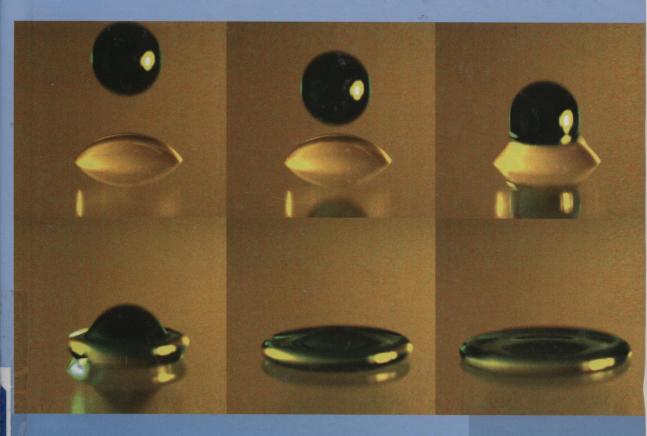
INKJET TECHNOLOGY FOR DIGITAL FABRICATION



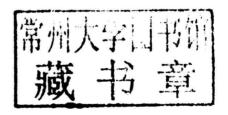
WILEY

Inkjet Technology for Digital Fabrication

Edited by

IAN M. HUTCHINGS and GRAHAM D. MARTIN

Inkjet Research Centre, Institute for Manufacturing, University of Cambridge, United Kingdom





This edition first published 2013 © 2013 John Wiley & Sons Ltd

Registered office: John Wiley & Sons Ltd, The Atrium, Southern Gate, Chichester, West Sussex, PO19 8SQ, United Kingdom

For details of our global editorial offices, for customer services and for information about how to apply for permission to reuse the copyright material in this book please see our website at www.wiley.com.

The right of the author to be identified as the author of this work has been asserted in accordance with the Copyright, Designs and Patents Act 1988.

All rights reserved. No part of this publication may be reproduced, stored in a retrieval system, or transmitted, in any form or by any means, electronic, mechanical, photocopying, recording or otherwise, except as permitted by the UK Copyright, Designs and Patents Act 1988, without the prior permission of the publisher.

Wiley also publishes its books in a variety of electronic formats. Some content that appears in print may not be available in electronic books.

Designations used by companies to distinguish their products are often claimed as trademarks. All brand names and product names used in this book are trade names, service marks, trademarks or registered trademarks of their respective owners. The publisher is not associated with any product or vendor mentioned in this book. This publication is designed to provide accurate and authoritative information in regard to the subject matter covered. It is sold on the understanding that the publisher is not engaged in rendering professional services. If professional advice or other expert assistance is required, the services of a competent professional should be sought.

The publisher and the author make no representations or warranties with respect to the accuracy or completeness of the contents of this work and specifically disclaim all warranties, including without limitation any implied warranties of fitness for a particular purpose. This work is sold with the understanding that the publisher is not engaged in rendering professional services. The advice and strategies contained herein may not be suitable for every situation. In view of ongoing research, equipment modifications, changes in governmental regulations, and the constant flow of information relating to the use of experimental reagents, equipment, and devices, the reader is urged to review and evaluate the information provided in the package insert or instructions for each chemical, piece of equipment, reagent, or device for, among other things, any changes in the instructions or indication of usage and for added warnings and precautions. The fact that an organization or Website is referred to in this work as a citation and/or a potential source of further information does not mean that the author or the publisher endorses the information the organization or Website may provide or recommendations it may make. Further, readers should be aware that Internet Websites listed in this work may have changed or disappeared between when this work was written and when it is read. No warranty may be created or extended by any promotional statements for this work. Neither the publisher nor the author shall be liable for any damages arising herefrom.

Library of Congress Cataloging-in-Publication Data

Inkjet technology for digital fabrication / edited by Ian M Hutchings, Graham D. Martin.

pages cm

Includes index.

ISBN 978-0-470-68198-5 (cloth)

- 1. Microfluidics. 2. Microfabrication. 3. Ink-jet printing. 4. Three-dimensional printing. 5. Coating processes.
- I. Hutchings, Ian M. II. Martin, Graham D. (Graham Dagnall) TJ853.4.M53I545 2013

(20.1106 1.22

620.1'06 - dc23

2012029022

A catalogue record for this book is available from the British Library.

Cloth ISBN: 978-0-470-68198-5

Typeset in 10/12pt Times-Roman by Laserwords Private Limited, Chennai, India Printed and bound in Singapore by Markono Print Media Pte Ltd

Inkjet Technology for Digital Fabrication

此为试读,需要完整PDF请访问: www.ertongbook.com

About the Editors

Ian M. Hutchings has been GKN Professor of Manufacturing Engineering at the University of Cambridge since 2001, working in the Institute for Manufacturing which is part of the Department of Engineering. Previously, he was Reader in Tribology at the Department of Materials Science and Metallurgy. His research interests are interdisciplinary, crossing the boundaries between engineering, materials science and applied physics. He established the Inkjet Research Centre at Cambridge in 2005 with support from the UK Engineering and Physical Sciences Research Council and several academic and industrial collaborators.

Graham D. Martin has been Director of the Inkjet Research Centre at the Institute for Manufacturing, University of Cambridge since 2005. He has a PhD in solid state physics and has worked in inkjet-related research, consultancy and product development for many years. The companies he has worked for include Cambridge Consultants Ltd (Non Impact Printing Systems group leader), Elmjet (Technical Director) and Videojet (Director of Technology).

List of Contributors

Khalid A. Alamry, Organic Materials Innovation Centre, School of Chemistry, University of Manchester, United Kingdom

Thomas Boland, Department of Biomedical Engineering, University of Texas at El Paso, USA

Paul Calvert, College of Engineering, University of Massachusetts Dartmouth, USA

Dolores Caras-Quintero, Organic Materials Innovation Centre, School of Chemistry, University of Manchester, United Kingdom

Julian Carter, Technology Consultant, United Kingdom

Neil Chilton, Printed Electronics Ltd., United Kingdom

Mark Crankshaw, R&D - Engineering, Xaar PLC, United Kingdom

Brian Derby, School of Materials, University of Manchester, United Kingdom

J. Frits Dijksman, Philips Research Europe, High Tech Campus 11, The Netherlands

Hanna M. Haverinen, Solar and Alternative Energy Engineering Research Center, King Abdullah University of Science and Technology (KAUST), Saudi Arabia

Ian M. Hutchings, Inkjet Research Centre, University of Cambridge, United Kingdom

Ghassan E. Jabbour, Department of Electrical Engineering, Department of Materials Science and Engineering, Solar and Alternative Energy Engineering Research Center, King Abdullah University of Science and Technology (KAUST), Saudi Arabia

Sungjune Jung, Department of Physics, University of Cambridge, United Kingdom

Marie-Beatrice Madec, Organic Materials Innovation Centre, School of Chemistry, University of Manchester, United Kingdom

Andromachi Malandraki, Organic Materials Innovation Centre, School of Chemistry, University of Manchester, United Kingdom

Graham D. Martin, Inkjet Research Centre, University of Cambridge, United Kingdom

Makoto Nakamura, Graduate School of Science and Engineering for Research, University of Toyama, Japan

Bill O'Neill, Department of Engineering, University of Cambridge, United Kingdom

Anke Pierik, University of Twente, Faculty of Science and Technology, Physics of Fluids, The Netherlands

Jake Reder, Celdara Medical, LLC, USA

Veronica Sanchez-Romaguera, Organic Materials Innovation Centre, School of Chemistry, University of Manchester, United Kingdom

Madhusudan Singh, Department of Materials Science and Engineering, University of Texas at Dallas, USA

Jonathan Stringer, Department of Mechanical Engineering, University of Sheffield, United Kingdom

Vivek Subramanian, Department of Electrical Engineering and Computer Sciences, University of California, USA

David B. Wallace, MicroFab Technologies, Inc., USA

Mike Willis, Pivotal Resources Ltd, United Kingdom

Desheng Xu, Organic Materials Innovation Centre, School of Chemistry, University of Manchester, United Kingdom

Stephen G. Yeates, Organic Materials Innovation Centre, School of Chemistry, University of Manchester, United Kingdom

Yuka Yoshioka, Heraeus Materials Technology, USA

Preface

From its initial use for product marking and date coding in the 1980s, and its development and widespread adoption for the desktop printing of text and images in the following two decades, inkjet technology is now having an increasing impact on commercial printing for many applications including labels, print-on-demand books and even newspapers. With great intrinsic flexibility and very short set-up times, inkjet printing is also challenging conventional methods for more specialised uses such as ceramic tile decoration and textile printing.

Exactly the same processes by which individual drops of liquid are produced and directed onto a substrate under digital control can be used to deposit materials other than the coloured 'inks' used for text and graphics. Metals, ceramics and polymers, with a wide range of functionality, can all be printed by inkjet methods, and exciting possibilities are also raised by the ability to print biological materials, including living cells. We are at the dawn of a digital age for printing, and it is the aim of this book to show how the changes which are happening in that world will lead to equally revolutionary changes in the ways in which we can manufacture products. Digital fabrication offers the possibilities of tailoring materials at a microscopic level, and positioning them exactly where they are required, with exactly the right properties. It has the potential to generate structures and functions which cannot be attained by other methods, and which are limited only by the creativity and ingenuity of the designer. It forms a new and powerful addition to the portfolio of methods available for manufacturing.

We are very grateful to the authors who have contributed to this volume, which we hope will help to define this rapidly moving field of research and provide a valuable resource for those who want to explore it further. It is impossible to forecast how it will develop, even over the next 10 years. What appears certain to us is that it will not stand still.

Ian M. Hutchings and Graham D. Martin Cambridge April 2012

Contents

		e Editors ontributors	xiii xv	
Pre	eface		xvii	
1.	Introduction to Inkjet Printing for Manufacturing Ian M. Hutchings and Graham D. Martin			
	1.1	Introduction	1	
	1.2	Materials and Their Deposition by Inkjet Printing	3	
		1.2.1 General Remarks	3	
		1.2.2 Deposition of Metals	3	
		1.2.3 Deposition of Ceramics	6	
		1.2.4 Deposition of Polymers	7	
	1.3	Applications to Manufacturing	8	
		1.3.1 Direct Deposition	9	
		1.3.2 Inkjet Mask Printing	12	
		1.3.3 Inkjet Etching	13	
		1.3.4 Inverse Inkjet Printing	14	
		1.3.5 Printing onto a Powder Bed	15	
	1.4	Potential and Limitations	15	
	Refe	rences	17	
2.	Func	lamentals of Inkjet Technology	21	
		nam D. Martin and Ian M. Hutchings		
	2.1	Introduction	21	
	2.2	Surface Tension and Viscosity	23	
	2.3	Dimensionless Groups in Inkjet Printing	25	
	2.4	Methods of Drop Generation	27	
		2.4.1 Continuous Inkjet (CIJ)	27	
		2.4.2 Drop-on-Demand (DOD)	28	
		2.4.3 Electrospray	33 34	
	2.5	2.5 Resolution and Print Quality		
	2.6	2.6 Grey-Scale Printing		
	2.7	.7 Reliability		
	2.8	Satellite Drops	38	

VI	Conter	rtc

	2.9	Print-Head and Substrate Motion	39		
	2.10	Inkjet Complexity	42		
	Refe	rences	42		
3.		amics of Piezoelectric Print-Heads its Dijksman and Anke Pierik	45		
	3.1	Introduction	45		
	3.2	Basic Designs of Piezo-Driven Print-Heads	47		
	3.3	Basic Dynamics of a Piezo-Driven Inkjet Print-Head			
		(Single-Degree-of-Freedom Analysis) Design Considerations for Droplet Emission from Piezo-Driven	49		
	3.4				
		Print-Heads	60		
		3.4.1 Droplet Formation	60		
		3.4.2 Damping	66		
		3.4.3 Refilling	67		
		3.4.4 Deceleration Due to Elongational Effects Prior to Pinching Off	70		
		3.4.5 Summary	71		
	3.5	Multi-Cavity Helmholtz Resonator Theory	71		
	3.6	Long Duct Theory	77		
	3.7	Concluding Remarks	83		
		ences	84		
4.	Fluid	s for Inkjet Printing	87		
		en G. Yeates, Desheng Xu, Marie-Beatrice Madec,	0,		
	Dolores Caras-Quintero, Khalid A. Alamry, Andromachi Malandraki				
		Veronica Sanchez-Romaguera			
	4.1	Introduction	87		
	4.2	Print-Head Considerations	88		
		4.2.1 Continuous Inkjet (CIJ)	88		
		4.2.2 Thermal Inkjet (TIJ)	88		
		4.2.3 Piezoelectric Drop-on-Demand (Piezo-DOD)	89		
	4.3	Physical Considerations in DOD Droplet Formation	89		
	4.4	Ink Design Considerations	95		
	4.5	Ink Classification	95		
		4.5.1 Aqueous Ink Technology	96		
		4.5.2 Non-aqueous Ink Technologies	100		
	4.6	Applications in Electronic Devices	105		
		4.6.1 Organic Conducting Polymers	105		
		4.6.2 Conjugated Organic Semiconductors4.6.3 Inorganic Particles	106		
	Refer		107 108		
	KUIUI	CHCCS	100		

			Contents	VII
5.	Who	n the Drop Hits the Substrate		113
٥.		han Stringer and Brian Derby		
				113
	5.1	Introduction		113
	5.2	Stable Droplet Deposition		114
		5.2.1 Deposition Maps		116
		5.2.2 Impact of Millimetre-Size Droplets		119
	<i>5</i> 2	5.2.3 Impact of Inkjet-Sized Droplets		120
	5.3	Unstable Droplet Deposition		122
	5.4	Capillarity-Driven Spreading		122
		5.4.1 Droplet–Substrate Equilibrium		124
		5.4.2 Capillarity-Driven Contact Line Motion		125
		5.4.3 Contact Angle Hysteresis		126
	5.5	Coalescence		126
		5.5.1 Stages of Coalescence5.5.2 Coalescence and Pattern Formation		128
				128
		5.5.3 Stable Bead Formation		130
		5.5.4 Unstable Bead Formation		131
	5.6	Phase Change		132
		5.6.1 Solidification		132
		5.6.2 Evaporation		134
	5.7	Summary		135
	Refe	rences		133
6.	Man	ufacturing of Micro-Electro-Mechanical Systems (MEMS)		141
		d B. Wallace		
	6.1	Introduction		141
	6.2	Limitations and Opportunities in MEMS Fabrication		142
	6.3	Benefits of Inkjet in MEMS Fabrication		143
	6.4	Chemical Sensors		144
	6.5	Optical MEMS Devices		147
	6.6	Bio-MEMS Devices		151
	6.7	Assembly and Packaging		152
	6.8	Conclusions		156
	0.0	Acknowledgements		156
	Refe	rences		156
	1.010			
7.		ductive Tracks and Passive Electronics		159
	Jake	Reder		
	7.1	Introduction		159
	7.2	Vision		159
	7.3	Drivers		160

7.3.1 Efficient Use of Raw Materials

160

		7.3.2	Short-Run and Single-Example Production	161
		7.3.3		162
	7.4	Incumbe	ent Technologies	162
	7.5	Conduc	tive Tracks and Contacts	162
		7.5.1	What Is Conductivity?	162
		7.5.2		163
		7.5.3	Contacts	163
	7.6	Raw Ma	aterials: Ink	164
		7.6.1	Particles	164
		7.6.2	Dispersants	168
		7.6.3	Carriers (Liquid Media)	170
		7.6.4	Other Additives	170
	7.7	Raw Ma	aterials: Conductive Polymers	172
	7.8		aterials: Substrates	172
	7.9	Printing	Processes	174
	7.10		position Processing	174
			Sintering	174
			Protective Layers	175
	7.11	Resistor	•	175
	7.12	Capacito	ors	176
	7.13	Other Pa	assive Electronic Devices	176
		7.13.1	Fuses, Circuit Breakers, and Switches	176
		7.13.2	Inductors and Transformers	177
		7.13.3	Batteries	177
		7.13.4	Passive Filters	177
		7.13.5	Electrostatic Discharge (ESD)	177
		7.13.6	Thermal Management	178
	7.14	Outlook		178
	Refei	rences		178
8.		ed Circui	it Board Fabrication	183
	8.1	Introduc	tion	102
	8.2	What Is		183
	8.3		a PCB Manufactured Conventionally?	183
	8.4	Imaging	•	185
	0.7		Imaging Using Phototools	185 187
			Laser Direct Imaging	188
	8.5		sign Formats	188
	8.6		pplications in PCB Manufacturing	189
	0.0		Introduction	189
			Legend Printing	190
			Soldermask	190
			Etch Resist	194
	8.7		ossibilities	202
	Refer			205
				203

9.	Activ	e Electronics	207		
	Madhusudan Singh, Hanna M. Haverinen, Yuka Yoshioka and Ghassan E. Jabbour				
	9.1	Introduction	207		
	9.2	Applications of Inkjet Printing to Active Devices	211		
		9.2.1 OLEDs	211		
		9.2.2 Other Displays	213		
		9.2.3 Energy Storage Using Batteries and Supercapacitors	214		
		9.2.4 Photovoltaics	215		
		9.2.5 Sensors	217		
		9.2.6 Transistors, Logic, and Memory	219		
		9.2.7 Contacts and Conductors	221		
		9.2.8 In Situ Synthesis and Patterning	223		
		9.2.9 Biological Applications	223		
	9.3	Future Outlook	224		
	Refere	ences	225		
10.	. Flat Panel Organic Light-Emitting Diode (OLED) Displays: A Case				
	Study		237		
	Julian	a Carter, Mark Crankshaw and Sungjune Jung			
	10.1	Introduction	237		
	10.2	Development of Inkjet Printing for OLED Displays	238		
	10.3	Inkjet Requirements for OLED Applications	241		
		10.3.1 Introduction	241		
		10.3.2 Display Geometry	241		
		10.3.3 Containment and Solid Content	241		
		Ink Formulation and Process Control	243		
	10.5	Print Defects and Control	246		
	10.6	Conclusions and Outlook	249		
		Acknowledgements	250		
	Refer	ences	250		
11.		ofrequency Identification (RFID) Manufacturing: A Case Study	255		
	Vivek	Subramanian			
	11.1	Introduction	255		
	11.2	Conventional RFID Technology	256		
		11.2.1 Introduction	256		
		11.2.2 RFID Standards and Classifications	256		
		11.2.3 RFID Using Silicon	258		
	11.3	Applications of Printing to RFID	260		
	11.4	Printed Antenna Structures for RFID	260		
		11.4.1 The Case for Printed Antennae	260		
		11.4.2 Printed RFID Antenna Technology	261		
		11.4.3 Summary of Status and Outlook for Printed Antennae	262		

x Contents

	11.5		RFID Tags	263	
		11.5.1	Introduction	263	
		11.5.2	Topology and Architecture of Printed RFID	264	
			Devices for Printed RFID	267	
	11.6	Conclus	sions	273	
	Refer	ences		273	
12.			and Cells and Thomas Boland	275	
	12.1	Introdu	ction	275	
	12.2		s for Biopolymers and Cells	277	
		12.2.1	Printer Types	277	
			Piezoelectric Print-Heads	277	
			Thermal Inkjet Print-Heads	279	
		12.2.4	Comparison of Thermal and Piezoelectric Inkjet for		
			Biopolymer Printing	279	
		12.2.5		280	
		12.2.6	Rapid Prototyping and Inkjet Printing	281	
	12.3		mulation	282	
			Introduction	282	
		12.3.2	Printed Resolution	283	
		12.3.3	Major Parameters: Viscosity and Surface Tension	283	
		12.3.4	Drying	285	
			Corrosion	285	
			Nanoparticle Inks	285	
		12.3.7	Biopolymer Inks	285	
	12.4	Printing		289	
		12.4.1		289	
			Cell-Containing Inks	289	
			Effects of Piezoelectric and Thermal Print-Heads on Cells	290	
		12.4.4	Cell Attachment and Growth	291	
			Biocompatibility in the Body	292	
	12.5	Reactiv		292	
	12.6	2.6 Substrates for Printing			
	12.7	Applica	-	297	
		12.7.1	Tissue Engineering	297	
		12.7.2	Bioreactors	298	
		12.7.3	Printed Tissues	298	
	12.8	Conclus	sions	299	
	Refer	ences		299	
13.			eering: A Case Study	307	
		to Nakan			
	13.1	Introduc		307	
		13.1.1	Tissue Engineering and Regenerative Medicine	307	
		13.1.2	The Third Dimension in Tissue Engineering and	200	
			Regenerative Medicine	308	