

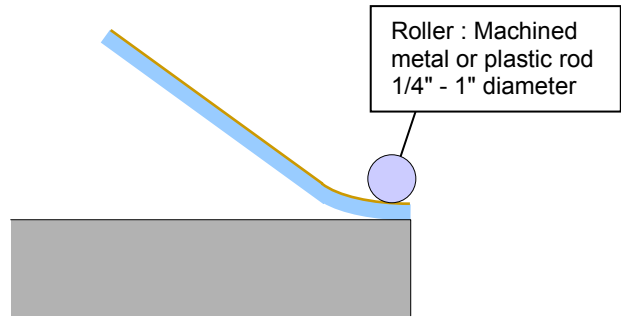


SILICONE TECHNOLOGIES DIVISION  
1100 Governor Lea Road, Bear, DE 19701  
(302) 834-2100 (302) 834-4021 (Fax)

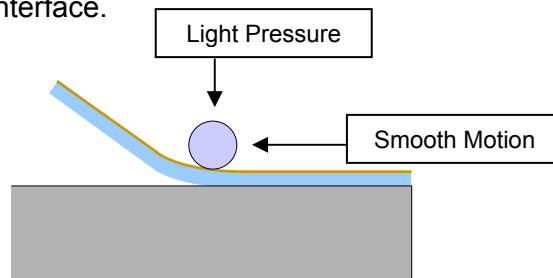
## Thermabond® Application Notes -D001 Liner Removal Techniques and Heat Sink Application

Typically, the most difficult part of working with Thermabond® is liner removal after the material has been tacked to the heat sink. The key to this process is avoid trapping air at this interface. If not removed, the material tends to "lift up" when the brown liner is removed, causing distortion, wrinkles, and more air entrapment. This procedure ensures that the air is removed every time, making adhesive attachment a simple and repeatable process.

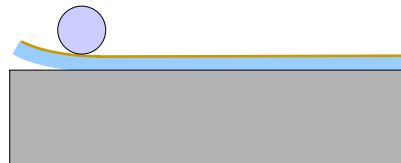
**Step 1** – After removing clear liner, tack material to one edge with brown liner on top. Hold opposite edge up. Place rolling pin at tacked edge and roll towards opposite side. Use light pressure and a smooth motion.



**Step 2** - Roller must remain flat to ensure even pressure. Use only enough pressure to flatten the Thermabond to the surface. Roller will push all air from the heatsink/adhesive interface.



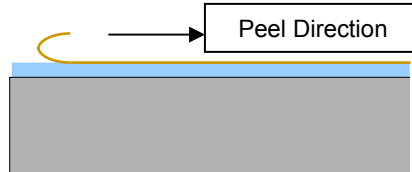
**Step 3** - Roll entire surface in a continuous motion. No air should be present. If air bubbles are present, press out to edges with fingers. A pin can be used to pierce the brown liner to aid in air removal.



# Liner Removal Techniques and Heat Sink Application

## **Step 4 - Liner Removal after heatsink attachment.**

Start peel at a corner. If the rubber pulls up, push liner and rubber back down to get a tack to the surface, then continue peel. Do not allow rubber to wrinkle. If it does even though the steps above have been followed, see step 5 - Troubleshooting Liner Removal.



## **Step 5 - Troubleshooting Liner Removal**

The most common causes for the liner to not release from the rubber and stay on your heatsink (or circuit board if done in reverse due to 3-D heatsinks) are:

- 1) Contamination on the heatsink surface or
- 2) Air entrapped at the interface.

The above procedure is designed to solve the air entrapment issues in condition 2.

Surface contamination can come from a number of sources, as addressed in A, B, & C below.

- A) Oils remaining on the surface of the heatsink

Thorough cleaning with a solvent (i.e., acetone or isopropyl alcohol) will remove most rolling and machining oils. See the Thermabond Fabrication Guide for details.

- B) Improper primer application (usually over-priming)

To avoid over priming, follow the procedure outlined in the Thermabond Fabrication Guide. Try diluting the primer to 4:1 or 6:1 if you are applying primer by hand.

- C) Contamination picked up from processing.

Check relative humidity conditions, dust contamination, or cleaning residues etc.

Please check that each of these conditions has been resolved and try the above procedure again.

## **For more help, contact us**

Call 1-800-635-9333 or 1-302-834-2100, or E-mail [techsupport@arlon-std.com](mailto:techsupport@arlon-std.com).

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