

**Description:**

POLYONICS XF-541 is a polyimide film with a permanent pressure sensitive acrylic adhesive and a high opacity, MATTE Tan or "Buff" colored topcoat specifically designed for EITHER thermal transfer or dot matrix printing.

Properties:

The print resists smearing, when immersed in Zestron for 5 minutes, and then wiped with a lint free cloth. Preheating the labeled product can further enhance print permanence in the case of extreme solvent and/or abrasion exposure, although this is not typically required for board processing applications. Printed in combination with the appropriate thermal transfer ribbon, passes the requirements of **MIL-STD-202G, Notice 12, Method 215K**.

Applications:

- POLYONICS XF-541 is specifically designed for high-temperature-lead-free solder applications.
- It is the ideal label to withstand surface mount board processes, on either the top or bottom side of the board. It can also be used on the top side of the board in mixed processes, and is recommended for the bottom side that is directly exposed to the wave solder environment.
- The XF-541 material when used with the appropriate ribbon will withstand exposure to a wide range of ether-polyol solvents, such as Zestron® (Dr. O.K.Wack Chemie GmbH), Prozone, or other active solvents such as Loctite 7452 Accelerator.
- XF-541 is particularly useful in manufacturing processes where dimensional stability of the label is critical.
- IC labeling for work in process, permanent ID & warranty labeling
- Product ID, asset tracking
- Anywhere a label will be exposed to extreme temperatures
- Designed to work in automatic label application equipment

Special Considerations:

- The surface that you want to label should be clean, dry and free of any surface contamination, such as dust, oil or rust. Isopropyl alcohol would be a recommend solvent to clean the surface.
- When you apply the label, you must use firm pressure to increase the physical contact of the adhesive with the surface of the product.
- Pressure sensitive adhesives will provide stronger bonds to a warm surface, as compared to a colder one. The adhesive will 'flow' more readily, increasing the surface area and increasing the adhesion peel strength.
- The XF-541 top coat & print should not be contacted while exposed to elevated temperature.
- All values shown are averages and should not be used for specification purposes. Adhesion and tack values have a 15% tolerance allotted to the above values stated.
- Test data and test results contained in this document are for general information only and shall not be relied upon by POLYONICS customers for designs and specifications, or be relied on as meeting specified performance criteria.
- Customers desiring to develop specifications or performance criteria for specific product applications should contact Polyonics for further information



Technical Data

Properties	Test Methods	Average Results	
		USA Units	SI Units
Thickness	ASTM D1000		
-Face sheet		0.0027 inch	0.068 mm
-Adhesive		0.0020 inch	0.050 mm
-Total		0.0047 inch	0.118 mm
Adhesion	Polyonics 80313		
-Stainless Steel	20 minute dwell	35 oz/in	39 N/100 mm
	24 hour dwell	40 oz/in	44 N/100 mm
Tack	Polyonics 80155	≥ 1200 g/in	
Weatherometer Testing	ASTM G154	Coating turned white/slight print deterioration	
Temperature Rating:	Long term	100 hours at 302°F (125°C)	
	Operating	5 minutes at 500°F (260°C)	
	Short term	90 seconds at 572°F (300°C)	
Shelf Life	1 year below 80°F (27°C) and 60% R.H.		
UL File #	PJI2.MH19503		
UL tested ribbons	Ricoh B110A		

Durability Testing

Properties	Test Methods	Test Environment	PCS ¹	Read Rate ²
Heat/Chemical	Polyonics 80386	Control 70°C, 5 min.	99%	100%
		Zestron, 5 minutes 25°C	100%	99%

Chemical Testing

Properties	Test Method	Test Fluid	Results
Chemical Resistance	MIL-STD-202G, Notice 12, Method 215K		
		Solvent A- 1 part IPA, 3 parts Mineral Spirits	No visible effect
		Solvent B- 1,1,1- Trichloroethane	Solvent deleted per notice 12
		Solvent C- Terpene Defluxer	No visible effect
		Solvent D- Saponifier	No visible effect

Polyonics Material Compliance

RoHS- Restriction of Hazardous Substances (EU Directive 2002/95/EC)	Limits set forth in Directive 2005/618/EC amending Directive 2002/95/EC
REACH- Registration Evaluation and Authorization of Chemicals (EU Directive 1907/2006/EC)	Limits set forth in Directive 1907/2006/EC Article 7 (2)
Halogens- Restriction use of Halogen (IEC 61249-2-21)	Limits set forth in International Electrochemical Commission



Key for Tables on page 2

- All SI units are mathematically derived from U.S. conventional units.
- Labels printed with recommended thermal transfer ribbon. Labels printed with 6.7 mil X dimension bars at 2:5. Labels exposed to indicated environments.
- ¹PCS - Print Contrast Signal. PCS determined with Quick Check 650, 0.005" aperture, 660 nm wavelength.
- Quick Check 650 manufactured by Photographic Sciences Corp.
- ² Read rate determined using a PSC Quick check 850 laser scanner.

Trademark:

Zestron

Reference:

ASTM: American Society of Testing and Materials (U.S.A.)

SI: International System of Units.



WARRANTY-LIMITATION

Polyonics' products are sold with the understanding that the Buyer will test them in actual use and determine for him/herself their adaptability to his/her intended uses. Polyonics warrants to the Buyer that its products are free from defects in material and workmanship, but limits its obligation under this warranty to replacement of the products shown to Polyonics' satisfaction to have been defective, provided that the Buyer has complied with the handling, storage and shelf life requirements as specified by Polyonics in applicable materials specifications.

The above warranties extend solely to Buyer and all warranty claims must be made by Buyer. Rework or Replacement shall neither extend nor decrease the original warranty period. The term of all warranty periods shall not exceed thirty (30) days from the date of the original shipment.

THE ABOVE WARRANTIES ARE EXCLUSIVE OF AND IN LIEU OF ALL OTHER WARRANTIES, WRITTEN OR ORAL, EXPRESS OR IMPLIED, STATUTORY OF OTHERWISE. NO IMPLIED STATUTORY WARRANTY OF MERCHANTABILITY OR OF FITNESS FOR A PARTICULAR PURPOSE SHALL APPLY. POLYONICS SHALL NOT BE LIABLE EITHER IN TORT OR IN CONTRACT FOR ANY LOSS OR DAMAGE, DIRECT, INCIDENTAL OR CONSEQUENTIAL, ARISING OUT OF THE USE OR INABILITY TO USE THE PRODUCT, OR FROM DELAY IN THE REPLACEMENT OR REPAIR OF PRODUCTS UNDER THE ABOVE WARRANTY.

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