DuPont LF131
SILVER CONDUCTOR

Technical Data Sheet

Product Description
DuPont LF131 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 interconnection 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 SnPb, SnAg and SAC solders.
- Excellent green-strength
- Compatible, sequentially or co-fired, with DuPont LF151 dielectric as a crossover or inner layer conductor

*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.

Typical Composition Properties

<table>
<thead>
<tr>
<th>Test</th>
<th>Properties</th>
</tr>
</thead>
<tbody>
<tr>
<td>Viscosity (Pa.s)</td>
<td>83 - 145</td>
</tr>
<tr>
<td>Brookfield HBT, UC&amp;SP @10 rpm, 25°C]</td>
<td></td>
</tr>
<tr>
<td>Thinner</td>
<td>4553</td>
</tr>
</tbody>
</table>

Typical Fired Properties

<table>
<thead>
<tr>
<th>Test</th>
<th>Properties</th>
</tr>
</thead>
<tbody>
<tr>
<td>Shrinkage (dried to fired) [%]</td>
<td>56 - 62</td>
</tr>
<tr>
<td>Mean fired thickness:</td>
<td>13 - 19, typical 16µm</td>
</tr>
<tr>
<td>(using 200 mesh) [µm]</td>
<td></td>
</tr>
<tr>
<td>Coverage @ 16µm fired (cm²/g)</td>
<td>67 - 72</td>
</tr>
<tr>
<td>Resistivity (mΩ/sq @ 16µm)</td>
<td>&lt; 2.0</td>
</tr>
<tr>
<td>Soldered Adhesion¹ Initial (N)</td>
<td>&gt; 20</td>
</tr>
<tr>
<td>Aged (1000hrs@ 150ºC)[N]</td>
<td>≥ 18</td>
</tr>
</tbody>
</table>

¹ 90º 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. DuPont LF131 is recommended for use on dielectric only for crossover and inner layer applications.

This table shows anticipated typical physical properties for DuPont LF131 based on specific controlled experiments in our labs and are not intended to represent the product specifications, details of which are available upon request.
Typical 30-minutes fire profile

![Typical 850°C 30 Minute Firing Profile](image)

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).

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For more information on DuPont LF131 or other DuPont Microcircuit Materials products, please contact your local representative:

**Americas**
DuPont Microcircuit Materials
14 T.W. Alexander Drive
Research Triangle Park, NC 27709
Tel.: 800-284-3382

**Europe**
Du Pont (U.K.) Limited
Coldharbour Lane
Bristol BS16 1QD
U.K.
Tel.: 44-117-931-3191

**Asia**
DuPont Kabushiki Kaisha
Sanno Park Tower, 11-1
Nagata-cho 2-chome
Chiyoda-ku, Tokyo 100-611
Japan
Tel.: 81-3-5521-8650

DuPont Taiwan Ltd
45, Hsing-Pont Road,
Taoyuan, Taiwan 330
Tel.: 886-3-377-3616

DuPont China Holding Co. Ltd
Bldg 11, 399 Keyuan Rd., Zhangji Hi-Tech Park,
Pudong New District, Shanghai 201203, China
Tel.: 86-21-6386-6366 ext.2202

DuPont Korea Inc.
3~5th Floor, Asia tower #726,
Yeoksam-dong, Gangnam-gu
Seoul 135-719, Korea
Tel.: 82-10-6385-5399

E. I. DuPont India Private Limited
7th Floor, Tower C, DLF Cyber Greens,
Sector-25A, DLF City, Phase-III,
Gurgaon 122 002 Haryana, India
Tel.: 91-124-4091818

DuPont Company (Singapore) Pte Ltd
1 HarbourFront Place, #11-01
HarbourFront Tower One,
Singapore 098633
Tel.: 65-6586-3022

http://mcm.dupont.com

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