



**TECHNICAL DATA SHEET**

# Phenolic Coated Nomex® - 410X2PH1 (Single Sided) Phenolic B-Stage - 410X2PH2 (Double Sided)

A flexible composite insulation composed of 2 mil 410 Nomex® aramid paper coated on one or both sides with Alamotape® Phenolic based thermosetting adhesive system. The thermosetting adhesive is applied to the Nomex® in b-stage form. Once b-staged, the product can be heated and pressed for full cure bonding to many substrates. The adhesive is tack free at room temperature - no release liner is needed.

### PRODUCT ATTRIBUTES

- Excellent thermal stability, electrical properties, and chemical resistance
- Extremely high adhesive bond strength
- High continuous temperature resistance
- RoHS and REACH compliant

REPRESENTATIVE PHYSICAL PROPERTIES			
PROPERTY	VALUE		TEST METHOD
<b>NOMINAL THICKNESS</b> (double coated)	0.004 inches		ASTM D374
<b>YIELD:</b>	<u>Single Coat</u>	<u>Double Coat</u>	
Square yards per pound	8.54	6.2	
Pounds per square yard	0.12	0.16	
<b>DIELECTRIC STRENGTH</b> (2-inch diameter electrodes)	1500 Volts		ASTM D149
<b>TENSILE STRENGTH:</b>			
Machine Direction (MD)	26 lb/in		ASTM D828
Cross Machine Direction (XMD)	12 lb/in		
<b>DIELECTRIC CONSTANT</b>	3.0 (23°C, 50% RH, 60 Hz)		ASTM D150
<b>180° PEEL ADHESION (stainless steel):</b>			
Phenolic on Nomex	Exceeds strength of Nomex > 30 lb/in		ASTM D3330
Phenolic on 7 mil Al foil			
<b>LAMINATION PARAMETERS:</b>			
Temperature	310°F		
Time	30 minutes		
Pressure	25 - 75 psi		
<b>OPERATING TEMPERATURE</b>	-40°C - 220°C		

*Lamination Parameters are to be used as guidelines only. Samples should be tested for each application to insure proper usability. Parameters can be adjusted to match performance requirements, but curing temperature should never fall below 310°F.*

### STORAGE

- Shelf life: one (1) year from date of shipment.
- Store in a clean area free from exposure to excessive heat, moisture, or direct sunlight (50°F to 80°F).

*Product performance will vary in each application and is dependent upon composite construction. Alamotape does not guarantee the replication of this data by third parties. None of the data or statements contained herein is intended to warrant the performance of this product. Data is representative and not intended as a manufacturing specification.*