

# INTERNATIONAL STANDARD

## NORME INTERNATIONALE

**Materials for printed boards and other interconnecting structures –  
Part 2-36: Reinforced base materials, clad and unclad – Epoxy woven E-glass  
laminated sheets of defined flammability (vertical burning test), copper-clad for  
lead-free assembly**

[IEC 61249-2-36:2008](https://standards.iteh.ai/catalog/standards/sist/7675e127-bec0-46c6-bb18-11d999999999/iec-61249-2-36-2008)

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**Matériaux pour circuits imprimés et autres structures d'interconnexion –  
Partie 2-36: Matériaux de base renforcés, plaqués et non plaqués – Feuilles  
stratifiées en tissu de verre de type E époxyde, plaquées cuivre, d'inflammabilité  
définie (essai de combustion verticale) pour les assemblages sans plomb**



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## CONTENTS

FOREWORD.....	4
1 Scope.....	6
2 Normative references.....	6
3 Materials and construction .....	6
3.1 Resin system.....	6
3.2 Metal foil .....	7
3.3 Reinforcement.....	7
4 Internal marking.....	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 Indentations (pits and dents).....	8
6.1.2 Wrinkles .....	8
6.1.3 Scratches .....	8
6.1.4 Raised areas .....	8
6.1.5 Surface waviness.....	9
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.....	12
6.8.1 Typical sheet sizes .....	12
6.8.2 Tolerances for sheet sizes .....	12
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 .....	13
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.....	14
7.3 Flammability .....	14
7.4 Water absorption .....	14
7.5 Measling.....	15
7.6 Glass transition temperature and cure factor .....	15
7.7 Decomposition temperature .....	15
7.8 Thermal resistance .....	16
7.9 Z-axis expansion .....	16
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 .....	17

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(standards.iteh.ai)

IEC 61249-2-36:2008

<https://standards.iteh.ai/catalog/standards/sist/7675e127-bec0-46c6-bb18-1e8c1649184/iec-61249-2-36-2008>

1e8c1649184/iec-61249-2-36-2008

8.5	Certificate of conformance .....	17
8.6	Safety data sheet.....	17
9	Packaging and marking.....	17
10	Ordering information .....	17
	Annex A (informative) Engineering information .....	19
	Annex B (informative) Common laminate constructions.....	21
	Annex C (informative) Guidelines for qualification and conformance inspection .....	22
	Bibliography .....	23
	Table 1 – Electrical properties .....	7
	Table 2 – Nominal thickness and tolerance of metal-clad laminate .....	9
	Table 3 – Bow and twist .....	10
	Table 4 – Pull-off and peel strength .....	11
	Table 5 – Dimensional stability .....	12
	Table 6 – Size tolerances for cut panels .....	13
	Table 7 – Rectangularity of cut panels .....	13
	Table 8 – Flexural strength.....	14
	Table 9 – Flammability .....	14
	Table 10 – Water absorption .....	15
	Table 11 – Measling .....	15
	Table 12 – Glass transition temperature and cure factor .....	15
	Table 13 – Decomposition temperature .....	16
	Table 14 – Thermal resistance .....	16
	Table 15 – Z-axis expansion.....	16

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INTERNATIONAL ELECTROTECHNICAL COMMISSION

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

**Part 2-36: Reinforced base materials, clad and unclad –  
Epoxide woven E-glass laminate sheets of defined flammability  
(vertical burning test), copper-clad for lead-free assembly**

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International Standard IEC 61249-2-36 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
91/801/FDIS	91/824/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.

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 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

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## MATERIALS FOR PRINTED BOARDS AND OTHER INTERCONNECTING STRUCTURES –

### Part 2-36: Reinforced base materials, clad and unclad – Epoxide woven E-glass laminate sheets of defined flammability (vertical burning test), copper-clad for lead-free assembly

#### 1 Scope

This part of IEC 61249 gives requirements for properties of di-functional brominated epoxide woven E-glass laminate sheet 0,05 mm up to 3,2 mm, of defined flammability (vertical burning test), copper-clad. The glass transition temperature is defined to be 120 °C minimum.

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

Some property requirements may have several classes of performance. The class desired should be specified on the purchase order otherwise the default class of material will be supplied.

#### 2 Normative references

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

IEC 61249-5-1:1995, *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)*

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

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

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

#### 3 Materials and construction

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

##### 3.1 Resin system

Majority di-functional epoxide, modified epoxide, woven E-glass laminate with a glass transition temperature of 120 °C minimum. The flammability rating is achieved through the use of bromine reacted into the polymer. Inorganic fillers may be used. 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.



### 3.2 Metal foil

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

### 3.3 Reinforcement

Woven E-glass as specified in the future IEC 61249-6-3, woven E-glass fabric (for the manufacture of prepreg and copper clad materials).

## 4 Internal marking

Not specified.

## 5 Electrical properties

The electrical property requirements are shown in Table 1.

**Table 1 – Electrical properties**

Property	Test method (IEC 61189-2)	Requirements
Resistance of foil	2E12	As specified in IEC 61249-5-1
Surface resistance after damp heat while in the humidity chamber (optional)	2E03	≥10 000 MΩ
Surface resistance after damp heat and recovery	IEC 61249-2-36:2008 2E03	≥50 000 MΩ
Volume resistivity after damp heat while in the humidity chamber (optional)	2E04	≥5 000 MΩm
Volume resistivity after damp heat and recovery	2E04	≥10 000 MΩm
Relative permittivity after damp heat and recovery (1 MHz)	2E10	≤5,4
Dissipation factor after damp heat and recovery (1 MHz)	2E10	≤0,035
Electric strength (only for material thickness less than 0,5 mm)	2E11	≥30 kV/mm
Arc resistance	2E14	≥60 s
Dielectric breakdown (only for material thicknesses ≥0,5 mm)	2E15	≥40 kV
Surface resistance at 125 °C	2E07	≥1 000 MΩ
Volume resistivity at 125 °C	2E07	≥1 000 MΩm

## 6 Non-electrical properties of the copper-clad laminate

### 6.1 Appearance of the copper-clad sheet

The copper-clad face 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 2M18.

### 6.1.1 Indentations (pits and dents)

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

Size mm	Point value for each indentation
0,13 – 0,25	1
0,26 – 0,50	2
0,51 – 0,75	4
0,76 – 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

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

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### 6.1.2 Wrinkles

There shall be no wrinkles in the copper surface.

### 6.1.3 Scratches

Scratches deeper than 20 % of the nominal thickness of the foil thickness are not permitted.

Scratches with a depth 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 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.

### 6.1.4 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.

### 6.1.5 Surface waviness

When examined in accordance with test method 2M12 of IEC 61189-2, the surface waviness in both the machine and cross machine direction shall not exceed 7 µm.

## 6.2 Appearance of the unclad face

The unclad face of a 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 or release foil used. Variations of gloss due to the impact of pressure of gases released during the curing are permitted.

## 6.3 Laminate thickness

The laminate thickness may be ordered to include or exclude the copper foil contribution as specified in the purchase order. As a general rule, laminates less than 0,8 mm are measured excluding copper, and laminates greater or equal to 0,8 mm are measured including copper. 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 2. The fine tolerances shall apply unless the other tolerances are ordered.

**Table 2 – Nominal thickness and tolerance of metal-clad laminate**

Nominal thickness excluding metal foil (material intended for multilayer boards) mm	Nominal thickness including metal foil (material intended for single or double sided boards) mm	Tolerance requirements ± mm		
		Coarse	Fine	Extra fine
≥0,05 ≤0,10		0,03	0,02	0,01
>0,10 ≤0,15		0,04	0,03	0,02
>0,15 ≤0,30		0,05	0,04	0,03
>0,30 ≤0,50		0,08	0,05	0,04
>0,50 ≤0,80		0,09	0,06	0,05
>0,80 ≤1,00	≥0,80 ≤1,00	0,13	0,09	0,07
>1,00 ≤1,30	>1,00 ≤1,30	0,17	0,11	0,08
	>1,30 ≤1,70	0,20	0,13	0,10
	>1,70 ≤2,10	0,23	0,15	0,12
	>2,10 ≤2,60	0,25	0,18	0,15
	>2,60 ≤3,20	0,30	0,20	0,15

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 3.

**Table 3 – Bow and twist**

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	≥0,8 ≤1,3	≤350	≤2,0	≤1,5
			>350 ≤500	≤1,8	≤1,3
			>500	≤1,5	≤1,0
		>1,3 <1,7	≤350	≤1,5	≤1,0
			>350 ≤500	≤1,3	≤0,8
			>500	≤1,0	≤0,5
		≥1,7 ≤3,2	≤350	≤1,0	≤0,5
			>350 ≤500	≤0,8	≤0,4
			>500	≤0,5	≤0,3

NOTE 1 The requirements for bow and twist apply only to one-sided, copper-clad laminates with maximum foil thickness of 105 μm (915 g/m<sup>2</sup>) and double-sided, copper-clad laminates with maximum foil thickness difference of 70 μm (610 g/m<sup>2</sup>).

NOTE 2 Requirements for laminates with copper foil configurations beyond these limits are subject to agreement between purchaser and supplier.

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**6.5 Properties related to the copper foil bond**

Pull-off and peel strength requirements are shown in Table 4. These requirements apply to copper foil with a normal profile depth. In the case of low or very low profile copper foil, the requirements shall be at least 50 % of that shown in Table 4 as a minimum.

**Table 4 – Pull-off and peel strength**

Property	Test method (IEC 61189-2)	Requirements			
<b>Pull-off strength</b>	<b>2M05</b>	<b>≥25 N</b>			
		<b>Thickness of the copper foil</b>			
		≤12 μm (≤101 g/m <sup>2</sup> )	18 μm (152 g/m <sup>2</sup> )	35 μm (305 g/m <sup>2</sup> )	≥70 μm (≥610 g/m <sup>2</sup> )
Peel strength after heat shock of 20 s	2M14	≥0,7 N/mm	≥0,9 N/mm	≥1,2 N/mm	≥1,6 N/mm
		No blistering nor delamination			
Peel strength after dry heat 125 °C	2M15	≥0,7 N/mm	≥0,9 N/mm	≥1,2 N/mm	≥1,6 N/mm
		No blistering nor delamination			
Peel strength after exposure to solvent vapour. Solvents as agreed upon between purchaser and supplier	2M06	≥0,7 N/mm	≥0,9 N/mm	≥1,2 N/mm	≥1,6 N/mm
		No blistering nor delamination			
Peel strength after simulated plating	2M16	≥0,6 N/mm	≥0,8 N/mm	≥1,0 N/mm	≥1,2 N/mm
		No blistering nor delamination			
Peel strength at high temperature Temperature 125 °C (optional)	2M17	Not specified	≥0,7 N/mm	≥0,9 N/mm	≥1,1 N/mm
		No blistering nor delamination			
Blistering after 20 s heat shock	2C05	No blistering nor delamination			
NOTE 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

Punching is not applicable. The laminate shall, in accordance with the manufacturer's recommendations, be capable of being 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.

## 6.7 Dimensional stability

The dimensional stability requirements are shown in Table 5. When specimens are tested in accordance to IEC 61189-2, method 2X02, the observed tolerance shall be as specified in Table 5. The nominal dimensional stability value shall be as agreed upon between user and vendor. The tolerance range around the agreed upon nominal thickness shall be range B, unless otherwise specified on the purchase order.

The choice of the glass fabrics 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.

Class A performance shall apply unless otherwise noted on the purchase order.

**Table 5 – Dimensional stability**

Property	Test method (IEC 61189-2)	Class	Requirements ppm
Dimensional stability	2X02	A	±300
		B	±200
		C	±100
		X	As agreed upon between user and supplier

**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;
- 1 065 mm × 1 155 mm;
- 1 065 mm × 1 280 mm;
- 1 000 mm × 1 000 mm;
- 1 000 mm × 1 200 mm.

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**6.8.2 Tolerances for sheet sizes**

The size of sheet delivered by the supplier shall not deviate more than  $\begin{matrix} +20 \\ 0 \end{matrix}$  mm from the ordered size.

<https://standards.iteh.ai/catalog/standards/sist/7675e127-bec0-46c6-bb18-1e8c1f649f84/iec-61249-2-36-2008>

**6.9 Cut panels**

**6.9.1 Cut panel sizes**

On delivery, cut panel sizes shall be 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 following tolerances for length and width shall apply as shown in Table 6. Tolerances indicated as normal shall be in effect unless otherwise specified by in the purchasing specification.

**Table 6 – Size tolerances for cut panels**

Panel size mm	Tolerance requirements ± 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 following requirements for rectangularity shall apply as shown in Table 7. Tolerance indicated as normal shall be in effect unless otherwise specified in the purchasing specification.

**Table 7 – Rectangularity of cut panels**

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

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## 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 4X.

Referee inspection shall be conducted at 10X 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.
- 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 one fibre 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.