

Table of contents

Acknowledgement	I
Zusammenfassung	II
Summary	VIII
Table of contents	XIII
List of figures	XVI
List of tables	XXII
List of symbols	XXIII
1 Introduction	1
2 Assembly and reliability issues of LED packages	5
2.1 LED assembly	5
2.2 LED device	7
2.3 Process chain of LED assembly	9
2.4 Reliability issues	11
3 Thermo-mechanical properties of LED components	14
3.1 Thermal expansion	14
3.2 Linear elastic material response	15
3.3 Thermal properties	17
3.4 The encapsulant	18
3.4.1 Epoxy	18
3.4.2 Silicone	22
3.5 Summary of material properties	26
4 Non-linear elastic strain response	27
4.1 Viscoelasticity of epoxy	28
4.2 Hyperelasticity of silicone	34
4.3 Curing	36

5	Interaction with moisture	40
5.1	Moisture Diffusion	41
5.1.1	Moisture diffusion in pure epoxy	43
5.1.2	Moisture diffusion in glass fiber reinforced PPA	50
5.1.3	Moisture diffusion in pure silicone	54
5.2	Hygroscopic swelling	55
5.2.1	Hygroscopic swelling of epoxy	56
5.2.2	Hygroscopic swelling of PPA	59
5.2.3	Hygroscopic swelling of silicone	61
5.3	Moisture induced change in stress relaxation	62
6	Degradation of silicone bulk material and silicone/PPA interface	67
6.1	Temperature-induced bulk degradation	67
6.1.1	Weight loss during degradation	68
6.1.2	Degradation Shrinkage	71
6.1.3	Silicone hardening	73
6.1.4	Change of the coefficient of thermal expansion	75
6.1.5	Fracture stress	76
6.1.6	Implementation of degradation in FEM	77
6.2	Interface degradation	81
6.2.1	Brief introduction to fracture mechanics	81
6.2.2	Adhesion tests and sample preparation	83
6.2.3	Experimental setup to investigate the influence of light on adhesion	87
6.2.4	Silicone to PPA interface adhesion properties	89
6.2.5	Degradation kinetics	93
6.2.6	Implementation in FEM	95
7	Stress simulation and reliability prognosis of LED packages	101
7.1	Cracks in the silicone encapsulant	101
7.1.1	Assembly and typical failure – white high power LED	101

7.1.2	Thermal model	103
7.1.3	Simulation of the Solid State Lighting Test (SSLT)	108
7.1.4	Conclusion and Outlook	110
7.2	Adhesion failure in silicone casted package	112
7.2.1	Assembly and typical failure – white high power LED	112
7.2.2	Optical model – determination of irradiation dose	114
7.2.3	Simulation of delamination during steady state operation	114
7.2.4	Conclusion and Outlook	116
7.3	Glue failure in epoxy casted package	118
7.3.1	Assembly and failure – low power LED	118
7.3.2	Thermo-mechanical-diffusion model	120
7.3.3	Thermo-diffusion results	123
7.3.4	Structural analysis	126
7.3.5	Conclusion and outlook	129
8	References	132