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(54) **Title:** LIGHT EMITTING DIODE (LED) DEVICES, COMPONENTS AND METHODS

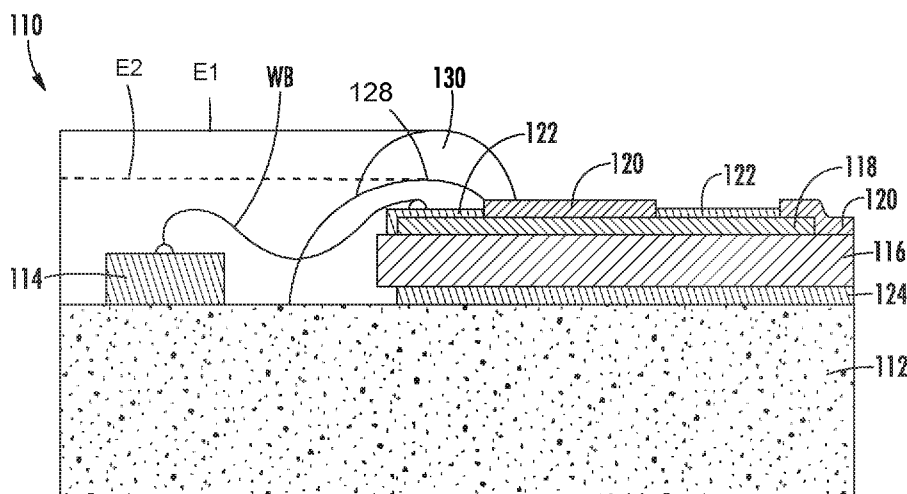


FIG. 1

(57) **Abstract:** Devices, components and methods containing one or more light emitter devices, such as light emitting diodes (LEDs) or LED chips, are disclosed. In one aspect, a light emitter device component can include a metallic substrate with a mirrored surface, one or more light emitter devices mounted directly or indirectly on the mirrored surface, and one or more electrical components mounted on the top surface and electrically coupled to the one or more light emitter devices, wherein the one or more electrical components can be spaced from the mirrored metal substrate by one or more non-metallic layers. Components disclosed herein can result in improved thermal management and light output.



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DESCRIPTION  
LIGHT EMITTING DIODE (LED) DEVICES, COMPONENTS AND  
METHODS

5                   CROSS REFERENCE TO RELATED APPLICATION

This application claims the benefit of U.S. Patent Application Serial No. 15/359,517 filed November 22, 2016, the disclosure of which is incorporated herein by reference in its entirety.

10                   TECHNICAL FIELD

The subject matter disclosed herein relates generally to components, modules, and methods for light emitting diode (LED) lighting. More particularly, the subject matter disclosed herein relates to multi-layered LED devices, components and methods with improved performance and  
15    manufacturability.

BACKGROUND

Optoelectronic devices utilizing light emitters or light emitter devices, such as light emitting diodes (LEDs) or LED components, have various  
20    applications in consumer electronics. One or more high brightness LED chips, for example, can be packaged within surface mount device (SMD) housings or in top-mount configurations for use as light sources in space-limited applications where thermal management and size can be important. Some high brightness LED chips can be housed in plastic, leaded chip  
25    carriers (PLCCs) or in or on ceramic, metal and/or mirrored substrates. The LED chips and/or LED housings can be improved for efficiency, brightness, durability and/or manufacturability. Typical end-products for LED chips packaged within SMD housings include for example, but are not limited to, LED light bulbs, commercial/residential directional lighting, general  
30    indoor/outdoor illumination, commercial displays, indoor cabinet displays, flashes for cameras, retail and window displays, emergency lighting and

signs, household appliances, and television and automotive instrument panels.

An area of improvement of LED components includes increasing thermal conductivity and capacity for increased power inputs while  
5 maintaining optimal performance. Moreover, improved durability of the LED packages is desired. Packages for high power or high wattage applications can incorporate various design features for increasing the lumens per watt (LPW) or lumens per dollar (LP\$). Design features for increasing thermal conductivity and high power capacity, as well as durability, can include, for  
10 example, a substrate comprising metal and a mirror, and/or a plurality of dielectric layers, prepregs, solder masks, and combinations thereof. Other areas of improvement for LED components include incorporation of design features which improve, for example, thermal properties and/or minimizing overall size, or footprint, to efficiently utilize space when mounted to an  
15 external source.

Accordingly, there remains a need for improved light emitter device components, modules, and methods that overcome or alleviate shortcomings of prior light emitter device components, modules and methods. Specifically, for example, there exists a need for improved thermal  
20 capacity LEDs, LED components and methods that are more durable and can be produced at reduced cost, higher manufacturability, and higher yield than existing devices.

## SUMMARY

25 In accordance with this disclosure, light emitting diode (LED) devices, components, and methods are provided. It is, therefore, an object of the present disclosure to provide light emitter device components, modules and methods improving thermal conductivity, power handling capabilities and durability.

30 These and other objects as can become apparent from the disclosure herein are achieved, at least in whole or in part, by the subject matter described herein.

### BRIEF DESCRIPTION OF THE DRAWINGS

A full and enabling disclosure of the present subject matter is set forth more particularly in the remainder of the specification, including reference to  
5 the accompanying figures, relating to one or more embodiments, in which:

Figure 1 is a cross-sectional side view illustrating a light emitter device component according to embodiments of the present subject matter;

Figures 2A, 2B and 2C are top plan views of light emitter device components illustrating further embodiments of the present subject matter;

10 Figure 3 is a cross-sectional side view illustrating a light emitter device component according to embodiments of the present subject matter;

Figures 4A, 4B and 4C are top plan views of light emitter device components illustrating further embodiments of the present subject matter;

15 Figure 5 is a cross-sectional side view illustrating a light emitter device component according to embodiments of the present subject matter;

Figures 6A, 6B and 6C are top plan views of light emitter device components illustrating further embodiments of the present subject matter; and

20 Figures 7A, 7B, 7C and 7D are tabular and graphical illustrations of the thermal properties of light emitter device components according to the present subject matter.

### DETAILED DESCRIPTION

Reference will now be made in detail to possible aspects or  
25 embodiments of the subject matter herein, one or more examples of which are shown in the figures. Each example is provided to explain the subject matter and not as a limitation. In fact, features illustrated or described as part of one embodiment can be used in another embodiment to yield still a further embodiment. It is intended that the subject matter disclosed and envisioned  
30 herein covers such modifications and variations.

In some aspects, solid state lighting apparatuses, LED devices and/or systems, and methods for producing the same, described herein can

comprise various solid state light emitter electrical configurations, color combinations, and/or circuitry components for providing solid state lighting apparatuses having improved efficiency, improved emission profiles, enhanced output and/or optimized color production. Apparatuses and  
5 methods such as those disclosed herein advantageously cost less, are more efficient, vivid, uniform, and/or brighter than some other solutions.

Unless otherwise defined, terms used herein should be construed to have the same meaning as commonly understood by one of ordinary skill in the art to which this subject matter belongs. It will be further understood that  
10 terms used herein should be interpreted as having a meaning that is consistent with the respective meaning in the context of this specification and the relevant art, and should not be interpreted in an idealized or overly formal sense unless expressly so defined herein.

Aspects of the subject matter are described herein with reference to  
15 sectional, perspective, elevation, and/or plan view illustrations that are schematic illustrations of idealized aspects of the subject matter. Variations from the shapes of the illustrations as a result, for example, of manufacturing techniques and/or tolerances, are to be expected, such that aspects of the subject matter should not be construed as limited to particular shapes  
20 illustrated herein. This subject matter can be embodied in different forms and should not be construed as limited to the specific aspects or embodiments set forth herein. In the drawings, the size and relative sizes of layers and regions can be exaggerated for clarity.

As illustrated in the various figures, some sizes of structures or  
25 portions are exaggerated relative to other structures or portions for illustrative purposes and, thus, are provided to illustrate the general structures of the present subject matter. Furthermore, various aspects of the present subject matter are described with reference to a structure or a portion being formed on other structures, portions, or both. As will be  
30 appreciated by those of skill in the art, references to a structure being formed "on" or "above" another structure or portion contemplates that additional structure, portion, or both may intervene. References to a structure or a

portion being formed "on" another structure or portion without an intervening structure or portion are described herein as being formed "directly on" the structure or portion. Similarly, it will be understood that when an element is referred to as being "connected", "attached", or "coupled" to another element, it can be directly connected, attached, or coupled to the other element, or intervening elements may be present. In contrast, when an element is referred to as being "directly connected", "directly attached", or "directly coupled" to another element, no intervening elements are present.

Furthermore, relative terms such as "on", "above", "upper", "top", "lower", or "bottom" are used herein to describe one structure's or portion's relationship to another structure or portion as illustrated in the figures. It will be understood that relative terms such as "on", "above", "upper", "top", "lower" or "bottom" are intended to encompass different orientations of the device in addition to the orientation depicted in the figures. For example, if the device in the figures is turned over, structure or portion described as "above" other structures or portions would now be oriented "below" the other structures or portions. Likewise, if devices in the figures are rotated along an axis, structure or portion described as "above", other structures or portions would now be oriented "next to" or "left of" the other structures or portions. Like numbers refer to like elements throughout.

Unless the absence of one or more elements is specifically recited, the terms "comprising", "including", and "having" as used herein should be interpreted as open-ended terms that do not preclude the presence of one or more elements.

The terms "electrically activated emitter(s)" and "emitter(s)" as used herein are synonymous terms and refer to any device capable of producing visible or near visible (e.g., from infrared to ultraviolet) wavelength radiation, including for example but not limited to, xenon lamps, mercury lamps, sodium lamps, incandescent lamps, and solid state emitters, including LEDs or LED chips, organic light emitting diodes (OLEDs), and lasers.

The terms "solid state light emitter(s)", "solid state emitter(s)", and "light emitter(s)" are synonymous terms and refer to an LED chip, a laser

diode, an organic LED chip, and/or any other semiconductor device preferably arranged as a semiconductor chip that comprises one or more semiconductor layers, which can comprise silicon, silicon carbide, gallium nitride and/or other semiconductor materials, a substrate which can  
5 comprise sapphire, silicon, silicon carbide and/or other microelectronic substrates, and one or more contact layers which can comprise metal and/or other conductive materials.

The terms "groups", "segments", "strings", and "sets" as used herein are synonymous terms. As used herein, these terms generally describe how  
10 multiple LEDs are electrically connected, such as in series, in parallel, in mixed series/parallel, in common anode, or in common anode configurations among mutually exclusive groups/segments/sets. The segments of LEDs can be configured in a number of different ways and may have circuits of varying functionality associated therewith (e.g. driver circuits, rectifying  
15 circuits, current limiting circuits, shunts, bypass circuits, etc.), as discussed, for example, in commonly assigned and co-pending U.S. Patent Application Serial No. 12/566,195, filed on September 24, 2009, U.S. Patent Application Serial No. 13/769,273, filed on February 15, 2013, U.S. Patent Application Serial No. 13/769,277 filed on February 15, 2013, U.S. Patent Application  
20 Serial No. 13/235,103, filed on September 16, 2011, U.S. Patent Application Serial No. 13/235,127, filed on September 16, 2011, and U.S. Patent No. 8,729,589, which issued on May 20, 2014, the disclosure of each of which is hereby incorporated by reference herein in the entirety.

The term "targeted" refers to configurations of LED chip segments  
25 that are configured to provide a pre-defined lighting characteristic that is a specified parameter for the lighting apparatus. For example, the targeted spectral power distribution can describe the characteristic of the light that is generated at a particular power, current, or voltage level.

Apparatuses, systems, and methods as disclosed herein can utilize  
30 red chips, green chips, and blue chips. In some aspects, chips for use in blue-shifted yellow light (BSY) devices can target different bins as set forth in Table 1 of commonly owned, assigned, and co-pending U.S. Patent

Application Serial No. 12/257,804, published as U.S. Pat. Pub. No. 2009/0160363, the disclosure of which is incorporated by reference herein in the entirety. Apparatuses, systems, and methods herein can utilize, for example, ultraviolet (UV) chips, cyan chips, blue chips, green chips, red  
5 chips, amber chips, and/or infrared chips.

The term "substrate" as used herein in connection with lighting apparatuses refers to a mounting member or element on which, in which, or over which, multiple solid state light emitters (e.g., LEDs) can be arranged, supported, and/or mounted. A substrate can be, e.g., a component  
10 substrate, a chip substrate (e.g., an LED substrate), or a sub-panel substrate. Exemplary substrates useful with lighting apparatuses as described herein can for example comprise printed circuit boards (PCBs) and/or related components (e.g., including but not limited to metal core printed circuit boards (MCPCBs), flexible circuit boards, dielectric laminates,  
15 ceramic based substrates, and the like), ceramic boards having FR4 and/or electrical traces arranged on one or multiple surfaces thereof, high reflectivity ceramics (e.g., alumina) support panels, and/or mounting elements of various materials and conformations arranged to receive, support, and/or conduct electrical power to solid state emitters. Electrical  
20 traces described herein provide electrical power to the emitters for electrically activating and illuminating the emitters. Electrical traces may be visible and/or covered via a reflective covering, such as a solder mask material, Ag, or other suitable reflector.

In some embodiments one substrate can be used to support multiple  
25 groups of solid state light emitters in addition to at least some other circuits and/or circuit elements, such as a power or current driving components and/or current switching components. In other aspects, two or more substrates (e.g., at least a primary substrate and one or more secondary substrate or substrates) can be used to support multiple groups of solid state  
30 light emitters in addition to at least some other circuits and/or circuit elements, such as a power or current driving components and/or temperature compensation components. The first and second (e.g., primary

and secondary) substrates can be disposed above and/or below each other and along different planes, adjacent (e.g., side-by-side) to each other, have one or more co-planar surfaces disposed adjacent each other, arranged vertically, arranged horizontally, and/or arranged in any other orientation with  
5 respect to each other.

Solid state lighting apparatuses according to aspects of the subject matter herein can comprise III-V nitride (e.g., gallium nitride) based LEDs or laser chips fabricated on a silicon, silicon carbide, sapphire, or III-V nitride growth substrate, including (for example) LEDs manufactured and sold by  
10 Cree, Inc. of Durham, N.C. Such LEDs and/or lasers can be configured to operate such that light emission occurs through the substrate in a so-called "flip chip" orientation. Such LED and/or laser chips can also be devoid of growth substrates (e.g., following growth substrate removal). In some cases, LEDs can comprise red – III-V chips, but not nitride such as InGaAlP,  
15 GaAsP, and the like.

LEDs useable with lighting apparatuses as disclosed herein can comprise horizontal structures (with both electrical contacts on a same side of the LED chip) and/or vertical structures (with electrical contacts on opposite sides of the LED chip). A horizontally structured chip (with or  
20 without the growth substrate), for example, can be flip chip bonded (e.g., using solder) to a carrier substrate or printed circuit board (PCB), or wire bonded. A vertically structured chip (without or without the growth substrate) can have a first terminal solder bonded to a carrier substrate, mounting pad, or printed circuit board (PCB), and have a second terminal wire bonded to  
25 the carrier substrate, electrical element, or PCB.

Electrically activated light emitters, such as solid state emitters, can be used individually or in groups to emit light to stimulate emissions of one or more lumiphoric materials (e.g., phosphors, scintillators, lumiphoric inks, quantum dots), and generate light at one or more peak wavelengths, or of at  
30 least one desired perceived color (including combinations of colors that can be perceived as white). Inclusion of lumiphoric (also called 'luminescent') materials in lighting apparatuses as described herein can be accomplished

by an application of a direct coating of the material on lumiphor support elements or lumiphor support surfaces (e.g., by powder coating, inkjet printing, or the like), adding such materials to lenses, and/or by embedding or dispersing such materials within lumiphor support elements or surfaces.

5 Methods for fabricating LEDs having a planarized coating of phosphor integrated therewith are discussed by way of example in U.S. Patent Application Publication No. 2008/0179611, filed on September 7, 2007, to Chitnis et al., the disclosure of which is hereby incorporated by reference herein in the entirety.

10 Other materials, such as light scattering elements (e.g., particles) and/or index matching materials can be associated with a lumiphoric material-containing element or surface. Apparatuses and methods as disclosed herein can comprise LEDs of different colors, one or more of which can be white emitting (e.g., including at least one LED with one or more  
15 lumiphoric materials).

In some aspects, one or more short wavelength solid state emitters (e.g., blue and/or cyan LEDs) can be used to stimulate emissions from a mixture of lumiphoric materials, or discrete layers of lumiphoric material, including red, yellow, and green lumiphoric materials. LEDs of different  
20 wavelengths can be present in the same group of solid state emitters, or can be provided in different groups of solid state emitters. A wide variety of wavelength conversion materials (e.g., luminescent materials, also known as lumiphors or lumiphoric media, e.g., as disclosed in U.S. Pat. No. 6,600,175, issued on July 29, 2003, and U.S. Patent Application Publication No.  
25 2009/0184616, filed on October 9, 2008, each disclosure of which is hereby incorporated by reference herein in the entirety), are well-known and available to persons of skill in the art.

In some aspects, lighting apparatuses and systems as described herein comprise multiple sets of solid state light emitters targeting different  
30 colors (e.g., one set targeting a first color and at least a second set targeting a second color that is different than the first color). In some aspects, each set of the multiple sets comprises at least two solid state light emitters of a

same color (e.g., the peak wavelengths coincide). In some aspects, each set of the multiple sets of solid state emitters is adapted to emit one or more different color(s) of light. In some aspects, each set of the multiple sets of solid state emitters is adapted to emit one or more color(s) of light that differ  
5 relative to one another (e.g., with each set of solid state emitters emitting at least one peak wavelength that is not emitted by another set of solid state emitters). Aspects of targeting and selectively activating sets of solid state emitters according to the present subject matter may be provided using the circuitry and/or techniques described in commonly assigned and co-pending  
10 U.S. Patent Application Serial No. 14/221,839, the disclosure of which was previously incorporated hereinabove by reference.

The term “color” in reference to a solid state emitter refers to the color and/or wavelength of light that is emitted by the chip upon passage of electrical current therethrough.

15 Some embodiments of the present subject matter may use solid state emitters, emitter packages, fixtures, luminescent materials/elements, power supply elements, control elements, and/or methods such as described in U.S. Patent Nos. 7,564,180; 7,456,499; 7,213,940; 7,095,056; 6,958,497; 6,853,010; 6,791,119; 6,600,175, 6,201,262; 6,187,606; 6,120,600;  
20 5,912,477; 5,739,554; 5,631,190; 5,604,135; 5,523,589; 5,416,342; 5,393,993; 5,359,345; 5,338,944; 5,210,051; 5,027,168; 5,027,168; 4,966,862, and/or 4,918,497, and U.S. Patent Application Publication Nos. 2009/0184616; 2009/0080185; 2009/0050908; 2009/0050907; 2008/0308825; 2008/0198112; 2008/0179611, 2008/0173884,  
25 2008/0121921; 2008/0012036; 2007/0253209; 2007/0223219; 2007/0170447; 2007/0158668; 2007/0139923, and/or 2006/0221272; U.S. Patent Application Serial No. 11/556,440, filed on December 4, 2006; with the disclosures of the foregoing patents, published patent applications, and patent application serial numbers being hereby incorporated by reference as  
30 if set forth fully herein.

The terms “lighting apparatus” and “module” as used herein are synonymous, and are not limited, except that it is capable of emitting light.

That is, a lighting apparatus can be a device or apparatus that illuminates an area or volume, e.g., a structure, a swimming pool or spa, a room, a warehouse, an indicator, a road, a parking lot, a vehicle, signage (e.g., road signs, a billboard), a ship, a toy, a mirror, a vessel, an electronic device, a  
5 boat, an aircraft, a stadium, a computer, a remote audio device, a remote video device, a cell phone, a tree, a window, an LCD display, a cave, a tunnel, a yard, a lamppost, or a device or array of devices that illuminate an enclosure, or a device that is used for edge or back-lighting (e.g., backlight poster, signage, LCD displays), light bulbs, bulb replacements (e.g., for  
10 replacing AC incandescent lights, low voltage lights, fluorescent lights, etc.), outdoor lighting, security lighting, exterior residential lighting (wall mounts, post/column mounts), ceiling fixtures/wall sconces, under cabinet lighting, lamps (floor and/or table and/or desk), landscape lighting, track lighting, task lighting, specialty lighting, rope lights, ceiling fan lighting, archival/art display  
15 lighting, high vibration/impact lighting-work lights, etc., mirrors/vanity lighting, spotlighting, high-bay lighting, low-bay lighting, or any other light emitting device.

The presently disclosed subject matter is directed to different embodiments of LED package structures having a light source that  
20 comprises LEDs. The LED packages can be arranged in different ways and are relatively small, while at the same time are efficient, reliable and cost effective. The embodiments according to the disclosure herein can have different shaped encapsulants, but can emit with improved or similar efficiency compared to similar LED packages with fully hemispheric  
25 encapsulants. In some embodiments where a plurality of LEDs are mounted on a substrate, the spacing between each LED chip can be controlled to optimize the intensity of light output from the LED package. The LED packages according to the disclosure herein can also be smaller and less expensive to manufacture.

30 In some embodiments, the LED packages can have encapsulants with planar surfaces that result in a certain amount of light experiencing total internal reflection (TIR) within the encapsulant. Using planar surfaces can

provide increased flexibility in the different shapes that can be used beyond conventional hemispheric lenses that are typically arranged to minimize TIR light, and the use of planar surfaces can allow for more compact LED packages. Some embodiments can comprise one or more LEDs on a submount with contacts and traces for applying an electrical signal to the one or more LEDs. The LED and the surface around the LED can be blanketed by a layer of phosphor material. In some embodiments the encapsulant can comprise a transparent material that is in a cubic or generally cubic shape over the LED and the submount. The conversion material layer can be of the type that converts light from the LED to another color or wavelength of light, and the conversion layer can be of a thickness and concentration such that less than all of the LED light is converted on its first pass through the conversion material.

Different LED packages according to the disclosure herein can have different shaped encapsulants to produce the desired emission profile and emission efficiency. Some embodiments can comprise encapsulants where not all of the surfaces are planar, with some comprising a hybrid combination of planar and curved surfaces. Some of these embodiments can comprise one or more LEDs mounted on a submount, with the encapsulant having an upper curved surface and planar side surfaces. The upper surface can have a radius of curvature that is greater than half the length or width of the submount, with the planar surfaces comprising truncated sections of the encapsulant so that the encapsulant does not overhang the edge of the submount. This can result in planar surfaces with a curved edge as described below. LED packages with planar encapsulants and planar/curved encapsulants are fully described in U.S. patent application Ser. No. 13/957,290, entitled "LED Package with Encapsulant Having Curved and Planar Surfaces," which is incorporated herein by reference in the entirety.

The disclosure herein can in some embodiments be directed to a number of different features and arrangements that can improve or tailor the emission characteristics of LED packages according to the disclosure

herein. These can include, but are not limited to, improved phosphor layer compositions and coverage, the use of particular silicones in different layers, the grouping of LEDs, a truncated (or cubic) encapsulant, spacing between a plurality of LEDs, the arrangement of phosphor layers, and/or  
5 improved coverage of reflective layers. In some embodiments, the use of some or all of these features can result in LED packages emitting light at improved lumen density.

The disclosure herein is described herein with reference to certain embodiments, but it is understood that the disclosure herein can be  
10 embodied in many different forms and should not be construed as limited to the embodiments set forth herein. In particular, the disclosure herein is described below in regards to certain LED packages having LEDs in different configurations, but it is understood that the disclosure herein can be used for many other LED packages with other LED configurations. The  
15 LED packages can also have many different shapes beyond those described below, such as rectangular, and the solder pads and attach pads can be arranged in many different ways. In other embodiments, the emission intensity of the different types of LEDs can be controlled to vary the overall LED package emission.

20 The embodiments described herein are with reference to an LED or LEDs, but in accordance with the disclosure herein and in some aspects LEDs as used herein can include LED chips or any other suitable structure or structures. For example, LEDs as used herein can be individual junctions of a monolithic LED. For example, instead of being completely separate  
25 LED chips, the LEDs can each be a LED region all on a common substrate that can have different types of monolithic junctions. A mesa between the LEDs and on the common substrate can extend to certain layers or can extend all the way to or from the common substrate. Therefore, a monolithic LED can comprise more than one LED junctions on a common substrate,  
30 and the gaps between the LEDs can be formed by the mesas that can at least partially separate the LEDs.

The components described herein can have different shapes and sizes beyond those shown, and one or different numbers of LEDs can be included. It is also understood that the embodiments described below utilize co-planar light sources, but it is understood that non co-planar light sources  
5 can also be used. It is also understood that an LED light source may be comprised of multiple LEDs that may have different emission wavelengths. As mentioned above, in some embodiments at least some of the LEDs can comprise blue emitting LEDs covered with a yellow phosphor along with red emitting LEDs, resulting in a white light emission from the LED package. In  
10 multiple LED packages, the LEDs can be serially interconnected or can be interconnected in different serial and parallel combinations.

Embodiments of the present disclosure are described herein with reference to cross-sectional view illustrations that are schematic illustrations of embodiments of the disclosure. As such, the actual thickness of the  
15 layers can be different, and variations from the shapes of the illustrations as a result, for example, of manufacturing techniques and/or tolerances are expected. Embodiments of the disclosure should not be construed as limited to the particular shapes of the regions illustrated herein but are to include deviations in shapes that result, for example, from manufacturing. A region  
20 illustrated or described as square or rectangular will typically have rounded or curved features due to normal manufacturing tolerances. Thus, the regions illustrated in the figures are schematic in nature and their shapes are not intended to illustrate the precise shape of a region of a device and are not intended to limit the scope of the disclosure herein.

25 The disclosure herein provides improvements over previously disclosed LED packages, devices and/or components. One of the advantages of LED packages according to the disclosure herein is that they are configured be more robust against improper handling. For example, and as discussed in more detail hereinbelow, the different LED package  
30 embodiments of the disclosure herein can comprise a plurality of printed circuit board (PCB) layers configured to surround LED chips and associated wired bonds, which in some embodiments can provide an additional degree

of strength to the LED package and/or provide a protective feature for the LED chips, wire bonds, etc. Moreover, in some aspects retention material, or dams, can be coupled with the one or more PCBs, as well as in some embodiments encapsulants, to protect the LEDs and/or wire bonds from  
5 improper handling.

The disclosure herein also provides for a number of improvements, including but not limited to improved light reflectivity, thermal conductivity, and/or efficiency. In some aspects LED packages and/or components provided herein can be configured to be capable of handling higher power  
10 inputs while still maintaining thermal conductivity. In some aspects LED packages and/or components provided herein can be configured to produce an improved, increased and/or optimized lumen output per input (i.e. high lumen per dollar (LP\$)).

Provided in some embodiments are light emitter device components  
15 comprising a metallic substrate having a top surface, a mirrored surface on at least a portion of the top surface of the metallic substrate, one or more light emitter devices mounted on the top surface of the metallic substrate or the mirrored surface, and one or more electrical components mounted on the top surface of the metallic substrate and electrically coupled to the one  
20 or more light emitter devices, wherein the one or more electrical components are spaced from the metallic substrate by a plurality of non-metallic layers. The non-metallic layers can comprise one or more dielectric layers, such as for example a polyimide-based polymer. Moreover, the dielectric layers can comprise a printed circuit board (PCB), including FR-4,  
25 CEM-3, CEM-4, or related composite materials.

In some aspects, and as discussed further herein, at least two PCBs are layered one on top of the other. Such a configuration can in some aspects further comprise a prepreg layer between the two PCB layers. The non-metallic layers, e.g. two or more PCBs, can increase the thermal  
30 conductivity of the light emitter device component as compared to a device with a non-metallic substrate without a plurality of non-metallic layers.

In some aspects the non-metallic layers are mounted to the metallic substrate and adjacent to the one or more light emitter devices. The height of the non-metallic layers can be configured to be greater than the height of the one or more light emitter devices, and can in some embodiments be  
5 configured to further comprise a retention material in contact with the non-metallic layers, wherein the retention material forms a dam surrounding the one or more light emitter devices. The height of the retention material can at least be as high as the non-metallic layers, and higher than the one or more light emitter devices. Moreover, the retention material can be configured to  
10 cover a wire bond electrically coupling the one or more light emitters devices to the one or more electrical components.

Methods of making the disclosed LED devices are also provided herein. For example, a method of forming a light emitter device component having improved thermal properties is provided, including mounting one or  
15 more light emitter devices on a top surface of a substrate, the substrate comprising a metallic base with mirrored upper surface, depositing a plurality of non-metallic layers on the top surface of the substrate and surrounding the one or more light emitter devices, and mounting one or more electrical components to at least one of the non-metallic layers,  
20 wherein the one or more electrical components are spaced from the substrate body by the non-metallic layers. The non-metallic layers can comprise dielectric layers, wherein the dielectric layers can comprise a PCB. In some aspects at least two PCBs can be layered one on top of another. In some aspects a prepreg layer can be applied between the two  
25 PCB layers. In some embodiments a solder mask can be applied on an upper surface of the non-metallic layers. In some aspects, the light emitter devices can be electrically coupled to the one or more electrical components by applying a wire bond.

In some embodiments the non-metallic layers can be positioned to  
30 form a stepped configuration with a recessed ledge between a first and second non-metallic layer, wherein at least one electrical component and wire bond can be positioned at the recessed ledge to provide a more

protected location. In some aspects the height of the non-metallic layers can be configured to be greater than the height of the one or more light emitter devices.

5 In some aspects, a method can further comprise applying a retention material in contact with one or more of the non-metallic layers, wherein the retention material can form a dam surrounding the one or more light emitter devices. In some embodiments the height of the retention material can be at least as high as the non-metallic layers, and higher than the one or more light emitter devices.

10 Embodiments of the present subject matter will be described with reference to Figures 1-7. Referring now to Figures 1-6, a light emitter device component can comprise light emitter device components or LED components that can be mounted over a substrate, and can in some aspects include one or more PCBs, with in some aspects metal layers or  
15 metal plating near the die attach surface. The substrate can in some aspects be metallic or non-metallic (e.g., ceramic). Generally, it is desirable for the substrate to be highly reflective to visible light (e.g., greater than about 90%) and provide conduction of heat and mechanical support. For example, ceramic materials, including those containing alumina, are among  
20 the materials that contain these desirable qualities. In other embodiments, and as described further herein, metallic materials can be used as the substrate.

Figure 1 illustrates a cross-sectional view of a light emitter package or LED component, generally designated **110**. LED component **110** as shown  
25 for example in Figure 1 can comprise a ceramic substrate or body **112** that can be of any suitable shape and configuration. In some embodiments the use of ceramic-based LED components, including substrate **112**, can provide improved reflection and thus improved efficiency. Ceramic materials can further be desirable for use in LED components because of thermal  
30 management properties. For example, Alumina materials ( $Al_2O_3$ ) have relatively low thermal resistance, low moisture sensitivity, superior reliability at high temperature environments, and the superior ability to dissipate heat.

Thus, in some aspects ceramic can be highly reflective but have relatively low thermal conductivity, and can therefore be best suited for high efficiency, or high lumens per watt (LPW), applications.

In one aspect, ceramic substrate **112** can comprise a ceramic body  
5 cast using low temperature co-fired ceramic (LTCC) materials and processes. Specifically, for example, ceramic substrate **112** can comprise a substrate cast from a thin green ceramic tape. The ceramic tape can comprise any ceramic filler material known in the art, for example, glass ceramics such as aluminum oxide ( $\text{Al}_2\text{O}_3$ ) or aluminum nitride (AlN) having  
10 0.3 to 0.5 weight percent of glass frits. The glass frits can be used as a binder and/or sintering inhibitor within the ceramic tape when the tape is fired. A green tape can be formed by casting a thick layer of a slurry dispersion of the glass frit, ceramic filler, one or more additional binders, and a volatile solvent. The cast layer can be heated at low temperatures to  
15 remove the volatile solvent. A green ceramic tape used for ceramic body **112** can advantageously comprise any thickness desired, thus contributing to a thinner size when desired. In another aspect, HTCC can be used. Ceramic body **112** can further comprise a ceramic material having any of a variety of scattering particle contained therein. Examples of suitable scattering  
20 particles can for example comprise particles of  $\text{Al}_2\text{O}_3$ ,  $\text{TiO}_2$ ,  $\text{BaSO}_4$ , and/or AlN. In one aspect,  $\text{Al}_2\text{O}_3$  particles can be selected based on cost considerations, along with its mechanical, optical, electrical, and thermal properties. In still another aspect, the substrate can be a comparatively simple structure without intervening layers such as those produced by thin-  
25 or thick-film processes (e.g., bare substrates produced CoorsTek and several others). Such substrates can be fired along with other materials (e.g., Zirconia) to improve optical and mechanical properties.

Referring to Figure 1, ceramic substrate **112** can for example be formed without any cavity or recess so that one or more LED chips **114** are  
30 disposed on and can mount to ceramic substrate **112**. As one example, substrate **112** can comprise a surface, such as an upper surface, that can but does not have to be disposed along a single plane. The one or more

LED chip(s), such as LED chip **114**, can be mounted directly to the surface of body **112** with only a thin adhesive layer (e.g., silicone or epoxy) between substrate **112** and LED chip **114** (i.e., without any intervening layer, such as a metal or other layer, as shown for example in Figure 1).

5 LED chip **114** can be electrically connected, such as by wirebonds **WB** or any other suitable technique, to one or more electrical components. Wirebond **WB** can comprise an electrically conductive wire or conduit material. As used herein, electrical components can, for example and without limitation, comprise electrical traces, leads, electrical pads, metal  
10 plating, contact or bond pads, or any other suitable electrical component. For example, metal plating **122** can comprise a copper foil having wire-bondable gold or silver portions provided thereon. In some instances two or more metal plates **122** can be provided and can serve as a cathode and the other as an anode for supplying LED chips **114** with current to illuminate an active  
15 layer within the LED chip. Such LED chips **114** can in some aspects be referred to as top-side contact chips or dies. Alternatively, LED chip **114** may be a flip-chip bonded to one or more electrical components, such as for example metal plating **122**. Any other suitable bonding techniques could be used as well.

20 Regardless of the specific connection, metal plating **122** can in some embodiments be separated from ceramic substrate **112** by one or more additional layers or components. For instance, as shown in Figure 1, an adhesive layer **124** can be applied to an upper surface of substrate **112**, upon which a printed circuit board (PCB) base layer **116** can be positioned,  
25 upon which a PCB metal layer **118** can be positioned. Moreover, in some aspects a solder mask **120** can be positioned or layered on an upper surface, including on PCB metal layer **118**, on PCB base layer **116**, or both.

Adhesive layer **124** can be configured to adhere PCB **116** to substrate **112**. Adhesive layer **124** can comprise, for example, an organic-based  
30 adhesive, a pressure-sensitive adhesive (PSA), and/or an epoxy or silicone adhesive.

By connecting LED chip **114** and electrical components/metal plating **122** to substrate **112** using one or more intervening layers, e.g., adhesive layer **124**, PCB base layer **116** and/or PCB metal layer **118**, the manufacturability of LED component **110** can in some embodiments be greatly improved. Specifically, for example, prior art methods can in some aspects require resource-intensive processes in which a seed layer is deposited on the substrate by physical vapor deposition or the like, and copper is plated on the seed layer to produce electrical traces on the substrate. Other metals are typically plated on the copper to make them wire-bondable. Such methods can require a number of additional processing steps with respect to substrate **112**, and these additional processing steps can leave contaminants on the ceramic surface, which can be difficult to remove and can negatively impact the performance (e.g., brightness) and reliability of the device. In contrast, using one or more intervening layers can in some aspects allow metal plating **122** to be adhered to substrate **112** in a comparatively simpler process. In such a configuration, the trace pattern can be formed separate from substrate **112** and applied using a lamination technique, such as for example a heat press and/or an overpressure chamber (i.e., autoclave) lamination technique with an adhesive film known to those having skill in the art in the multi-layer printed circuit board industry.

Printed circuit boards **116/118** can comprise a flexible printed circuit board ("flectape" PCB), such as PCB base **116**, comprising a polymer-like film, that can have at least one conductive layer, such as PCB metal **118**, within one or more layers of a flexible plastic resin (e.g., polyimide, Kapton from DuPont,). In some aspects adhesive layer **124** can comprise a tape-like adhesive provided on the flectape for easy connection of PCB **116/118** to substrate **112**. It should be recognized, however, that PCB **116/118** can comprise any material used in multilayer PCBs or flex PCBs, including prepreg materials, reinforced laminates (e.g., glass-reinforced epoxy, materials using carbon fiber), and non-reinforced materials.

As further illustrated in Figure 1, additional components can be integrated into LED component **110** to improve the performance and

manufacturability thereof. For example, LED component **110** can further comprise an electrically insulating solder mask **120** in one or more locations, particularly on an upper surface of component **110**. Solder mask **120** can be disposed on PCB **116/118**, and in some embodiments at least partially on  
5 and/or adjacent to metal plating **122**, such that when solder is used to attach one or more wires to an electrical solder pad (not shown), the solder will be contained within the predefined area. Choosing a white solder mask can improve the overall reflectivity of LED component **110**.

LED component **110** can further comprise a retention material such  
10 as retention material **128** or **130** disposed at least partially about an emission area in which LED chip **114** is positioned, where retention material **128/130** can be referred to as a dam. Retention material **128/130** can for example be dispensed. After application or placement of retention material **128/130**, such as for example by dispensing of retention material **128/130**, an  
15 encapsulant **E** can be disposed within the recess formed thereby. An encapsulant such as encapsulant **E1** or **E2** can contain one or more phosphors such that light emitted from the one or more LED chips **114** can produce an emission of a desired wavelength. Encapsulant **E1** or **E2** can be selectively filled to any suitable level within the space disposed between one  
20 or more inner walls of retention material **128/130**. For example, encapsulant **E1/E2** can be filled to a level proximate or equal to a height of retention material **128/130** or to any level above or below the retention material. The level of encapsulant **E** can be planar or curved in any suitable manner, such as concave or convex. Retention material **128** can be dispensed first, and  
25 retention material **130** can subsequently and separately (or simultaneously) be dispensed. Retention material **128** only can be dispensed, without also having the extra height of retention material **130**, wherein the height of retention material **128** then allows for the level of encapsulant to be lower (such as shown by the broken line below the top line of encapsulant **E2**)  
30 than what the level could be (**E1**) when retention material **130** is also used. By also using retention material **130**, however, the increased height of retention material **130** allows for the level of encapsulant **E1** to be higher

and/or allows for use of possible secondary optics that can be proximate to, even with, or even above the vertical height of retention material **140**.

In some aspects retention material **128/130** can be configured to have a height at least as tall as PCB **116/118**, and/or at least as tall as metal plating **122**, and in some aspects, as shown in Figure 1, taller than the upper surface of metal plating **122** and/or solder mask **120**. Such a configuration allows for wire bond **WB**, and particularly the connection of the wire bond to the metal plating, to be protected by retention material **128/130**. In some aspects, retention material **128/130** can be applied in two layers to achieve the desired height, i.e. a first layer applied to fill the step up between the upper surface of substrate **112** and the edge of PCB **116/118**, and the second applied on top of the first layer of retention material to cover wire bond **WB**. In some embodiments, wire bond **WB** can optionally comprise an "M-loop" shape, such as disclosed in U.S. Patent No. D753612 commonly owned herewith.

Figures 2A through 2B are plan views of LED component **110** depicted in Figure 1 showing the panel construction design of an LED component with a ceramic substrate and one PCB layer. Figure 1A shows the PCB routing, and particularly the PCB base layer **116** forming, for example only and without limitation, a substantially square body with a circular opening substantially in the center of the square body. The shape can also be any other shape or configuration, such as a rounded shape or configuration. Figure 2B shows further layers including PCB metal layer **118** and solder mask **120**. Metal plating **122** is also visible on the inner most portion of the circular opening as well as one or more contact pads. Finally, Figure 2C illustrates the LED component **110** with all layers depicted in Figure 1, including for example ceramic substrate **112**. One corner of LED component **110** can comprise a mark, e.g. a positive (+) or negative (-) symbol, for identifying electrical characteristics for a particular side of LED component **110**. For example, the positive (+) or negative (-) symbol can designate the side of the component comprising the anode or cathode.

Although not shown in Figures 2A through 2C, one or more light emitters such as LEDs or LED chips **114**, as shown in the cross-sectional view of Figure 1, can mount to or be disposed in the circular opening. The cross-sectional view of Figure 1 is representative of that taken along line X of  
5 Figure 2C, featuring each of the layers of LED component **110**.

Figure 3 illustrates a cross-sectional view of a light emitter package or LED component, generally designated **110**. LED component **110** as shown for example in Figure 3 can comprise a metal substrate **140**, including for example, but not limited to, aluminum, copper, etc., that can be of any  
10 suitable shape and configuration. On top of metal substrate **140** a mirror or reflective surface **142** can be provided. In some embodiments the use of a metal base mirror substrate, including metal substrate **140** and mirror **142**, can provide relatively high thermal conductivity, particularly as compared to a ceramic based substrate. Thus, in some aspects a mirrored metal  
15 substrate can be best suited for high power, or high lumen per dollar/cost (LP\$), applications.

Mirror or reflective surface **142** can, for example and without limitation, be positioned and disposed on substrate **140** as shown in Figure 3. In another aspect, mirror **142** can optionally instead be positioned and/or  
20 disposed on any surface or area of substrate **140**, including for example on a bottom surface of substrate **140** (i.e., a surface opposing the top surface on which one or more LED chips **114** are disposed). Mirror **140** can, for example, comprise a metal reflector (e.g., a silver layer and/or aluminum layer), a white thermal compound, or any other material known to limit loss  
25 through the bottom surface of substrate **140**, thereby further improving total reflection of LED component **110**.

Referring again to Figure 3, metal substrate **140** can for example be formed without any cavity or recess so that one or more LED chips **114** are disposed on and can mount to substrate **140**. As one example, substrate  
30 **140** can comprise a surface, such as an upper surface, that can but does not have to be disposed along a single plane. The one or more LED chip(s), such as LED chip **114**, can be mounted directly to the surface of

substrate/body **140** with only a thin adhesive layer (e.g., silicone or epoxy) between substrate **140** and LED chip **114** (i.e., without any intervening layer, such as a metal or other layer, as shown for example in Figure 3).

LED chip **114** can be electrically connected, such as by wirebonds  
5 **WB** or any other suitable technique, to one or more electrical components. Wirebond **WB** can comprise an electrically conductive wire or conduit material. As used herein, electrical components can, for example and without limitation, comprise electrical traces, leads, electrical pads, metal plating, contact or bond pads, or any other suitable electrical component. For  
10 example, metal plating **122** can comprise a copper foil having wire-bondable gold or silver portions provided thereon. In some instances, two or more metal plates **122** can be provided and can serve as a cathode and the other as an anode for supplying LED chips **114** with current to illuminate an active layer within the LED chip. Such LED chips **114** can in some aspects be  
15 referred to as top-side contact chips or dies. Alternatively, LED chip **114** may be a flip-chip bonded to one or more electrical components, such as for example metal plating **122**. Any other suitable bonding techniques could be used as well.

Regardless of the specific connection, metal plating **122** can in some  
20 embodiments be separated from substrate **140** by one or more additional layers or components. For instance, as shown in Figure 3, an adhesive layer **124** can be applied to an upper surface of substrate **140**, or upper surface of mirror **142**, upon which a printed circuit board (PCB) base layer **116** can be positioned, upon which a PCB metal layer **118** can be positioned. Moreover,  
25 in some aspects a solder mask **120** can be positioned or layered on an upper surface of device **110**, including on PCB metal layer **118**, on PCB base layer **116**, or both.

Adhesive layer **124** can be configured to adhere PCB **116** to substrate  
**140** and/or mirror **142**. Adhesive layer **124** can comprise, for example, an  
30 organic-based adhesive, a pressure-sensitive adhesive (PSA), and/or an epoxy or silicone adhesive.

By connecting LED chip **114** and electrical components/metal plating **122** to substrate **140** using one or more intervening layers, e.g., adhesive layer **124**, PCB base layer **116** and/or PCB metal layer **118**, the manufacturability of LED component **110** can in some embodiments be greatly improved. Specifically, for example, prior art methods can in some aspects require resource-intensive processes in which a seed layer is deposited on the substrate by physical vapor deposition or the like, and copper is plated on the seed layer to produce electrical traces on the substrate. Other metals are typically plated on the copper to make them wire-bondable. Such methods can require a number of additional processing steps with respect to substrate **140**, and these additional processing steps can leave contaminants on the ceramic surface, which can be difficult to remove and can negatively impact the performance (e.g., brightness) and reliability of the device. In contrast, using one or more intervening layers can in some aspects allow metal plating **122** to be adhered to substrate **140** in a comparatively simpler process. In such a configuration, the trace pattern can be formed separate from substrate **140** and applied using a lamination technique, such as for example a heat press and/or an overpressure chamber (i.e., autoclave) lamination technique with an adhesive film known to those having skill in the art in the multi-layer printed circuit board industry.

Printed circuit boards **116/118** can comprise a flexible printed circuit board ("flectape" PCB), such as PCB base **116**, comprising a polymer-like film, that can have at least one conductive layer, such as PCB metal **118**, within one or more layers of a flexible plastic resin (e.g., polyimide, Kapton from DuPont,). In some aspects adhesive layer **124** can comprise a tape-like adhesive provided on the flectape for easy connection of PCB **116/118** to substrate **140** and/or mirror **142**. It should be recognized, however, that PCB **116/118** can comprise any material used in multilayer PCBs or flex PCBs, including prepreg materials, reinforced laminates (e.g., glass-reinforced epoxy, materials using carbon fiber), and non-reinforced materials.

As further illustrated in Figure 3, additional components can be integrated into LED component **110** to improve the performance and

manufacturability thereof. For example, LED component **110** can further comprise an electrically insulating solder mask **120** in one or more locations, particularly on an upper surface of component **110**. Solder mask **120** can be disposed on PCB **116/118**, and in some embodiments at least partially on  
5 and/or adjacent to metal plating **122**, such that when solder is used to attach one or more wires to an electrical solder pad (not shown), the solder will be contained within the predefined area. Choosing a white solder mask can improve the overall reflectivity of LED component **110**.

LED component **110** shown in Figure 3 can further comprise a  
10 retention material such as retention material **128** or **130** disposed at least partially about an emission area in which LED chip **114** is positioned, where retention material **128/130** can be referred to as a dam. Retention material **128/130** can for example be dispensed. After application or placement of retention material **128/130**, such as for example by dispensing of retention  
15 material **128/130**, an encapsulant **E** can be disposed within the recess formed thereby. An encapsulant such as encapsulant **E1** or **E2** can contain one or more phosphors such that light emitted from the one or more LED chips **114** can produce an emission of a desired wavelength. Encapsulant **E1** or **E2** can be selectively filled to any suitable level within the space  
20 disposed between one or more inner walls of retention material **128/130**. For example, encapsulant **E1/E2** can be filled to a level proximate or equal to a height of retention material **128/130** or to any level above or below the retention material. The level of encapsulant **E1** or **E2** can be planar or curved in any suitable manner, such as concave or convex. Retention  
25 material **128** can be dispensed first, and retention material **130** can subsequently and separately (or simultaneously) be dispensed. Retention material **128** only can be dispensed, without also having the extra height of retention material **130**, wherein the height of retention material **128** then allows for the level of encapsulant to be lower (such as shown by the broken  
30 line below the top line of encapsulant **E2**) than what the level could be (**E1**) when retention material **130** is also used. By also using retention material **130**, however, the increased height of retention material **130** allows for the

level of encapsulant **E1** to be higher and/or allows for use of possible secondary optics that can be proximate to, even with, or even above the vertical height of retention material **140**.

In some aspects retention material **128/130** can be configured to have  
5 a height at least as tall as PCB **116/118**, and/or at least as tall as metal plating **122**, and in some aspects, as shown in Figure 3, taller than the upper surface of metal plating **122** and/or solder mask **120**. Such a configuration allows for wire bond **WB**, and particularly the connection of the wire bond to the metal plating, to be protected by retention material **128/130**. In some  
10 aspects, retention material **128/130** can be applied in two layers to achieve the desired height, i.e. a first layer applied to fill the step up between the upper surface of substrate **140/mirror 142** and the edge of PCB **116/118**, and the second applied on top of the first layer of retention material to cover wire bond **WB**.

15 Figures 4A through 4C are plan views of LED component **110** depicted in Figure 3 showing the panel construction design of an LED component with a ceramic substrate and one PCB layer. Figure 4A shows the PCB routing, and particularly the PCB base layer **116** forming, for example only and without limitation, a substantially square body with a  
20 circular opening substantially in the center of the square body. The shape can also be any other shape or configuration, such as a rounded shape or configuration. Figure 4B shows further layers including PCB metal layer **118** and solder mask **120**. Metal plating **122** is also visible on the inner most portion of the circular opening as well as one or more contact pads. Figure  
25 4C illustrates LED component **110** with all layers depicted in Figure 3, including for example metal substrate **140**. One corner of LED component **110** can comprise a mark, e.g. a positive (+) or negative (-) symbol, for identifying electrical characteristics for a particular side of LED component **110**. For example, the positive (+) or negative (-) symbol can designate the  
30 side of the component comprising the anode or cathode.

Although not shown in Figures 4A through 4C, one or more light emitters such as LEDs or LED chips **114**, as shown in the cross-sectional

view of Figure 3, can mount to or be disposed in the circular opening. The cross-sectional view of Figure 3 is representative of that taken along line X of Figure 4C, featuring each of the layers of LED component **110**.

Figure 5 illustrates a cross-sectional view of a light emitter package or LED component, generally designated **110**. LED component **110** depicted in Figure 5 comprises additional material layers, especially as compared to those of Figures 1 and 3, for example, to provide a LED component with multi-layer substrate.

More particularly, by way of example and not limitation, LED component **110**, as shown for example in Figure 5, can comprise a metal substrate **140** that can be of any suitable shape and configuration. On top of metal substrate **140** a mirror or reflective surface **142** can be provided. In some embodiments the use of a metal base mirror substrate, including metal substrate **140** and mirror **142**, can provide relatively high thermal conductivity, particularly as compared to a ceramic based substrate. Thus, in some aspects a mirrored metal substrate can be best suited for high power, or high lumen per dollar/cost (LP\$), applications.

Mirror or reflective surface **142** can, for example and without limitation, be positioned and disposed on substrate **140** as shown in Figure 5. In another aspect, mirror **142** can optionally instead be positioned and/or disposed on any surface or area of substrate **140**, including for example on a bottom surface of substrate **140** (i.e., a surface opposing the top surface on which one or more LED chips **114** are disposed). Mirror **140** can, for example, comprise a metal reflector (e.g., a silver layer), a white thermal compound, or any other material known to limit loss through the bottom surface of substrate **140**, thereby further improving total reflection of LED component **110**.

Referring again to Figure 5, metal substrate **140** can for example be formed without any cavity or recess so that one or more LED chips **114** are disposed on and can mount to substrate **140**. As one example, substrate **140** can comprise a surface, such as an upper surface, that can but does not have to be disposed along a single plane. The one or more LED chip(s),

such as LED chip **114**, can be mounted directly to the surface of substrate/body **140** with only a thin adhesive layer (e.g., silicone or epoxy) between substrate **140** and LED chip **114** (i.e., without any intervening layer, such as a metal or other layer, as shown for example in Figure 3).

5           LED chip **114** can be electrically connected, such as by wirebonds **WB** or any other suitable technique, to one or more electrical components. As used herein, electrical components can, for example and without limitation, comprise electrical traces, leads, electrical pads, metal plating, contact or bond pads, or any other suitable electrical component. Wirebond  
10 **WB** can comprise an electrically conductive wire or conduit material. For example, metal plating **122** can comprise a copper foil having wire-bondable gold or silver portions provided thereon. In some instances, two or more metal plates or plating **122** can be provided and can serve as a cathode and the other as an anode for supplying LED chips **114** with current to illuminate  
15 an active layer within the LED chip. Such LED chips **114** can in some aspects be referred to as top-side contact chips or dies. Alternatively, LED chip **114** may be a flip-chip bonded to one or more electrical components, such as for example metal plating **122**. Any other suitable bonding techniques could be used as well.

20           Regardless of the specific connection, metal plating **122** can in some embodiments be separated from substrate **140** by one or more additional layers or components. For instance, as shown in Figure 5, an adhesive layer **124** can be applied to an upper surface of substrate **140**, or upper surface of mirror **142**, upon which material layers can be applied, e.g. a plurality of  
25 printed circuit boards (PCBs), solder mask and/or prepreg layers. Adhesive layer **124** can be configured to adhere PCB **150/152**, and/or solder mask **120**, to substrate **140** and/or mirror **142**. Adhesive layer **124** can comprise, for example, an organic-based adhesive, a pressure-sensitive adhesive (PSA), and/or an epoxy or silicone adhesive.

30           By connecting LED chip **114** and electrical components/metal plating **122** to substrate **140** using one or more intervening layers, e.g., adhesive layer **124**, PCB base layer **150** and/or PCB metal layer **152**, the

manufacturability of LED component **110** can in some embodiments be greatly improved. Specifically, for example, prior art methods can in some aspects require resource-intensive processes in which a seed layer is deposited on the substrate by physical vapor deposition or the like, and  
5 copper is plated on the seed layer to produce electrical traces on the substrate. Other metals can be plated on the copper to make them wire-bondable. Such methods can require a number of additional processing steps with respect to substrate **140**, and these additional processing steps can leave contaminants on the ceramic surface, which can be difficult to  
10 remove and can negatively impact the performance (e.g., brightness) and reliability of the device. In contrast, using one or more intervening layers can in some aspects allow metal plating **122** to be adhered to substrate **140** in a comparatively simpler process. In such a configuration, the trace pattern can be formed separate from substrate **140** and applied using a lamination  
15 technique, such as for example a heat press and/or an overpressure chamber (i.e., autoclave) lamination technique with an adhesive film known to those having skill in the art in the multi-layer printed circuit board industry.

In the embodiment depicted in Figure 5, a plurality of PCB, solder mask and prepreg layers are provided, in some embodiments to form one or  
20 more, or at least two, non-coplanar layers or surfaces. For example, a first PCB base layer **150** can be positioned proximate to mirrored substrate **140/142**, upon which a first PCB metal layer **152** can be positioned. In some aspects, the first PCB base layer **150** and first PCB metal layer **152** can together be referred to as the first PCB layer. A second PCB layer can be  
25 built upon the first PCB layer, the second PCB layer comprising a second PCB base layer **154** and second PCB metal layer **156**, as depicted in Figure 5. Moreover, in some aspects a solder mask **120** can be positioned or layered on an upper surface of device **110**, including on second PCB metal layer **156**, on second PCB base layer **154**, or both. Moreover, in some  
30 aspects solder mask **120** can extend below first PCB base layer **150**, in some embodiments by way of via **160**. In some aspects, a prepreg **158**, or

prepreg layer, can be positioned between first PCB layer **150/152** and second PCB layer **154/156**.

Printed circuit boards **150/154** can comprise a flexible printed circuit board (“flectape” PCB), comprising a polymer-like film, that can have at least  
5 one conductive layer, such as PCB metal **152/156**, within one or more layers of a flexible plastic resin (e.g., polyimide, Kapton from DuPont,). In some aspects, adhesive layer **124** can comprise a tape-like adhesive provided on the flectape for easy connection of PCB **150/152**, or solder mask **120**, to substrate **140** and/or mirror **142**. It should be recognized, however, that PCB  
10 **150/154** can comprise any material used in multilayer PCBs or flex PCBs, including prepreg materials, reinforced laminates (e.g., glass-reinforced epoxy, materials using carbon fiber), and non-reinforced materials. In some aspects PCB **150/154**, or other suitable material, can form one or more, or at least two, non-coplanar surfaces comprising an electrical component and  
15 mounted on the top surface of the metallic substrate. In some embodiments one or more of these non-coplanar surfaces can be electrically coupled to the one or more light emitter devices.

As noted above, solder mask **120** can be positioned or layered on an upper surface of device **110**, including on second PCB metal layer **156**, on  
20 second PCB base layer **154**, or both. It can also be configured to extend, in some aspects continuously from the upper surface, below first PCB base layer **150**, in some embodiments by way of via **160**. Solder mask **120** can be disposed at least partially on and/or adjacent to metal plating **122**, such that when solder is used to attach one or more wires to an electrical solder pad  
25 (not shown), the solder will be contained within the predefined area. Choosing a white solder mask can improve the overall reflectivity of LED component **110**.

In some embodiments, via **160** can comprise a thermally conductive via disposed, or buried, within the plurality of layers of PCBs and prepregs,  
30 as depicted in Figure 5. Such a configuration can in some aspects provide a pathway to conduct heat, such as heat produced by LED **114**. In one aspect, multiple conductive thermal vias **160** can be used to dissipate the heat

released from the one or more LED chips **114**. Conductive thermal vias **160** can conduct heat away from LED component **110** by causing heat to flow on a path out from the one or more LED chips **114** and any intervening layers, such as PCBs **150**, **152**, **154** and/or **156**. Conductive thermal vias **160** can  
5 comprise any thermally conductive material known in the art, for example silver metal, which can assist in minimizing junction temperature difference between the LED chip(s) and an external sink or surface, thus prolonging the life of LED component **110**.

In Figure 5, LED component **110** can further comprise a retention  
10 material such as retention material **128** or **130** disposed at least partially about an emission area in which LED chip **114** is positioned, where retention material **128/130** can be referred to as a dam. Retention material **128/130** can for example be dispensed. After application or placement of retention material **128/130**, such as for example by dispensing of retention material  
15 **128/130**, an encapsulant **E1/E2** can be disposed within the recess formed thereby. An encapsulant such as encapsulant **E1** or **E2** can contain one or more phosphors such that light emitted from the one or more LED chips **114** can produce an emission of a desired wavelength. Encapsulant **E1** or **E2** can be selectively filled to any suitable level within the space disposed  
20 between one or more inner walls of retention material **128/130**. For example, encapsulant **E1/E2** can be filled to a level proximate or equal to a height of retention material **128/130** or to any level above or below the retention material. The level of encapsulant **E1** or **E2** can be planar or curved in any suitable manner, such as concave or convex. Retention material **128** can be  
25 dispensed first, and retention material **130** can subsequently and separately (or simultaneously) be dispensed. Retention material **128** only can be dispensed, without also having the extra height of retention material **130**, wherein the height of retention material **128** then allows for the level of encapsulant to be lower (such as shown by the broken line below the top  
30 line of encapsulant **E2**) than what the level could be (**E1**) when retention material **130** is also used. By also using retention material **130**, however, the increased height of retention material **130** allows for the level of

encapsulant **E1** to be higher and/or allows for use of possible secondary optics that can be proximate to, even with, or even above the vertical height of retention material **140**.

In some aspects therefore, retention material **128/130** can be  
5 configured to have a height at least as tall as the plurality of layers of PCBs, prepregs and solder masks, as depicted in Figure 5. More particularly, dam or retention material **128/130** can be configured to be at least as tall as metal plating **122**, and in some aspects, as shown in Figure 5, taller than the upper surface of metal plating **122** and/or solder mask **120**, all of which is on top of  
10 first and second PCBs. Such a configuration allows for wire bond **WB**, and particularly the connection of the wire bond to the metal plating, to be protected by retention material **130**.

In some embodiments a first PCB layer **150/152** can provide an inner ledge extending more inward toward LED chip **114** as compared to second  
15 PCB layer **154/156**, and at a lower height. Stated another way, when viewed from the top down, e.g. as in Figures 6A-6C, the center cutout for first PCB layer **150** is smaller than the center cutout for second PCB layer **154**. This stepped configuration provided by the multi-layered arrangement provides an inner ledge upon which metal plating **122**, or electrical contact, can be  
20 applied. Metal plating **122** on this PCB layer **150** ledge provides a location for wire bonding **WB** that is recessed and protected from inadvertent contact from an outside force, thereby making LED component **110** more robust. Because the wired bonding **WB** is both recessed below the height of the second PCB layer **154** and covered with retention material **128/130**, it is less  
25 likely to be impacted and damaged by outside forces.

In some aspects, retention material **130** can be applied in two layers to achieve the desired height, i.e. a first layer (such as retention material **128**) applied to fill the step up between the upper surface of substrate **140/mirror 142** and the edge of first PCB **150/152**, and the second layer  
30 applied on top of the first layer of retention material **128/130** to cover wire bond **WB**. Whether applied in one, two, or more layers, retention material

**128/130** can be configured to cover the recessed ledge between first PCB layer **150** and second PCB layer **154**, and protect wire bond **WB**.

In some embodiments, the height of second PCB layer **154** can be configured at any desirable height, or thickness, to achieve the desired depth of the step between first and second PCB layers. The depth of the retention material **128/130** can be configured to correspond to this depth/height so as to extend at least level with, or in some aspects above, the plurality of layers, including for example an upper surface of solder mask **120**. In some aspects the depth of retention material **128/130** can correspond to the overall height of the multiple layers of PCBs, prepregs and solder masks, which can be adjusted as desired based the number of layers and/or relative thickness of each.

In some aspects, and still referring for example to Figure 5, a LED component such as LED component **110** can comprise a substrate, such as substrate **140**, and one or more light emitter devices, such as LEDs or LED chips **114**, mounted or disposed on the substrate, where the LED component includes a plurality of non-coplanar surfaces and where the substrate can be metallic or non-metallic, and where the substrate does or does not include a mirrored surface. In this configuration or embodiment, at least one or more of the one or more light emitter devices can be wirebonded to a first electrical component, such as at metal plating **122** of a first PCB layer, such as a first PCB layer **150/152**, and where metal plating **122** is non-coplanar with the substrate and/or the top surface of the one or more light emitter devices on the substrate. A second electrical component of the LED component, such as metal plating of second PCB layer **154/156**, can be non-coplanar with the first electrical component and also non-coplanar with the substrate and the top surface of the one or more light emitter devices on the substrate. The second electrical component can be electrically connected to the first electrical component. While not necessary, a retention material can cover or contact at least a portion of the first electrical component. The second electrical component can comprise an external contact for electrical connection to the LED component.

Figures 6A through 6C are plan views of LED component **110** depicted in Figure 5 showing the panel construction design of an LED component with a ceramic substrate and one PCB layer. Figure 6A shows the PCB routing, and particularly the PCB base layer **150** forming, for example only and without limitation, a substantially square body with a circular opening substantially in the center of the square body. The shape can also be any other shape or configuration, such as a rounded shape or configuration. Figure 6B shows further layers including PCB metal layer **156** and -PCB layer **154**. . Finally, Figure 6C illustrates the LED component **110** with all layers depicted in Figure 5, including for example mirror **142** and vias **160**. One corner of LED component **110** can comprise a mark, e.g. a positive (+) or negative (-) symbol, for identifying electrical characteristics for a particular side of LED component **110**. For example, the positive (+) or negative (-) symbol can designate the side of the component comprising the anode or cathode.

Although not shown in Figures 6A through 6C, one or more light emitters such as LEDs or LED chips **114**, as shown in the cross-sectional view of Figure 5 can mount to or be disposed in the circular opening. The cross-sectional view of Figure 5 is representative of that taken along line X of Figure 6C, featuring each of the layers of LED component **110**.

Figures 7A and 7B provide data demonstrating, for example and without limitation, improved thermal properties of the disclosed LED components and devices. This data is for the LED components and devices as disclosed for example herein. Different features for the LED components and devices can mean that data such as in Figures 7A and beyond are different. Figure 7A is a tabular compilation of performance data for an exemplary LED component (CXB1512) configured in accordance with the instant disclosure. Figure 7B is a plot comparing an exemplary LED component (CXB1512) with Al versus HRA (aluminum mirror versus high reflectivity alumina) and the effects on Delta T versus heat sink over increasing currents (mA). The aluminum mirror and high reflectivity alumina substrates were used as exemplary materials for purposes of collecting the

data presented herein. In Figures 7A and 7B, data in the plot and columns 4 and 5 of the table is the temperature of the LES (light emitting surface) as measured by an IR camera with a given heat sink temp (column 2) at a given current (column 3). Column 6 is the difference between 4 (ceramic) and 5 (metal). The plot is showing relative temperature change with current: at 0 current, delta TLES is 0 or with current applied add the value from the curve to the heat sink temperature. Figures 7C and 7D demonstrate the improved optical properties of the disclosed LED components and devices. Figure 7C shows the lumen output over increasing power (W) for an exemplary LED component (CXB1512) with a mirrored substrate versus a ceramic substrate. Figure 7D shows the lumen per watt (LPW) over increasing power (W) for an exemplary LED component (CXB1512) with a mirrored substrate versus a ceramic substrate. Figures 7C and 7D show the lumen and LPW performance difference for the two products outlined in Figures 7A and 7B. Particularly, ceramic starts with better lumen/LPW performance at lower power, but has quicker droop with increased current due to the thermal properties. As a result, the curve for ceramic crosses under the metal curve. At least one conclusion is that ceramic is better for lower power and high LPW applications, but metal is better for high power and high lumen per dollar applications.

Embodiments of the present disclosure shown in the drawings and described above are exemplary of numerous embodiments that can be made within the scope of the appended claims. It is contemplated that the configurations of LED components such as those disclosed herein can comprise numerous configurations other than those specifically disclosed.

## CLAIMS

What is claimed is:

1. A light emitter device component comprising:
  - a metallic substrate having a top surface;
  - a mirrored surface on at least a portion of the top surface of the metallic substrate;
  - one or more light emitter devices mounted on the top surface of the metallic substrate or the mirrored surface; and
  - one or more electrical components mounted on the top surface of the metallic substrate and electrically coupled to the one or more light emitter devices, wherein the one or more electrical components are spaced from the metallic substrate by a plurality of non-metallic layers.
2. The light emitter device component according to claim 1, wherein the one or more non-metallic layers comprise a plurality of dielectric layers.
3. The light emitter device component according to claim 2, wherein the plurality of dielectric layers comprise a polyimide-based polymer.
4. The light emitter device component according to claim 2, wherein the dielectric layers each comprise a printed circuit board (PCB).
5. The light emitter device component according to claim 4, wherein each printed circuit board comprises FR-4, CEM-3, CEM-4, or a related composite material.
6. The light emitter device component according to claim 4, wherein the PCBs are layered one on top another.

7. The light emitter device component according to claim 6, further comprising a prepreg layer between the two PCB layers.
8. The light emitter device component according to claim 1, wherein the one or more light emitter devices comprise light emitting diode (LED) chips.
9. The light emitter device component according to claim 1, wherein the one or more light emitter devices is mounted directly on the top surface of the metallic substrate or directly on the mirrored surface without any intervening layer other than a thin adhesive layer.
10. The light emitter device component according to claim 1, further comprising a solder mask on an upper surface of the one or more non-metallic layers.
11. The light emitter device component according to claim 1, wherein the one or more non-metallic layers increase thermal conductivity of the light emitter device component as compared to a device with a non-metallic substrate without a plurality of non-metallic layers.
12. The light emitter device component according to claim 1, wherein the light emitter devices are electrically coupled to the one or more electrical components by a wire bond.
13. The light emitter device component according to claim 12, wherein the one or more non-metallic layers form a stepped configuration with a recessed ledge between a first and second non-metallic layer, wherein at least one electrical component and wire bond is located at the recessed ledge.

14. The light emitter device component according to claim 1, wherein the one or more non-metallic layers are mounted to the metallic substrate and adjacent to the one or more light emitter devices.
15. The light emitter device component according to claim 1, wherein a height of the one or more non-metallic layers is greater than a height of the one or more light emitter devices.
16. The light emitter device component according to claim 1, further comprising a retention material in contact with the one or more non-metallic layers, wherein the retention material forms a dam surrounding the one or more light emitter devices.
17. The light emitter device component according to claim 16, wherein a height of the retention material is at least as high as the one or more non-metallic layers, and higher than the one or more light emitter devices.
18. The light emitter device component according to claim 16, wherein the retention material covers a wire bond electrically coupling the one or more light emitter devices to the one or more electrical components.
19. The light emitter device component according to claim 16, wherein the retention material is applied in at least two layers, one on top of another.
20. The light emitter device component according to claim 16, further comprising an encapsulant covering the one or more light emitter devices and contained within the dam formed by the retention material.

21. The light emitter device component according to claim 1, further comprising a via transecting the one or more non-metallic layer.
22. The light emitter device component according to claim 21, wherein a solder mask is provided on an upper surface of the one or more non-metallic layers, and on a lower surface of the one or more non-metallic layers, wherein the solder mask on the upper and lower surfaces are connected by the via.
23. A light emitter device component comprising:
  - a metallic substrate having a top surface;
  - a mirrored surface on at least a portion of the top surface of the metallic substrate;
  - one or more light emitter devices mounted on the top surface of the metallic substrate or the mirrored surface;
  - at least two non-coplanar surfaces comprising an electrical component and mounted on the top surface of the metallic substrate;
  - and
  - a retention material in contact with at least one of the non-coplanar surfaces, wherein the retention material forms a dam surrounding the one or more light emitter devices.
24. The light emitter device of claim 23, wherein one of the non-coplanar surfaces is electrically coupled to the one or more light emitter devices.
25. The light emitter device of claim 23, wherein the one or more non-coplanar surfaces comprise one or more printed circuit boards (PCBs) layered one on top of another.
26. A light emitter device component comprising:
  - a substrate with one or more light emitter devices mounted on the substrate;

at least one or more of the one or more light emitter devices being wirebonded to a first electrical component where the first electrical component is non-coplanar with the substrate; and

a second electrical component that is non-coplanar with the first electrical component and the substrate.

27. The light emitter device of claim 26, wherein the second electrical component is electrically connected to the first electrical component.
28. The light emitter device of claim 26, comprising a retention material that covers or contacts at least a portion of the first electrical component.
29. The light emitter device of claim 26, wherein the second electrical component comprises an external contact for electrical connection.
30. A method of forming a light emitter device component having improved thermal properties, the method comprising:
  - mounting one or more light emitter devices on a top surface of a substrate, the substrate comprising a metallic base with a mirrored upper surface;
  - disposing a plurality of non-metallic layers on the top surface of the substrate and surrounding the one or more light emitter devices; and
  - mounting one or more electrical components to at least one of the non-metallic layers, wherein the one or more electrical components are spaced from the substrate body by the non-metallic layers.
31. The method of forming a light emitter device component according to claim 30, wherein the non-metallic layers comprise one or more

dielectric layers, and wherein the one or more dielectric layers comprise a printed circuit board (PCB).

32. The method of forming a light emitter device component according to claim 31, comprising disposing at least two PCBs one on top of another.
33. The method of forming a light emitter device component according to claim 32, further comprising applying a prepreg layer between the two PCBs.
34. The method of forming a light emitter device component according to claim 30, wherein the one or more light emitter devices comprise light emitting diode (LED) chips.
35. The method of forming a light emitter device component according to claim 30, further comprising electrically coupling the light emitter devices to the one or more electrical components by applying a wire bond.
36. The method of forming a light emitter device component according to claim 35, wherein the non-metallic layers form a stepped configuration with a recessed ledge between a first and second non-metallic layer, wherein at least one electrical component and wire bond is located at the recessed ledge.
37. The method of forming a light emitter device component according to claim 30, wherein a height of one or more of the non-metallic layers is greater than a height of the one or more light emitter devices.
38. The method of forming a light emitter device component according to claim 30, further comprising applying a retention material in contact

with the non-metallic layers, wherein the retention material forms a dam surrounding the one or more light emitter devices.

39. The method of forming a light emitter device component according to claim 38, wherein a height of the retention material is at least as high as one or more of the non-metallic layers, and higher than the one or more light emitter devices.



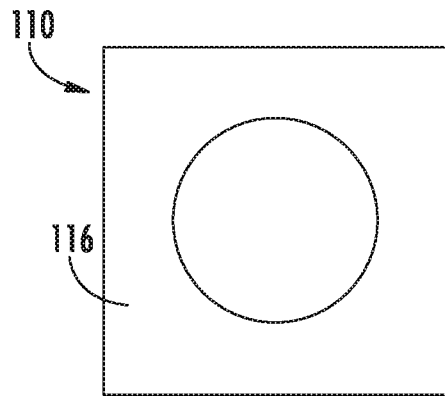


FIG. 2A

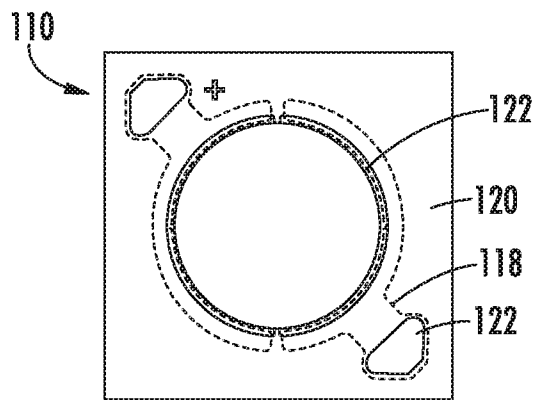


FIG. 2B

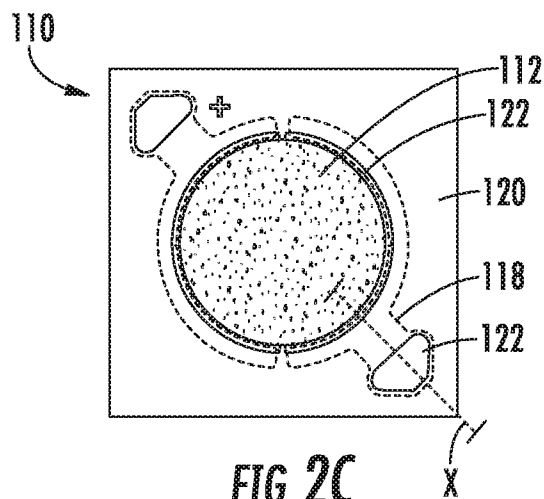


FIG. 2C

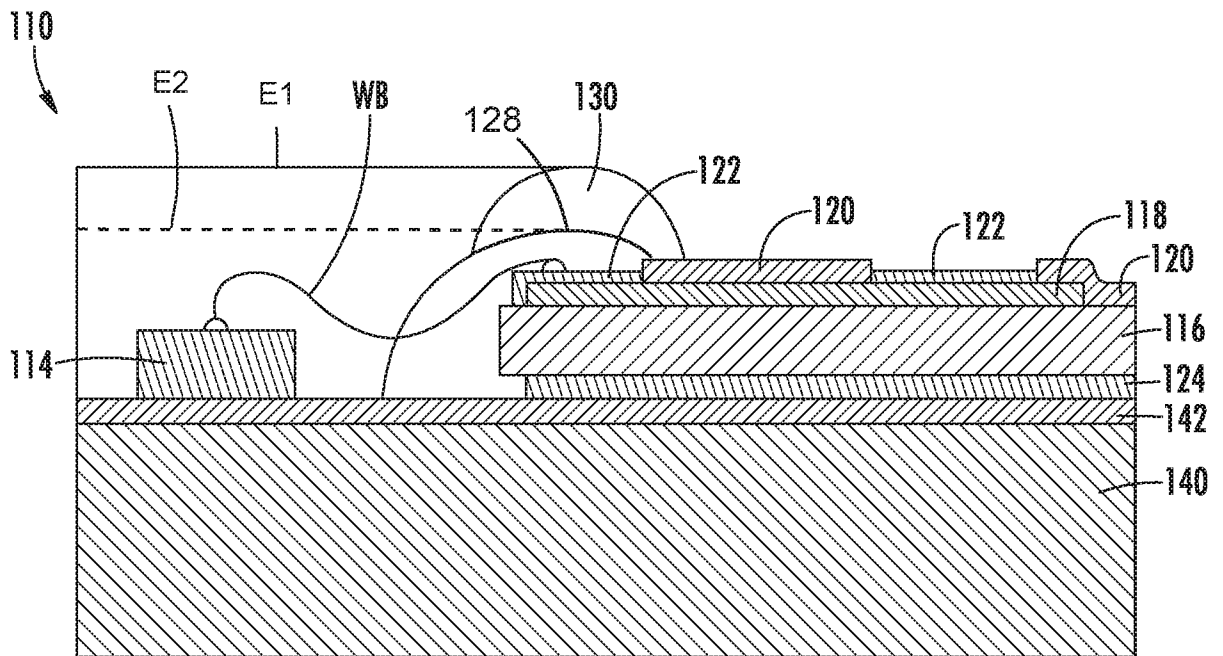


FIG. 3

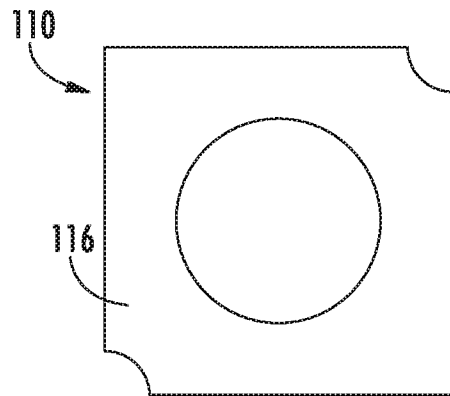


FIG. 4A

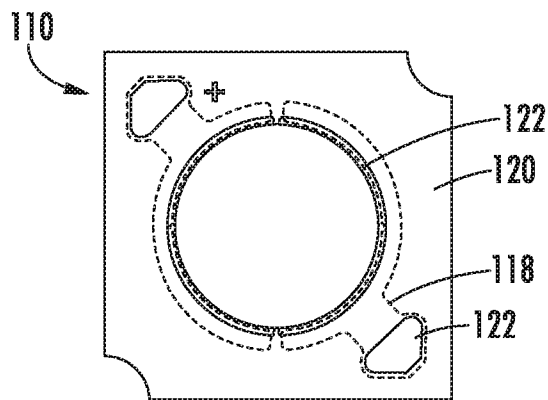


FIG. 4B

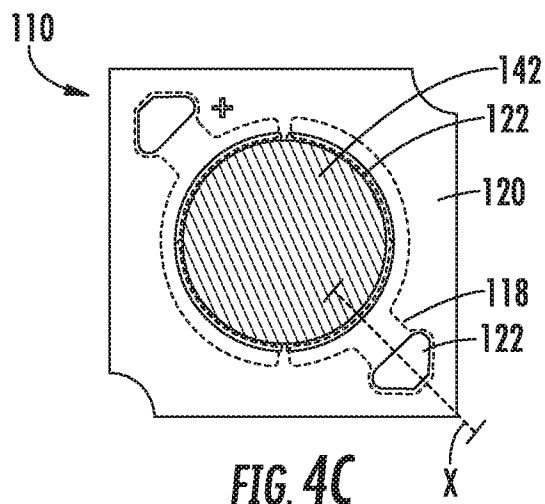


FIG. 4C





PRODUCT	TEMP	CURRENT	T <sub>LES</sub> HRA	T <sub>LES</sub> AL	DELTA
CXB1512	85	350	107.4	101.7	-5.7
CXB1512	85	600	128.6	115.5	-13.0
CXB1512	85	1050	186.7	142.5	-44.2
CXB1512	105	350	127.4	121.7	-5.7
CXB1512	105	600	148.6	135.5	-13.0
CXB1512	105	800	169.4	147.3	-22.1

FIG. 7A

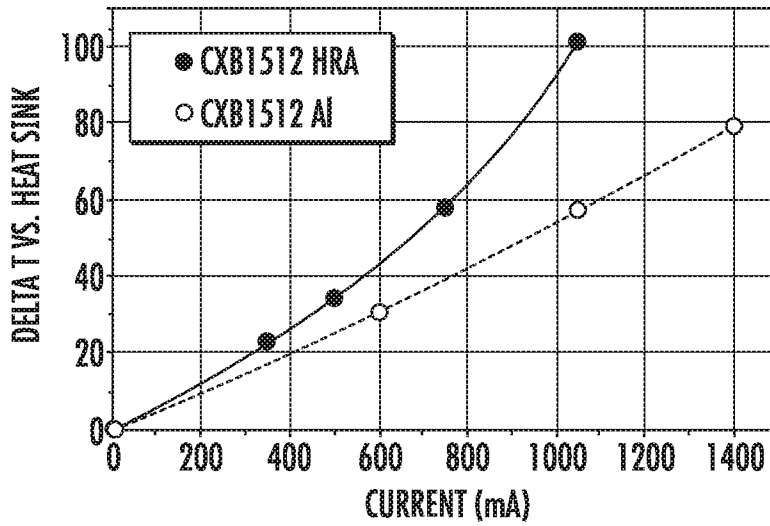


FIG. 7B

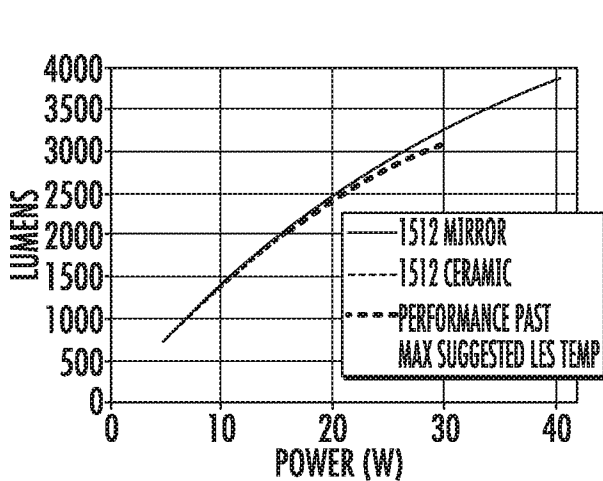


FIG. 7C

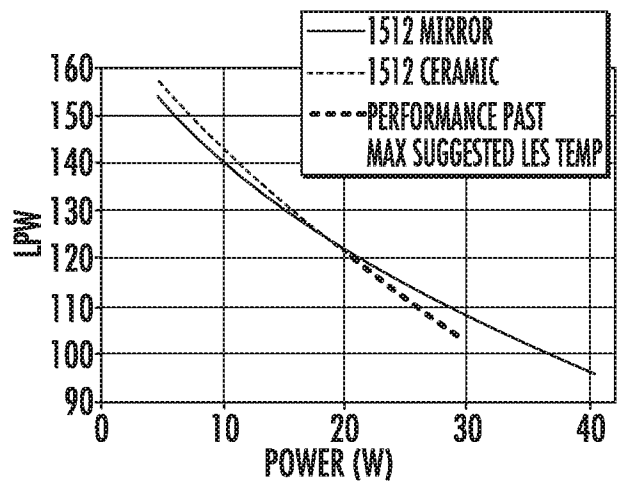


FIG. 7D

**INTERNATIONAL SEARCH REPORT**

International application No  
PCT/US2017/062307

**A. CLASSIFICATION OF SUBJECT MATTER**  
INV. H05K1/05  
ADD.  
  
According to International Patent Classification (IPC) or to both national classification and IPC

**B. FIELDS SEARCHED**  
Minimum documentation searched (classification system followed by classification symbols)  
H05K

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)  
EPO-Internal, WPI Data

**C. DOCUMENTS CONSIDERED TO BE RELEVANT**

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
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Y	paragraphs [0094], [0105] - [0112], [0116]; figures	22
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Further documents are listed in the continuation of Box C.

See patent family annex.

\* Special categories of cited documents :

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- "X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
- "Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art
- "&" document member of the same patent family

Date of the actual completion of the international search  1 March 2018	Date of mailing of the international search report  09/03/2018
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Name and mailing address of the ISA/ European Patent Office, P.B. 5818 Patentlaan 2 NL - 2280 HV Rijswijk Tel. (+31-70) 340-2040, Fax: (+31-70) 340-3016	Authorized officer  Geoghegan, C
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International application No  
PCT/US2017/062307

C(Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT		
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