



**Thermal Transfer Printable Polyimide  
1 mil STATIC DISSIPATIVE, LIGHT GREEN**

**Description:** POLYONICS XF-705 is a special 1 mil (25µ) polyimide film with a high-temperature permanent pressure sensitive acrylic adhesive and a high opacity, semi-gloss, light green tinted topcoat specifically designed for thermal transfer printing. Using a 1 mil vs. a 2 mil polyimide film base offers polyimide thermal performance at less cost. **XF-705 is deemed to be a STATIC SAFE product in accordance with EIA 625, EIA 541. The Test Methods employed were in accordance with EOS/ESD S11.11.**

**Use:** POLYONICS XF-705 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 which is directly exposed to the wave solder environment. XF-705 is particularly useful in manufacturing processes where dimensional stability of the label is critical.

**Properties:** The XF-705 topcoat, in combination with the appropriate thermal transfer ribbon, passes the requirements of **MIL-STD-202G, Notice 12, Method 215K** and **MIL-STD-883E, Notice 4, Method 2015.13**. The print resists smearing, even when the board and label are directly removed from a reflow or wave solder environment. 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. **Moreover, when the label is peeled from its release liner, less than 25 volts per square inch of electrostatic charge is generated, making it safe to use in a static free work environment, per EIA 625 and 541..**

Properties	Test Methods	Average Results	
		USA Units	SI Units
<b>Thickness</b>	<b>ASTM D1000</b>		
-Substrate		0.0015 inch	0.038 mm
-Adhesive		0.0010 inch	0.025 inch
-Total		0.0025 inch	0.064 mm
<b>Adhesion</b>	<b>Polyonics 80313</b>		
<b>Stainless Steel</b>	<b>20 minute dwell</b>	27 oz/in	30N/100 mm
	<b>24 hour dwell</b>	30 oz/in	33N/100 mm
<b>Tack</b>	<b>Polyonics 80155</b>		
		≥ 1000g	
<b>Surface Resistivity</b>	<b>EOS/ESD S.11.11</b>	Label Surface >10 <sup>7</sup> Ohms	
<b>Peel Value</b>	<b>Polyonics 80331</b>	<25 volts	
<b>Temperature Rating:</b>		-40 to 550°F (-40 to 287°C)	
<b>Shelf Life</b>		1 year below 80°F and 60% R.H.	
<b>UL File #</b>		TBD	
<b>Ribbon recommendations</b>		Armor AXR7+, Sony 4070, JPP1, Ricoh B110C, Union Chemicar US300, DNP R510	

All SI units are mathematically derived from U.S. conventional units.

**Note.** All values shown are averages and should not be used for specification purposes. Adhesive and Tack values have a 10% tolerance allotted to the above stated values. 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.

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Labels printed with a recommended thermal transfer ribbon. Labels printed with 6.7 mil X dimension bars at 2:5 ratio. Labels exposed to indicated environments.

Properties	Test Method	Test Environment	PCS <sup>1</sup>	Read Rate <sup>2</sup>
Heat/Chemical Resistance	Polyonics	Control	99%	100%
		Alpha Metals Inc. 2110 Saponifier 10% aqueous, 65-70°, 5 min.	99%	100%
		Isopropanol 99%, 65-70°, 5 min.	97%	100%
		Kyzen XJN+ 30%, 5 min.	99%	100%

<sup>1</sup>PCS - Print Contrast Signal. PCS determined with Quick Check 650, 0.005" aperture, 660 nm wavelength. Quick Check 650 manufactured by : Photographic Sciences Corp.

<sup>2</sup> Read rate determined using a PSC Quick Check 850 laser scanner.

Properties	Test Method	Test Fluid	Results
Chemical Resistance	MIL-STD-202G, Notice 12, Method 215K MIL-STD-883E, Notice 4, Method 2015.13		
		Solvent A- 1part IPA, 3 parts Mineral Spirits	No visible effect
		Solvent B- Trichloroethane	Solvent deleted per Notice 12
		Solvent C- Terpene Defluxer	No visible effect
		Solvent D- Saponifier	No visible effect

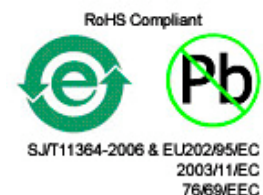
**Trademarks:**

XJN+ & Aquanox SSA-TM is a trademark of Kyzen Corporation

**References:**

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

SI: International System of Unit.


**WARRANTY-LIMITATION**

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