Quality & Reliability Data

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Section 1 - Introduction

The major influence, within Knowles Capacitors, is to provide its Customers with 'World Class' capacitors.

Knowles (Syfer) has developed its own unique 'Wet Process' for the manufacture of Multilayer Ceramic Chip Capacitors. This has been in operation for some 30 years, significantly increasing the reliability levels obtained today, over those that were the expectation then.

The Knowles (Syfer) 'Wet Process' is based upon the principle of Screen Printing, both ceramic and electrode layers, in a single operation. This gives a more consistent deposition and greater accuracy of electrode alignment. In contrast to parts made by 'Tape Methods', it reduces stresses within the components.

At all manufacturing stages, well defined controls are in place. Statistical Process Control (SPC) techniques are used extensively to monitor and to reduce process variability.

Micro-sections are prepared from each batch of product built. Destructive Physical Analysis (DPA) is conducted on each micro-section to verify structural integrity and the absence of voids, delaminations or other defects.

After the fabrication cycle, 100% testing is conducted for:

(1) Capacitance
(2) Dissipation Factor
(3) Insulation Resistance
(4) Voltage Proof

The Knowles Quality Control Functions audit each process stage and the outgoing products, to ensure strict conformity to internal, customer, national and international specifications.

Knowles Suzhou holds IECQ-CECC, TUV, UL, and ISO9001 approvals.
In addition to its advanced construction methods, and sophisticated Quality Controls, Knowles carries out regular long term accelerated tests on its products to prove their reliability.

The Capacitor Industry accepts that no single test, in isolation, is an effective measure of total reliability and, therefore, accelerated testing, directed at selected capacitor performance factors, is conducted, by Knowles, on a regular basis. This includes:

1. 125°C Endurance Testing at 1.5 times rated voltage
2. 85°C / 85% Relative Humidity Testing at stress voltages of 1.5, 5 and 50 Vdc

Knowles maintains its rigorous test regime, to give its customers useful and detailed data on the reliability of its products. There is a continuing trend toward higher value capacitors in all major dielectric categories as circuit designers have demanded even greater volumetric capacity. This has prompted an increase in the number of 'high' value lots tested; now approximately 20% of such parts are tested compared with 10% for standard product. The results presented here reflect this change in product mix.

Each section of this document describes the methodology of test and includes a summary of the results obtained. Failure In Time (F.I.T.) data is shown, based upon endurance test results.

The aim of this document is to confirm that Knowles continues to maintain its reputation for the manufacture of products that meet, and exceed, customer's expectations of reliability.

The Knowles Quality and Technical personnel are available to discuss this information, on request.
Section 2 - Test Conditions

**Endurance**

- **Duration**: 1000 Hours
- **Intermediate Check Time**: 168 Hours
- **Voltage**: Up to 1.5 x Rated Voltage
- **Current Limitation**: Each component stressed via a 100kΩ resistor
- **Temperature**
  - C0G: 125°C
  - X7R: 125°C
- **Post Test Limits**
  - **Insulation Resistance**
    - C0G: ≥ 4000MΩ or 40s (Whichever is the less)
    - X7R: ≥ 2000MΩ or 50s (Whichever is the less)

**85°C / 85%RH**

- **Duration**: 168 Hours
- **Voltage Bias**: Rated voltage up to a maximum of 50 volts dc, however, when specified, 1.5Vdc or 5Vdc may be required
- **Current Limitation**: Each component stressed via a 100kΩ resistor
- **Temperature**: 85°C
- **Relative Humidity**: 85%
- **Post Test Limits**
  - **Insulation Resistance**
    - C0G: ≥ 4000MΩ or 40s (Whichever is the less)
    - X7R: ≥ 2000MΩ or 50s (Whichever is the less)
Section 3 - F.I.T. Rate Data

Acceleration Factor Calculations

\[
\text{Acceleration Factor (AF)} = AF_{\text{voltage}} \times AF_{\text{temperature}}
\]

where

\[
\text{Acceleration Factor}_{\text{voltage}} = \left[ \frac{V_{\text{stress}}}{V_{\text{use}}} \right]^{2.7}
\]

and

\[
\text{Acceleration Factor}_{\text{temperature}} = e^{\left( \frac{E_a}{k} \left( \frac{1}{T_{\text{use}}} - \frac{1}{T_{\text{stress}}} \right) \right)}
\]

where

- \( E_a \) = Activation energy (1.0 eV for M.L.C's)
- \( k \) = Boltzmann' Constant (8.617 \times 10^{-5} \text{eV/K})
- \( T \) = Temperature in K (273 + Temperature in °C)

Failure Rates at the Specified Confidence Level (60%) are derived from:

\[
FR = \frac{X^2}{2} \times \frac{1}{AF \times H}
\]

where

- \( FR \) = Estimated Failure Rate at Use Stress
- \( X^2 \) = Chi Square calculated for number of rejects at test stress
- \( H \) = Component test hours

Conversion Factors

<table>
<thead>
<tr>
<th>From</th>
<th>To</th>
<th>Operation</th>
</tr>
</thead>
<tbody>
<tr>
<td>FITS</td>
<td>MTBF (Hours)</td>
<td>( 10^9 \div \text{FITS} )</td>
</tr>
<tr>
<td>FITS</td>
<td>MTBF (Years)</td>
<td>( 10^9 \div (\text{FITS} \times 8760) )</td>
</tr>
</tbody>
</table>
**C0G Capacitor Reliability Data**

Product type: C0G capacitors with dielectric code C and G  
Time period analyzed: 1st January 2016 to 31st December 2016  
Test laboratory: Knowles Reliability Test Department  
Number tested: 16,435  
Test conditions: 1000 hours with 1.5x rated voltage applied at 125°C  
Results: 9 failures in 15,935,800 component test hours

**FIT (Failure In Time) Rate Graph**

The FIT (Failure In Time) rate graph provides an indication of component reliability in relation to a customer’s application with respect to temperature and voltage being applied. For example, at 25°C and 50%RV (Rated Voltage), the FIT rate graph indicates 0.002 FITs. As a comparison, an automotive customer specifies maximum of 0.1 FITs at 25°C and 50%RV (Rated Voltage).
**X7R Capacitor Reliability Data**

**Product type:** X7R capacitors with dielectric code X and J  
**Time period analyzed:** 1st January 2016 to 31st December 2016  
**Test laboratory:** Knowles Reliability Test Department  
**Number tested:** 46,710  
**Test conditions:** 1000 hours with 1.5x rated voltage applied at 125°C  
**Results:** 0 failures in 44,380,400 component test hours

**FIT (Failure In Time) Rate Graph**

The FIT (Failure In Time) rate graph provides an indication of component reliability in relation to a customer’s application with respect to temperature and voltage being applied. For example, at 25°C and 50%RV (Rated Voltage), the FIT rate graph indicates 0.000 FITs. As a comparison, an automotive customer specifies maximum of 0.1 FITs at 25°C and 50%RV (Rated Voltage).