**Product Description**

DuPont LF121 palladium/silver conductor composition is intended to be applied to ceramic substrates by screen printing and firing in a conveyor furnace in an air (oxidizing) atmosphere. It has been developed to form interconnecting tracks and pads for component and lead attachment, in hybrid microcircuits and networks.

**Product Benefits**

- Excellent fine line resolution
- Lead, cadmium, and nickel free*
- Excellent solderability with lead and lead-free solders.
- Excellent green-strength
- Compatible, sequentially or co-fired, with DuPont LF151 dielectric as a crossover

*Cadmium, lead and nickel “free” as used herein means that these are not intentionally added to the referenced product. Trace amounts however may be present.

**Processing Conditions**

**Printing**

200 - 325 mesh stainless steel, 0.3 - 0.5 mil emulsion. Print speeds up to 20 cm/s.

**Drying**

Allow prints to level for 5 - 10 minutes at room temperature, then dry for 10 - 15 minutes at 150°C.

**Firing**

850°C peak held for 10 minutes on 30 minutes cycle in air (oxidizing) atmosphere.

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**Composition Properties**

<table>
<thead>
<tr>
<th>Test</th>
<th>Properties</th>
</tr>
</thead>
<tbody>
<tr>
<td>Viscosity (Pa.s) [Brookfield HBT, UC&amp;SP @10 rpm, 25°C]</td>
<td>150 - 250</td>
</tr>
<tr>
<td>Thinner</td>
<td>DuPont 4553</td>
</tr>
<tr>
<td>Retest (months)</td>
<td>6</td>
</tr>
</tbody>
</table>

**Typical Composition Properties**

<table>
<thead>
<tr>
<th>Test</th>
<th>Properties</th>
</tr>
</thead>
<tbody>
<tr>
<td>Shrinkage (dried to fired) [%]</td>
<td>22 - 28</td>
</tr>
<tr>
<td>Mean fired thickness: (using 200</td>
<td>12 - 16, typical 14</td>
</tr>
<tr>
<td>Coverage @ 16µm fired (cm²/g)</td>
<td>67 - 72</td>
</tr>
<tr>
<td>Resistivity (mΩ/sq @ 16µm)</td>
<td>≤ 30</td>
</tr>
<tr>
<td>Soldered Adhesion¹</td>
<td></td>
</tr>
<tr>
<td>Initial (N)</td>
<td>≥ 18</td>
</tr>
<tr>
<td>Aged (48hrs @ 150°C)[N]</td>
<td>≥ 18</td>
</tr>
</tbody>
</table>

¹90° wire peel test on 2mm x 2mm pad soldered with 95.5Sn/3.8Ag/0.7Cu Solder using mildly activated flux, Alpha 611 on both Alumina.

This table shows anticipated typical physical properties for DuPont LF121 based on specific controlled experiments in our labs and are not intended to represent the product specifications, details of which are available upon request.
Figure 1 - 30 Minutes Profile

Processing
Substrates
Substrates of different compositions and from various manufacturers may result in variation in performance properties. DuPont LF121 is recommended for Al₂O₃ substrates only.

Thinner
This composition is optimized for screen printing, 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.

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

Storage and Shelf Life
Containers should be stored, tightly sealed, in a clean, stable environment at room temperature (<25°C). Shelf life of material in unopened containers is six months from date of shipment. Some settling of solids may occur and compositions should be thoroughly mixed prior to use.

Safety and Handling
For Safety and Handling information pertaining to this product, read the Material Safety Data Sheet (MSDS).

For more information on DuPont LF121 or other DuPont Microcircuit Materials products, please contact your local representative:

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