



Sicrys™ Silver Inks Handbook

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Table of Contents

1.	General Guidelines	3
1.1	Goal	3
1.2	Ag Sicrys™ Products	3
1.3	Ink Handling	4
1.4	Printing	5
1.5	Sintering	7
1.6	Adhesion	9
2.	Printing Guidelines	10
2.1	Printing conditions for Ag Sicrys™ inks	10
2.1.1	Sicrys™ Printing Conditions with DMC-11610 Print Head	10
2.1.2	Sicrys™ Printing Conditions with KM1024 SHB Print Head	11
2.1.3	Sicrys™ Printing Conditions with Ricoh E3 Gen3 Print Head	12
2.2	Printing recommendations for Sicrys™ ink	13
2.2.1	Printing recommendations for narrow line printing	13
2.2.2	Printing recommendations to avoid coffee stains	14
2.2.3	Printing recommendations for wide area printing	14
2.3	Printer Work Procedures	15
2.3.1	Printer Startup and Shutdown Procedure with Sicrys™ inks	15
2.3.1.1	Goals	15
2.3.1.2	Printer Startup	15
2.3.1.3	Printer Shutdown	15
2.3.1.4	Additional Recommendations	15
2.3.2	Printer Maintenance Procedure with Sicrys™ inks	16
2.3.2.1	Goals	16
2.3.2.2	Maintenance Procedure	16

1. General Guidelines

1.1 Goal

This handbook provides details on Sicrys™ Ag ink products, with guidance on handling, printing and sintering of the inks.

For additional information, see note at the end of the document.

1.2 Ag Sicrys™ Products

Sicrys™ Ag inks are solvent-based nanoparticle inks, suitable for inkjet printing and sintering by various possible methods (section 1.5). A comprehensive list of Sicrys™ products can be found at www.pvnanocell.com, including ink specification information, data sheets, and MSDS. The information can also be accessed by sending an email with the specific request to info@pvnanocell.com. The inks mentioned in this handbook include the following:

- Sicrys™ I50T-11
- Sicrys™ I50T-13
- Sicrys™ I30EG-1
- Sicrys™ I40DM-106
- Sicrys™ I50DM-106
- Sicrys™ I50TM-115
- Sicrys™ I50TM-119
- Sicrys™ I50TNG4.3-2
- Sicrys™ I57TG4-025
- Sicrys™ I55DMG4-045

1.3 Ink Handling

Safety and Handling

- Take proper care of inks as chemicals, read the Material Safety Data Sheet (MSDS) and product labels before using the products.
- Use appropriate equipment and safety measures.
- Keep product container closed when not in use to prevent solvent evaporation and spilling hazard.

Storage

- Keep ink in a cool, ventilated, dry place, at room temperature, without direct light. Keep bottle properly closed. Solvent evaporation will cause ink deterioration (high viscosity and agglomeration). Storage in freezers (or at below room temperature) is not recommended.
- Water or excess humidity in the ink will damage the ink (viscosity increase).

Shelf Life

- If stored correctly, the ink shelf life is 1 year.

General Spill Management and Response

Note: Detailed spill management to be found in specific MSDS

- Wear personal protective equipment: gloves, lab coat, goggles.
- Ventilate area of spill.
- Contain the spill by pre-installing trays or absorbent materials. Do not allow material to reach electrical connections.
- If material has spilled, clean first with a dry absorbent-type cloth and follow, if desired, with a wet cloth.

Ink Disposal

- Dispose according to instructions in MSDS. Do not dispose into sewage systems.

1.4 Printing

Sicrys™ inks have been designed by PVN to be compatible with a variety of commercially available inkjet print heads. However, the information shared in this handbook pertains to Konica Minolta KM1024, Ricoh Gen3 E3 and Dimatix cartridge print heads. The information hereby shared is provided “As Is”, based on PVN experience, and PVN does not warrant its accuracy, completeness or suitability.

General Printing Guidelines:

Use suitable inkjet printer and print head, compatible with conductive inks. Follow print head supplier guidance.

Note: Sicrys™ inks have high metal content; therefore high densities. Take this into consideration when adjusting printing parameters such as vacuum meniscus.

Before Printing

- Make sure all electrical connections in the printer are protected so that none of them is exposed to the conductive ink during the printing process. PVN inks are metallic and should not come into contact with electrical connections.
- Clean the ink supply line of the print head with appropriate recommended flushing fluid (or ink specific solvent) to remove contaminants and previous residual inks/solvents. Other solvents/inks may be incompatible with our inks.
- Mix bottle containing the ink (hand shake bottle) before filling the print head.
- Optional (usually not needed) – filter ink before use (with 300 series stainless steel filter media).

During Printing

- Work at a head temperature that correlates with print head supplier and PVN recommendations for ink viscosity.
- We recommend wiping the nozzle outlets during the print session with a moistened clean room cloth with the recommended flushing fluid. This will ensure no clogging of the nozzles occurs. A good practice is to define a wipe cycle for your system and application. Follow print head manufacturing guidance.

- Cloth used for wiping the print head must be fibreless and soft (used in clean rooms) so as not to damage the print head. Never use industrial paper towels, toilet paper or sponges.
- Capping, spitting or tickle modes are recommended if ink remains idle between print sessions.

After Printing

- The ink may be left in the print head between printing sessions if the system has capping capabilities to avoid drying on the orifice plate of the print head.
- If you would like to empty the print head, discharge the remaining ink from the print head. Clean the print head with appropriate flushing fluid, performing purges and wipes. Perform this step until the cloth wiping the print head comes out clean, with no remnants of the ink.
- Cloth used for wiping the print head must be fibreless and soft (used in clean rooms) so as not to damage the print head. Never use industrial paper towels, toilet paper or sponges.

Flushing Fluid

- Use appropriate flushing fluid, as follows:

Cat. #	Recommended Flushing Fluid
Sicrys™ I50T-11	Tripropylene glycol monomethyl ether (TPM) **
Sicrys™ I50T-13	Tripropylene glycol monomethyl ether (TPM) **
Sicrys™ I30EG-1	Ethylene Glycol
Sicrys™ I50DM-106	Diethylene glycol monomethyl ether (DGME)
Sicrys™ I50TM-115	FL119-01 *
Sicrys™ I50TM-119	FL119-01 *
Sicrys™ I50TNG4.3-2	Tripropylene glycol monomethyl ether (TPM) **
Sicrys™ I57TG4-025	Tripropylene glycol monomethyl ether (TPM) **
Sicrys™ I55DMG4-045	Diethylene glycol monomethyl ether (DGME)

* Contact sales@pvnanocell.com to order product.

** When using TPM solvent for flushing, use dry TPM.

1.5 Sintering

Sicrys™ Ag inks may be sintered by various methods:

1. **Thermal Sintering:** Recommended thermal sintering conditions are in a box oven in air, at the highest temperature which is compatible with the substrate material. Sintering may be performed at as low as 120°C, see specific ink datasheet. Resistivity values depend on the sintering temperature.
 - When using a convection oven with a thin substrate, affix the substrate so that it will not move in the air flow.
2. **Laser Sintering:** Laser sintering conditions should be fine-tuned to the type of laser used and specific application. Laser sintering may be carried out in ambient conditions (air). Sample resistivity values are 3-6xbulk (ink and process dependent). See table below, for examples of laser sintering process results (not optimized).

Laser wavelength: 532nm

Laser operation mode: Continuous

Laser spot size: 350µm

INK	Substrate	Laser Data				Line Dimensions		Resistivity	
		Scanning profile	Fluence [J/cm ²]	Power [mW]	Scan speed [mm/sec]	Width [µm]	Avg. Thickness [µm]	µΩcm	x Bulk (Ag)
I50DM-106	Glass	Raster , 0.1mm step	200	1000	5	510	1.5	5.2	3.3
		Raster , 0.1mm step	150	1000	6.7	927	1.8	6.4	4
		Along line	50	15000	100	300	1.2	6.4	4
	Kapton	Along line	8	5000	200	150	2	4.8	3
	PET	Along line	7	2000	100	150	2	6.4	4
I50TM-119	Glass	Raster , 0.1mm step	198	990	5	1633	5.4	8.6	5
		Raster , 0.1mm step	150	997	6.7	1594	5.9	10.1	6
		Raster , 0.1mm step	200	1000	5	2cm square	2.2	6.6	4.1
	Kapton	Along line	38	1300	10	75	5	7.7	4.8
		Along line	159	560	1	75	10	9.4	5.9

3. NIR Sintering: NIR lamp can be used for sintering. Achievable resistivity values: <4xbulk (ink and process dependent).

Following are examples of NIR sintering process results (not optimized):

INK	Substrate	NIR Data *			Line Dimensions		Resistivity	
		Fluence [J/cm ²]	Power [KW]	Exposure time [sec]	Width [μm]	Avg. Thickness [μm]	μΩcm	x Bulk (Ag)
I50DM-106	PET	41.5	21.6	0.4	507	3.4	3.7	2.3
	PEN	10.8	27	0.1	561	3.1	6.1	3.8
	Glass	1080	32.4	10	527	0.8	3.6	2.3
	ITO	648	32.4	6	500	6	4	2.5

* Adphos NIR lamp.

4. UV Flash Sintering: UV flash conditions should be fine-tuned to the type and power of lamp. Sintering may be carried out in air. Achievable resistivity values: ~6xbulk (ink and process dependent).
5. Photonic sintering: Photonic sintering should be fine-tuned to the type and power of lamp. Sintering may be carried out in air. With Xe lamp, achievable resistivity values: <10xbulk (ink and process dependent).
6. Pressure sintering: Combining heat and pressure can improve resistivity of printed silver ink. Achievable resistivity values: <3xbulk (ink and process dependent).

Following are examples of pressure sintering process results (not optimized):

INK	Substrate	Sintering Data			Line Dimensions		Resistivity	
		Temperature [°C]	Time [min]	Pressure [psi]	Width [μm]	Avg. Thickness [μm]	μΩcm	x Bulk (Ag)
I50DM-106	FR4	186	73	340	300	6	4.2	2.6
	Kapton	186	73	340	300	6	4.2	2.6

1.6 Adhesion

Sicrys™ products are compatible with a variety of substrates. For a comprehensive list of products and substrates to which they are compatible with, visit PV Nano Cell website at: <http://www.pvnanocell.com/product-shortlist.html>.

Note: when applying ASTM or ISO adhesion standards, make sure the test is relevant to your application (the cut done in the standards is usually not needed for conductive patterns).

1.7 Soldering

Printed and sintered Sicrys™ products may be soldered with the products outlined in this section. Please note that the soldering process must be fine-tuned to the application, including temperature suitable for the substrate, thickness, etc.

Solder Paste

Manufacturer: Koki Company Limited

Product #: SS4-M951DK

Composition: Sn₆₂Pb₃₆Ag₂ Flux RMA 13%

Additional information, including data sheet, may be found in the following link:

<https://www.datasheets.com/en/details/SS4M951DK-KOKI+Company-42677933>

Silver Conductive Epoxy Adhesive

Manufacturer: MG Chemical

Product #: M331-14G

Additional information, including data sheet, may be found in the following link:

<https://www.mouser.com/ProductDetail/MG-Chemicals/8331-14G?qs=sGAEpiMZZMvJqaFk9Bliv6jhjM0Pk6JzHea7mFx9BnQ%3D>

The silver conductive epoxy has been used by us to connect LEDs.

2. Printing Guidelines

2.1 Printing conditions for Ag Sicrys™ inks

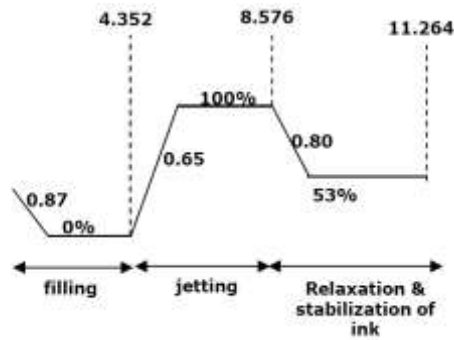
Sicrys™ inks have been designed by PVN to be compatible with a variety of commercially available print heads such as XAAR, Dimatix, Ricoh, and Konica Minolta (some print head models may not be compatible with conductive solvent inks, print head data sheet should be checked). However, the information shared in this handbook pertains specifically to Konica Minolta KM1024, Ricoh Gen3 E3 and Dimatix cartridge print heads. In sections 2.1.1, 0 and 2.1.3, we recommend starting printing conditions for the different inks in these print heads. The waveform printing conditions hereby shared are provided “As Is”, based on PVN experience, and PVN does not warrant its accuracy, completeness or suitability. The information is meant to be used as a starting point for the user. It is recommended that the user perform optimization of the printing process in order to accommodate its needs to the specific system and application of interest.

Further information and specifications of each print head are available in the print head manufacturer’s website. Please follow the guidelines and instructions of the printer system and print head provider.

2.1.1 Sicrys™ Printing Conditions with DMC-11610 Print Head

Cat. #	Head temp [°C]	frequency [kHz]	Waveform (V)
Sicrys™ I50T-11	35	10	19
Sicrys™ I50T-13	35	10	19
Sicrys™ I30EG-1	45	10	17
Sicrys™ I40DM-106	30	5	25
Sicrys™ I50DM-106	35	5	25
Sicrys™ I50TNG4.3-2	35	10	17

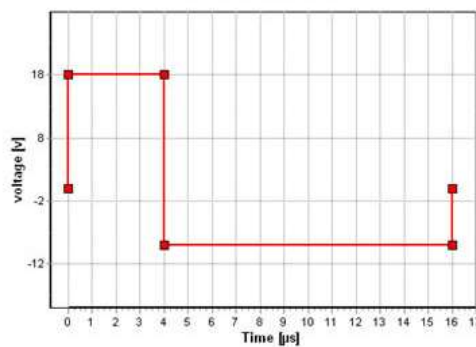
DMC-11610 Pulse Shape:



2.1.2 Sicrys™ Printing Conditions with KM1024 SHB Print Head

Cat. #	Head temp [°C]	frequency [kHz]	Waveform (V, μs)
Sicrys™ I50T-11	35	6	(14,4)(-8,11)
Sicrys™ I50T-13	35	6	(14,4)(-8,11)
Sicrys™ I30EG-1	40	6	(20,8)(-10,15)
Sicrys™ I50DM-106	35	6	(16,4)(-8,12)
Sicrys™ I50TM-115	35	6	(18,4)(-9,12)
Sicrys™ I50TM-119	40	6	(18,4)(-9,12)
Sicrys™ I50TNG4.3-2	35	6	(16,4)(-8,10)
Sicrys™ I57TG4-025	35	6	(16,4)(-8,48)
Sicrys™ I55DMG4-045	35	6	(15,4)(-7.5,12)

KM 1024 Pulse Shape:



2.1.3 Sicrys™ Printing Conditions with Ricoh E3 Gen3 Print Head

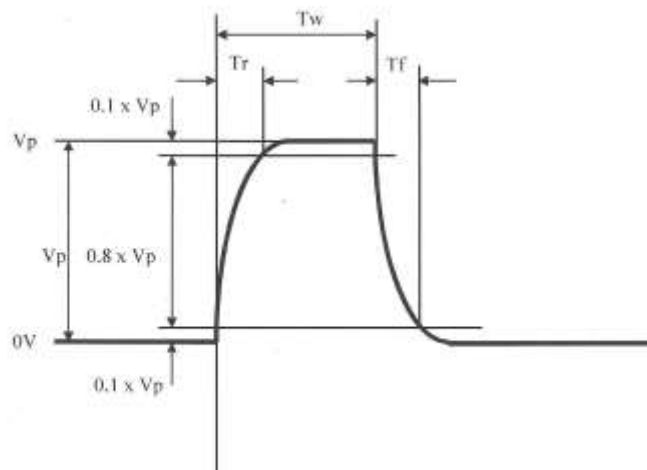
Fire sequence: 3 phase channel

Phase delay time: 35µs

Cat. #	Head temp [°C]	frequency [kHz]	Waveform * Vp (V), Tw (µs)
Sicrys™ I50T-11	35	6	(23,7.3)
Sicrys™ I50T-13	35	6	(20,7.2)
Sicrys™ I30EG-1	35	12	(17.9,7.5)
Sicrys™ I40DM-106	26	12	(16.2,9.8)
Sicrys™ I50DM-106	35	12	(16.2,8.5)
Sicrys™ I50TM-115	38	6	(22,7)
Sicrys™ I50TM-119	40	12	(17.2, 8.3)
Sicrys™ I50TNG4.3-2	35	6	(18, 9)
Sicrys™ I57TG4-025	38	6	(16,10)
Sicrys™ I55DMG4-045	35	6	(16.3,6.7)

* The system sets the rise time (Tr) and fall time (Tf) at 2.8µs (measured between 10 and 90% amplitude) and the slew rate.

Ricoh Gen3 E3 Pulse Shape:



2.2 Printing recommendations for Sicrys™ ink

2.2.1 Printing recommendations for narrow line printing

It is recommended to follow the steps outlined below in order to obtain narrow lines with Sicrys™ ink:

With printed dot shifting:

1. Print dots at low dpi, where dots do not touch.
2. Print additional shifted dots until reaching a continuous line. For best results, wait sufficient time between layers in order to ensure the previous layer has dried.
3. Repeat (1) and (2) until desired thickness is achieved.

Note: Printed pattern thickness determines the final dpi and number of times will repeat (1) and (2).

Without printed dot shifting:

1. Print a single layer at a wide range of resolutions and choose the resolution that provides the narrowest continuous line without bulging characteristics.
2. Print at the chosen dpi from (1) until reaching desired thickness. For best results, wait sufficient time between layers in order to ensure the previous layer has dried.

Additional recommendations:

1. It is recommended to print at a higher resolution in the cross-print direction than in the print direction.
2. Higher substrate temperatures may be used in order to produce narrower lines and decrease drying time.

An example for printing with I55DMG4.045 on silicon nitride coated wafer, showing the effect of stage temperature on the printed line width:

Stage Temperature (°C)	Line Width
60	~50µm
100	~40µm

2.2.2 Printing recommendations to avoid coffee stains

If coffee stain effect is observed in the printed pattern, it is recommended to lower the stage temperature in order to reduce the effect.

2.2.3 Printing recommendations for wide area printing, if no dot shifting is available

It is recommended to follow the steps outlined below in order to obtain wide area printing with Sicrys™ ink:

1. Print the first few layers (1-2) at 60% area coverage (60% of desired pattern):



2. Print the remaining layers at 100% area coverage (100% of desired pattern):



2.3 Printer Work Procedures

2.3.1 Printer Startup and Shutdown Procedure with Sicrys™ inks for printers without capping (ink cannot be kept in system overnight)

2.3.1.1 Goals

- Cleaning the print head at the end of each day and before the weekend.
- Maintaining the print head in good condition.
- Allowing easy start up at the beginning of each printing shift.
- Priming the print head.
- Changing between inks.

2.3.1.2 Printer Startup

1. At the beginning of a printing shift, purge all flushing fluid out of the system before introducing ink into the system.
2. Priming the print head:
 - Perform a long purge.
 - Wait 10 sec.
 - Perform a short purge.
 - Adjust the meniscus pressure (Sicrys™ inks are high density inks. Adjust the meniscus pressure accordingly).

2.3.1.3 Printer Shutdown

1. Empty the ink out of the system (according to ink system procedures).
2. Introduce flushing fluid into the system.
3. Purge the print head with alternating pulses of flushing fluid and air. Run each pulse for the duration of 5 sec.
4. Repeat step 3 three to four times or until clear fluid comes out the nozzles.
5. Cap the print head in a solvent-rich environment.

2.3.1.4 Additional Recommendations

- Clean the ink tank from ink before adding the flushing fluid.
- Wait 10 sec between washing cycles.
- Between ink changes in the printer, use shutdown procedure (without step 5) followed by the startup procedure.

2.3.2 For printers with capping (ink can be left in system overnight)

- At the beginning of the day perform long maintenance cycle.
- At the end of the day, perform regular maintenance cycle and perform capping to the print head.

2.3.3 Printer Maintenance Procedure with Sicrys™ inks

2.3.3.1 Goals

- Maintenance procedure to be implemented throughout the printing session.
- Maintaining the print head in good condition.
- Keeping all nozzles running between print runs.
- Opening clogged nozzles.
- Straightening crooked jetting.

2.3.3.2 Maintenance Procedure

1. If required due to missing nozzles or crooked jetting:
2. Perform a wet wipe:
 - 2.1. Use a lint free wipe, wet with the advised flushing fluid.
3. Perform a nozzle check: Print a test pattern using all nozzles in order to check the nozzle condition.
4. If not all nozzles are firing, repeat step 2.
5. If after two wipes nozzles are still missing, perform short purge and wipe.

For additional questions or comments please contact:

info@pvnanocell.com or sales@pvnanocell.com

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