6 Punching and machining

The laminate shall, in accordance with the manufacturer's recommendations, be capable of being punched, sheared or drilled. Delamination at the edges due to the shearing process is permissible, provided that the depth of delamination is not larger than the thickness of the base material. Delamination at the edges of drilled holes due to the drilling process is not permissible. Drilled holes shall be capable of being through-plated with no interference from any exudations into the hole.

A suitable test method for evaluating punching is 2M19 of IEC 61189-2. Requirements for punching force and pull-out force are matters for agreement between user and supplier.

6.7 Dimensional stability

When specimens are tested in accordance with IEC 61189-2, 2X02 the observed tolerance shall be as specified in Table 6. The nominal dimensional stability value shall be as agreed upon between user and vendor. The tolerance range around the agreed upon nominal range shall be range B unless otherwise specified on the purchase order.

Table 6 – Dimensional stability

Property	Test method IEC 61189-2	Class	Requirement µm/m
Dimensional stability	2X02	A	±600
		B	±400
		C	±200
		X	As agreed upon between user and supplier

IEC 61249-2-46:2018
<https://standards.iteh.ai/catalog/standards/sist/e1720219-4a25-4a43-97c8-a62d56899a8d/iec-61249-2-46-2018>

The choice of the glass fabrics and cellulose papers in the construction of the laminate has a significant impact on dimensional stability. Examples of typical constructions used in printed board applications can be found in Annex B. Annex B is not a construction requirement table but is presented for engineering information only.

6.8 Sheet sizes

6.8.1 Typical sheet sizes

Sheet sizes are matters of agreement between purchaser and supplier. However, the recommended sizes are listed below:

- 915 mm × 1 220 mm;
- 1 020 mm × 1 220 mm;
- 1 070 mm × 1 220 mm;
- 1 065 mm × 1 155 mm;
- 1 065 mm × 1 280 mm;
- 1 000 mm × 1 000 mm;
- 1 000 mm × 1 200 mm.

6.8.2 Tolerances for sheet sizes

The size of the sheet delivered by the supplier shall not deviate by more than $\pm \begin{smallmatrix} 25 \\ 0 \end{smallmatrix}$ mm from the ordered size.

6.9 Cut panels

6.9.1 Cut panel sizes

Cut panel sizes shall be, when delivered, in accordance with the purchaser's specification.

6.9.2 Size tolerances for cut panels

For panels cut to size according to the purchaser's specification, the tolerances for length and width shall apply as shown in Table 7. Tolerances indicated as "normal" shall be in effect unless otherwise specified in the purchasing specification.

Table 7 – Size tolerances for cut panels

Panel size mm	Tolerance requirement ± mm	
	Normal	Close
≤300	2,0	0,5
>300 ≤600	2,0	0,8
>600	2,0	1,6

NOTE The specified tolerances include all deviations caused by cutting the panels.

6.9.3 Rectangularity of cut panels

For panels cut to size according to the purchaser's specification, the requirements for rectangularity shall apply as shown in Table 8. Tolerance indicated as "normal" shall be in effect unless otherwise specified in the purchasing specification.

<https://standards.iteh.ai/catalog/standards/sist/e1720219-4a25-4a43-97c8-a2d578998d1/iec-61249-2-46-2018>

Table 8 – Rectangularity of cut panels

Property	Test method IEC 61189-2	Requirement mm/m	
		Normal	Close
Rectangularity of cut panels	2M23	≤3	≤2

6.10 Thermal conductivity

The thermal conductivity shall meet the requirement in Table 9.

Table 9 – Thermal conductivity

Property	Test method	Nominal Value W/(m•K)	Tolerance W/(m•K)
Thermal conductivity	2XXX ^a	1,5	±0,20

^a Under consideration (steady-state heat flow method).

7 Non-electrical properties of the base material after complete removal of the copper foil

7.1 Appearance of the dielectric base material

The etched specimens shall be inspected to verify that no surface or subsurface imperfections of the dielectric material exceed those shown below. The panels shall be inspected using an optical aid apparatus which provides a minimum magnification of 4×.

Referee inspection shall be conducted at 10× magnification. Lighting conditions of inspection shall be appropriate to the material under inspection or as agreed upon between user and supplier.

Surface and subsurface imperfections (such as weave texture, resin starvation, voids, foreign inclusions) shall be acceptable provided that the imperfections meet the following:

- the reinforcement fibres are not cut or exposed;
- the foreign inclusions are not conductive;
- metallic inclusions are not acceptable;
- the imperfections do not propagate as a result of thermal stress;
- the foreign inclusions are translucent;
- opaque foreign fibres are less than 15 mm in length and average no more than 1,0 per 300 mm × 300 mm area;
- opaque foreign inclusions other than fibres shall not exceed 0,50 mm. Opaque foreign inclusions less than 0,15 mm shall not be counted. Opaque foreign inclusions between 0,50 mm and 0,15 mm shall average no more than two spots per 300 mm × 300 mm area;
- voids (sealed voids or surface void) have a longest dimension less than 0,075 mm and there shall not be more than three voids in a 3,5-mm diameter circle.

7.2 Flexural strength

When the laminate is tested in accordance with test method 2M20 of IEC 61189-2, the flexural strength shall be as shown in Table 10.

Table 10 – Flexural strength requirements

Property	Test method IEC 61189-2	Requirements
Flexural strength Length direction Cross direction (applicable to sheets ≥0,80 mm – 1,70 mm in thickness)	2M20	≥250 N/mm ² ≥150 N/mm ²
Flexural strength at elevated temperature Length direction (applicable to sheets ≥0,80 mm – 1,70 mm in thickness)		Not specified

7.3 Flammability

When the laminate is tested in accordance with test method 2C06 of IEC 61189-2, the flammability shall be as shown in Table 11.