

DuPont LL617

Co-fired, solderable silver/palladium conductor

Technical Data Sheet

Product Description

DuPont LL617 is a co-fired, external solderable silver/palladium composition for the DuPont™ GreenTape™ 9K7 low temperature co-fired ceramic (LTCC) material system. The composition is cadmium and lead-free*. The composition is designed for use in co-fire only, solderable applications where subsequent high temperature, 850°C post firings are not required. Builds requiring additional 850°C refires should use 6277 silver/palladium or 7484 silver/palladium in post fired, solderable conductor configurations.

Product Benefits

When used with the GreenTape™ 9K7 LTCC system, DuPont LL617 will offer the following benefits:

- Co-fire processing
- Cadmium and lead free*

*Cadmium and lead “free” as used herein means that cadmium and lead are not an intentional ingredients in and are not intentionally added to the referenced product. Trace amounts however may be present.

Processing

For detailed recommendations on the use of DuPont LL617 and the GreenTape™ 9K7 system, consult this data sheet and the GreenTape™ LTCC Design Guide. For compatible co-fired and post fired conductor compositions, reference the GreenTape™ 9K7 Product Selector Guide.

Printing

The composition should be thoroughly stirred for 1 to 2 minutes prior to use. This is best achieved by slowly stirring the paste by hand using a clean, burr-free spatula (flexible plastic or stainless steel). Care must be taken to avoid air entrapment.

Print the paste material directly on preconditioned GreenTape™ 9K7 green sheets using appropriate thick film screen printing methods and a vacuum stone or other support structure which uniformly distributes a vacuum to secure the green sheet to the printer's stage plate.

Typical Properties

Property	Value
Viscosity, (Pa.s, 10 rpm, 25° C) ¹	180 - 300
Solids, (%) ²	73.5 - 75.5
Coverage, (cm ² /gram)	80 - 90
Clean-up solvent	1-Propoxy 2-Proponal
Thinner	8250
Line/space resolution, (um, dried)	250 / 250
Dry print thickness, (um)	22 - 25
Fired print thickness, (um)	12 - 14
Resistivity, (mOhms/sq) ³	<= 55
Solder acceptance, (%) ⁴	>= 95
Solder leach resistance, (# dips) ⁵	5 - 7
Soldered initial adhesion, (N) ⁶	>= 25
Soldered aged adhesion, (N) ⁷	>= 15

¹ Brookfield 2xHAT, SC4-14 / 6R spindle and utility cup
² 1050° C

³ Normalized to 15 um dry thickness

⁴ Co-fire-only, 62Sn/36Pb/2Ag solder, 220° C, 5 sec. dip

⁵ Co-fire-only, 62Sn/36Pb/2Ag solder, 230° C, 10 sec. dip

⁶ Initial, co-fire-only, 62Sn/36Pb/2Ag solder, 220° C

⁷ 48 hrs./150° C, co-fire-only, 62Sn/36Pb/2Ag solder, 220° C

The above table shows the anticipated typical physical and electrical properties for DuPont LL617 based on specific controlled experiments in our labs and are not intended to represent the product specifications, details of which are available upon request.

Printing is typically performed using a 325 mesh, stainless steel screen with a 10 to 12 micron emulsion thickness.

Printing should be performed in a clean, well ventilated area. Optimum printing characteristics are generally achieved when the room and paste container temperatures are in the 20 - 23°C range.

Drying

Allow conductor prints to level for 5 to 10 minutes at room temperature and then dry in a well ventilated oven or conveyor dryer for 5 minutes at 100°C. Do not over-dry.

Lamination

Collate and laminate multiple printed conductor green sheets according to the recommended processing parameters detailed in the DuPont™ GreenTape™ LTCC Design Guide.

Typical lamination parameters are 3000 psi at 70°C for 10 minutes. Lamination pressures may vary slightly based upon part design and the individual tape lot shrinkage factors.

Firing

Fire in a well ventilated conveyor 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.

GreenTape™ 9K7 requires the use of dedicated, specially coated setters in order to prevent parts from sticking during firing.

Consult the DuPont™ GreenTape™ 9K7 low temperature co-fired ceramic system data sheet and DuPont™ GreenTape™ LTCC Design Guide for additional details.

For further information regarding firing profiles, furnace recommendations and setter tile choices, please contact your local DuPont™ Technical Service Representative.

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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