

RTI HSC™ Tape Processing Guidelines

- Storage:** Store tape in sealed plastic bag. To retain plasticizer, store bag in an air tight container
Shelf life: lamination characteristics unchanged after 6 months.
- Punching:** Tape layers can be punched mechanically to form shapes, cavities or vias.
Tape layers can be laser machined to create vias or complex shapes.
- Lamination:** Increase pressure slowly to prevent air entrapment
RTI X4 binder laminates at lower temperatures and pressures than typical solvent based cast tapes.
Lamination time / temperature / pressure - minimum recommendation: 10 minutes / 65°C / 3500 psi.
- Dicing / Scribing:** Tapes, or laminated structures can be blade cut, sawn, or laser cut.
Tapes, or laminated structures can blade scribed and then post-fire snapped.
- Organic Burn Out:** Must be ramped slowly to 500°C to ensure complete organic volatilization.
Ramp rate depends on part size, kiln load, and air flow during burn-out.
Conservative test profile: 1°C/minute to 500°C, with 30 minute soak.

