



# DuPont PE815

## SILVER ALLOY CONDUCTOR - TECHNICAL DATA SHEET

### PRODUCT DESCRIPTION

DuPont PE815 Silver Alloy Conductor is used to fabricate Smart Cards & RFID Tags, laminated or hot roll calendered onto flexible substrates including polyester and PVC film. PE815 is a high conductivity silver-bearing conductor that possesses excellent abrasion resistance, adhesion, & print resolution. DuPont PE815 is fully compatible with DuPont 8144 (overcoat carbon) and DuPont 5018 UV dielectric.

### PRODUCT BENEFITS

- High Conductivity Silver Alloy Conductor
- Thermal Cure 120–140°C; 2–10 minutes
- < 25 mOhms/square/mil @ 15 µm
- Laminated/Calendered Smart Card/RFIDs

### PROCESSING

#### Screen Printing Equipment

- Automatic Reel-to-Reel
- Semi-Automatic Flat-Bed
- Rotary Screen/Cylinder Screen

#### Substrates

- Polyester Film (print-treated, non-print-treated)
- PVC (for Smart Card lamination only)
- Coated Papers & Nonwovens (calendered)

#### Screens

- 400–280 wire/inch Stainless Steel mesh
- 156–110 thread/cm Polyester mesh

#### Curing

Dry at 120–140°C oven for 2–10 minutes in a well-ventilated oven or conveyor dryer, where the exhaust meets environmental regulations. Drying efficiency, print quality/thickness help insure best electrical & physical performance.

**Table 1 - Typical Electrical & Physical Properties**

(Printed on Melinex ST505 Polyester Film)

| Test  | Properties  |
|---|---|
| Sheet Resistivity (mOhms/sq/25 µm) 140°C/10 min (15 µm Dried Print Thickness) | 140°C/10 min Calendered 80°C<br>140°C/10 min Laminated 80°C |
| Resistivity Δ% After Crease (ASTM F1683, 180°, 1 cycle, 2 kg)                 | w/5018 UV Encap<br>No Encap                                 |
| Abrasion Resistance (ASTM D3363 Pencil Hardness)                              | 2H  |
| Adhesion (Tape Cross Hatch) (ASTM D3359 w/3M Scotch Tape 600)                 | No Transfer (after calender)                                |
| Clean-up Solvent  | Ethylene Diacetate  |
| Overprint Carbon/Dielectric   | 8144/5018   |

**Table 2 - Typical Composition Properties**

(Printed on Melinex ST505 Polyester Film)

| Test  | Properties  |
|---|-------------|
| Solids (%) @ 150°C  | 86–89       |
| Viscosity (PaS) Brookfield RVT, #14 spindle, 10 rpm, 25°C | 30–60       |
| Density (g/cc)  | 4.0         |
| Coverage (cm <sup>2</sup> /g @ 15 µm)                     | 140         |
| Coverage (cm <sup>2</sup> /g @ 25 µm)                     | 80          |
| Dried Print Thickness (microns)                           | 15–25       |
| Thinner   | DuPont 8210 |

*This table shows anticipated typical physical properties for DuPont PE815 based on specific controlled experiments in our labs and are not intended to represent the product specifications, details of which are available upon request.*

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### LAMINATION/HOT ROLL CALENDERING

DuPont PE815 is designed for post-cure processing to maximize the high conductivity required for Smart Card and RFID read range performance. This is done using production level uniaxial lamination equipment, or continuous feed hot roll calender lamination method for RFID inlays.

### 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. Thinning is not recommended.

### SAFETY AND HANDLING

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

For more information on DuPont PE815 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

DuPont (UK) Limited  
Coldharbour Lane  
Bristol BS16 1QD  
United Kingdom  
Tel: 44.117.931.3191

#### Asia

DuPont Kabushiki Kaisha  
MCM Technical Lab  
DuPont Electronics Center  
KSP R&D B213  
2-1, Sakado 3-Chom,  
Takatsu-ku, Kawasaki-shi  
Kanagawa, 213-0012  
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 Harbour Front Place, #11-01  
Harbour Frong Tower One,  
Singapore 098633  
Tel: 65-6586-3022

<http://mcm.dupont.com>

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CAUTION: Do not use in medical applications involving permanent implantation in the human body. For other medical applications, see "DuPont Medical Caution Statement," H-50102-4.