PRODUCT DESCRIPTION
The DuPont™ AS series of thick film pastes is suitable for applications where thermal management is crucial to performance of the circuit. AS300 is a silver paste for screen printing of conductive interconnect layers on aluminum substrates and heat sinks for construction of high thermal conductivity interfaces for LED lighting and power components.

KEY FEATURES
- High solder adhesion
- Wire bondable with 50 μm Au wire
- Low temperature firing process <450°C
- High operating temperatures (>220°C)
- Patternable, additive process for lower material costs
- Compatible with dielectric paste (AS100) and thermal via fill (AS320) pastes

PROCESSING SUMMARY
Screen type
325 mesh stainless steel screen with 12 μm emulsion buildup

Drying
Allow prints to level for 10 minutes at room temperature for >10 minutes at 150°C.

Firing
7–9 minutes @ peak temperature of 450°C with a total time of 75–90 minutes in an air atmosphere

COMPATIBILITY
Whilst DuPont has tested this composition with the materials specified above and the recommended processing conditions, it is impossible or impractical to cover every combination of materials, customer processing conditions and circuit layouts. It is therefore essential that customers thoroughly evaluate the material in their specific situations in order to completely satisfy themselves with the overall quality and suitability of the composition for its intended application(s).

STORAGE AND SHELF LIFE
Containers may be stored in a clean, stable environment at room temperature (between 5°C – 30°C) with their lids tightly sealed.

Storage in high temperature (>30°C) or in freezers (temperature <0°C) is NOT recommended as this could cause irreversible changes in the material. The shelf life of compositions in factory-sealed (unopened) containers between (5°C – 30°C) is 3 months from date of shipment.

SUBSTRATES
Substrates of different compositions and from various manufacturers may result in variations in performance properties.

Table 1-Typical Physical Properties
<table>
<thead>
<tr>
<th>Test</th>
<th>Properties</th>
</tr>
</thead>
<tbody>
<tr>
<td>Viscosity (Pa.s) Brookfield UC&amp;S SC-14 @ 10 RPM, 25°C</td>
<td>85–115</td>
</tr>
<tr>
<td>Coverage, (cm²/g) At total fired thickness of 14 μm</td>
<td>55–65</td>
</tr>
<tr>
<td>Thinner</td>
<td>DuPont 4553</td>
</tr>
<tr>
<td>Shelf Life (months)</td>
<td>3</td>
</tr>
</tbody>
</table>

Table 2-Typical Fired Properties
<table>
<thead>
<tr>
<th>Test</th>
<th>Properties</th>
</tr>
</thead>
<tbody>
<tr>
<td>Fired Thickness¹</td>
<td>13-15 μm</td>
</tr>
<tr>
<td>Electrical Resistivity¹</td>
<td>&lt;1.3 m Ω /sq @25 μm thickness</td>
</tr>
<tr>
<td>Solder Adhesion²</td>
<td>&gt;15 N</td>
</tr>
<tr>
<td>Wire Bond Pull Strength³</td>
<td>&gt;25 g</td>
</tr>
</tbody>
</table>

Test Procedure
¹ Printed with 325 mesh stainless steel mesh/12 μm EOM, fired for 7–9 minutes @ peak temperature of 450°C with a total time of 75–90 minutes in an air atmosphere.
² AWG 20 tin plated copper wire, solder 95.5/3.8/0.7 (Sn/Ag/Cu), pad size 2x2 mm.
³ 50 μm Au wire. All wire breaks, no bond lifts.
**DUPONT AS300 SILVER CONDUCTOR**

**THINNER**

A300 composition is optimized for screen printing and thinning is not normally required. Use the DuPont recommended thinner for slight adjustments to viscosity or to replace evaporation losses. The use of too much thinner or the use of a non recommended thinner may affect the rheological behavior of the material and its printing characteristics. Please refer to Table 1.

**DRIYING**

Allow prints to level at room temperature, then dry in a well ventilated oven or conveyor dryer. Refer to ‘Processing Summary’.

**FIRING**

Fire in well ventilated belt, conveyor furnace or static furnace. Air flows and extraction rates should be optimized to ensure that oxidizing conditions exist within the muffle and that no exhaust gases enter the room. Full information on requirements for firing is contained in DuPont Technical Guide EUT 7.4 ‘Process Guide-Firing’. Refer to ‘Processing Summary’.

**GENERAL**

Performance will depend to a large degree on care exercised in screen printing. Scrupulous care should be taken to keep the composition, printing screens and other tools free of metal contamination. Dust, lint and other particulate materials may also contribute to poor yields.

**SAFETY AND HANDLING**

DuPont thick film compositions are intended for use in an industrial environment by trained personnel. All appropriate health/safety regulations regarding storage, handling and processing of such materials should be complied with. For information on health/safety regulations please refer to the specific product MSDS and to the DuPont Safety Guide EUT 7.1 ‘Practical Safe Handling of Thick Film Compositions’.

**PRINTING**

The composition should be thoroughly mixed before use. This is best achieved by slow, gentle hand stirring with a clean burr-free spatula (flexible plastic or stainless steel) for about 1-2 minutes. Care must be taken to avoid air entrapment. Printing should be performed in a well ventilated area. Additional information on requirements for printing areas is contained in DuPont Technical Guide EUT 7.3 ‘Processing-Screen Printing Rooms’ available on request.

Note: optimum printing characteristics are generally achieved in the room temperature range of 20°C–23°C. It is therefore important that the material, in its container, is at the temperature prior to commencement of printing. Class 10,000 printing area is recommended for building complex hybrids and multilayer circuits, otherwise severe yield losses could occur. Refer to ‘Processing Summary’.

---

**Recommended Firing Profile**

**Time/minutes**

<table>
<thead>
<tr>
<th>Temperature (°C)</th>
<th>0</th>
<th>10</th>
<th>20</th>
<th>30</th>
<th>40</th>
<th>50</th>
<th>60</th>
<th>70</th>
<th>80</th>
</tr>
</thead>
<tbody>
<tr>
<td>100</td>
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<td></td>
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<td></td>
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<tr>
<td>200</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>250</td>
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<td></td>
</tr>
</tbody>
</table>

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**TIME/minutes**

<table>
<thead>
<tr>
<th>Temperature (°C)</th>
<th>39 minutes &gt; 200°C</th>
<th>7 – 9 minutes &gt; 450°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>0</td>
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</tr>
<tr>
<td>10</td>
<td></td>
<td></td>
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<tr>
<td>20</td>
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<tr>
<td>80</td>
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</tbody>
</table>
DUPONT AS300 SILVER CONDUCTOR

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