10-074HF

Component Metallization

Description

10-074HF is a silver bearing conductor paste designed to screen print solderable electrodes onto a variety of electrical ceramic component devices. The fired film forms a highly adherent bond to many types of substrates, including piezoelectric transducers (PZTs), NTC thermistors, alumina, steatite and porcelain. The metalized electrode is solderable for external lead attachments.

Key Features

- Excellent adhesion
- Excellent solderability
- Compatible on piezoelectric transducers (PZTs), NTC thermistors, alumina, steatite and porcelain



Typical Properties	
Viscosity	35 – 50 kcps, Brookfield RVT, Spindle #7, @ 20 rpm, 25°C
Alloy Ratio	100
Resistivity	< 3.0 mΩ/□ at 25 µm fired film thickness
Solderability	Sn10/Pb88/Ag2 at 210 – 230 °C, 2 – 3 seconds dip 100%
Adhesion	Sn62/Pb36/Ag2 at 200 °C 100 x 100 mil pads Initial: > 6 lbs

Recommended Processing Guide	
Printing Parameters	100 – 250 mesh stainless steel screen 0.3 – 1.0 mil emulsion
Drying Temperature	100 - 150 ºC for 10 - 15 minutes
Process Temperature (TDS)	725 – 850ºC peak temperature Dwell time of 8 – 12 minutes at peak temperature Cycle time of 45 – 60 minutes Larger parts may require a longer firing profile
Film Thickness	5 – 9 µm
Recommended Thinner	Heraeus RV-252

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Warranty

Material guaranteed to meet specifications for 6 months from date of manufacturing with proper storage.

Storage

Store in a dry location at 15 - 25°C. DO NOT REFRIGERATE. Allow paste to come to room temperature prior to opening. Spatulate well before using, as settling may occur during storage.

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