

SILICONE RUBBER PRESS PADS

Multilayer, Flexible Circuitry, Rigid/Flex Laminations

Saint-Gobain® Norseal® Silicone Rubber Press Pads 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.

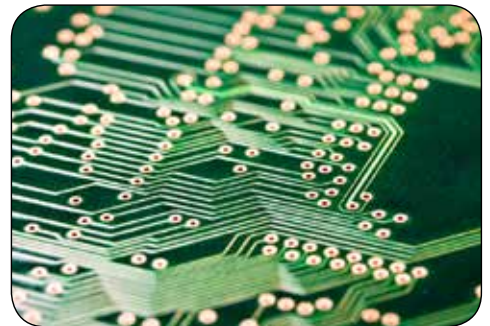
Saint-Gobain brings decades of experience with PTFE and thermoplastic bonding films to this product line. Our knowledge of this technology enables us to produce **Norseal** press pads that provide substantial cycle life without silicone reversion.

Norseal press pads products are specially designed 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 COHRElastic 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	81	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	3.9	15
Color	—	Red	Brown	Red	Dark Gray	Charcoal Gray
Temperature °F	—	350 Max	350-400	350-400	380-600	575 Max
Width in. (cm)	—	36 (91.4)	36 (91.4), 40 (102)	36 (91.4)	38 (96.5)	36 (91.4) x 36 (91.4) sheets

Norseal Silicone Rubber Press Pads

Product No.	Thickness mm (in.)
3320	.063, .094, and .125 (1.59, 2.38, and 3.18)
4420	.045 and .063 (1.15 and 1.59)
4444	.063, .094, and .125 (1.59, 2.38, and 3.18)
4480	.063 (1.59)
555	.250 (6.53)

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)

- Talc-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

10 years after the date of sale for base material when stored in original packaging at temperatures up to 70°F (21°C) and 50% relative humidity (for optional PSA, see other data sheets).

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 misuse of the materials it provides arising out of the design, fabrication or application of the products into which the materials are incorporated.

WARRANTY: For a period of 6 months, Saint-Gobain warrants this product(s) to be free from defects in manufacturing. The only obligation under any applicable product warranty will be to replace any portion proving defective, or at our option, to refund the purchase price thereof. SAINT-GOBAIN DISCLAIMS ALL IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.

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