

## Product Description

DM-CAP-4311S is a single part screen printable carbon paste for general electronic application use. The paste should be cured at low temperature (140°C) to achieve a sheet resistance of  $<20 \Omega/\square/\text{mil}$ .

## Product Benefits

- Good printability
- Low temperature curing
- Good screen residence time
- Compatibility with low temperature substrates such as PET

## Paste Preparation

The paste is a single part system. Gently stir before use. Avoid rapid stirring to prevent air entrapment during the stirring process. Once the paste has been removed from the container for printing, this may introduce contamination. Please do not replace the paste in the original container.

## Properties of Uncured Paste

Test	Properties
Viscosity (Lamy, cone-plate 50s <sup>-1</sup> , 25°C)	4,000-8,000 cP
Thinner	This should normally not be required. If necessary, use DM-CAP-4030-DT for slight adjustments in viscosity.
Coverage	350 cm <sup>2</sup> /g

## Paste Processing Conditions

Parameter	Typical Properties
Substrate	PET, Glass, FR4
Screen	PET, 5 µm emulsion, 100 mesh, 40 thread
Flood Speed	30 mm/s
Print Speed	45 mm/s
Squeegee hardness	90 Durometer Shore A
Squeegee pressure	3 kg
Squeegee angle	45°
Cured thickness	10 – 12 µm
Print gap	1 mm
Number of stroke	1

Guideline curing parameters are minimum 140°C for 30 – 60 in a well ventilated convection oven.

## Properties of Cured Paste

Test	Typical Properties
Thickness	10 – 12 $\mu\text{m}$
Sheet Resistance	<20 $\Omega/\square/\text{mil}$
Adhesion	5B
Pencil hardness scale	3H

## Clean-Up

Equipment can be cleaned using alcohols such as propanol.

## Storage and shelf-life

Containers should be stored at room temperature (10 – 20°C) with lids tightly sealed. The paste shelf-life for an unopened container is 3 months from date of shipment. The material should not be stored at temperature below 0°C or greater than 25°C. Dycotec Materials cannot assume responsibility for a paste that has not been stored in appropriate conditions or where the pastes have been contaminated following use.

## Safety and Handling

For safe use of this product, please review relevant material and safety datasheet (MSDS).

For more information, please contact:

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All information reported in the datasheet is for experimental work undertaken in our laboratories and illustrates typical values only. Processing conditions may vary depending on customers' experience and their application requirements and manufacturing process equipment set-up. More detailed information can be obtained via [info@dycotecmaterials.com](mailto:info@dycotecmaterials.com).

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