
EIGHTEENTH ANNUAL
BiTS
TM
Burn-in & Test Strategies Workshop
March 5 - 8, 2017
Hilton Phoenix / Mesa Hotel
Mesa, Arizona
Archive -Tutorial
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Tutorial

BiTS Workshop 2017 Schedule

Tutorial Day

Sunday March 5 - Noon

Interconnect Sockets and Applications

In this tutorial, we will go over the socket contact element fundamentals, types of socket contact elements, contact element materials, and printed circuit board (PCB) & hardware requirements. We will also cover electrical, and system design and test requirements. We will provide you with different options for selecting interconnect sockets depending on your requirements like signal integrity, cycle life, cost, etc.

Ashok Kabadi - AK Technology Leadership

Mohan Prabhugoud - Intel

Tutorial – Abstract

Ashok Kabadi

Mohan Prabhugoud

In this tutorial, we will go over the socket contact element fundamentals, types of socket contact elements, contact element materials, and printed circuit board (PCB) & hardware requirements. We will also cover electrical, and system design and test requirements. We will provide you with different options for selecting interconnect sockets depending on your requirements like signal integrity, cycle life, cost, etc.

At the end of the course, you will have a clear understanding of the types of sockets available in the industry, how to select the best one for your needs, and how to successfully develop and implement the same.

Target audience includes: PCB designers, mechanical engineers, hardware engineers, hardware engineering managers, and materials engineers.

Tutorial – Objectives

Ashok Kabadi

Mohan Prabhugoud

Objectives

- Understand what the interconnect socket is and its benefits
- Understand the contact elements and resistances
- Understand different types of interconnect sockets available in the industry and their applications
- Provide overview of different PCB plating available in the industry and their applications
- Understand mechanical system design methodologies with special emphasis on tolerances, PCB Keep-Out-Zones (KOZs) and retention design
- Provide overview of electrical signal integrity measurements
- Understand test and validation requirements for interconnect technologies
- Understand the entire end-to-end process flow, right from gathering the requirements to successful implementation

Tutorial – Biography

Ashok Kabadi

Mohan Prabhugoud

Ashok Kabadi joined Intel as a Manufacturing Engineer in the Systems Manufacturing Department in 1981. Over his thirty-five year career at Intel, his technological innovations advanced the high-tech industry. His last role was Mechanical Architect and Senior Principal Engineer in the Platform Hardware Group (PHG). Ashok drove the development of multiple advanced platform technologies whichhad significant and measurable impact on improving the cost and time-to-market (TTM) of Intel products as well as external customer products, These technologies included Metallized Particle Interconnect (MPI) sockets, zero keepout (ZKO) sockets, and coax via technology. Ashok was also the key driver for building the Technical Leadership Program in Guadalajara, Mexico (GDC), as well as personally mentoring and growing the pipeline of technical talent in GDC.

He has a deep passion for innovation in the areas of socket interconnect, thermal design, and printed circuit boards. In addition to 16 patents, he has delivered multiple publications, presentations and talks at conferences within the US and internationally. Ashok is now Managing Director of AK Technology (AKT) Leadership providing consulting services and the BiTS Workshop Technical Program Co-chair.

Mohanraj Prabhugoud is currently a Senior Mechanical Engineer at Intel Corporation. He has worked on mechanical design of sockets, socket retention, thermal margining tool, heat sink, PCBs, chassis, etc. for over ten years. Mohan received his MS and PhD in Mechanical Engineering degrees from North Carolina State University.

Interconnect Sockets and Applications

Ashok Kabadi – AK Technology Leadership
Mohan Prabhugoud – Intel Corp.

BiTS Workshop
March 5 - 8, 2017

Agenda

1. **Introduction and Background**
   - Second-Level-Interconnect definition
   - Purpose of sockets
   - Benefits of sockets

2. **Contact Element**
   - Single-compression Vs Dual-compression
   - Contact resistance theory
   - Examples of calculating resistances
   - Relationship between Contact load, Contact travel and Contact resistance

Agenda

3. Types of Contacts

– Polymer –based
  • Metallized and wire-type
– Particle Interconnect
– Metal-based
  • MEMS–based
  • Spring–loaded
  • Stamped-and-formed
  • Screw-machine
  • Buckling
– Summary

Break --- 30 minutes

Agenda

4. Contact Element Material

- Contact material requirement
- Types of material and plating
- Contact material selection

5. Printed-Circuit-Board and Hardware Requirements

- Surface finish requirement
- Mechanical tolerances (positional and absolute)
- Keep-Out Zones (KOZ)

Agenda

6. Electrical Characterization: Signal-Integrity (SI)

- Insertion loss
- Cross-talk
- Current carrying capacity
- Impedance (capacitance and inductance)

Break --- 30 minutes

7. Interconnect Socket and System Design

- Types of interconnect system
- Mechanical hardware design and tolerances
- Force-Deflection analysis

Agenda

8. Socket Interconnect System Testing

- Daisy-chain packages and CRES test board
- Electrical - Test fixture example
- System qualification -- Environmental test

9. Real-world Examples and Summary of Technologies

10. Design Process Flow

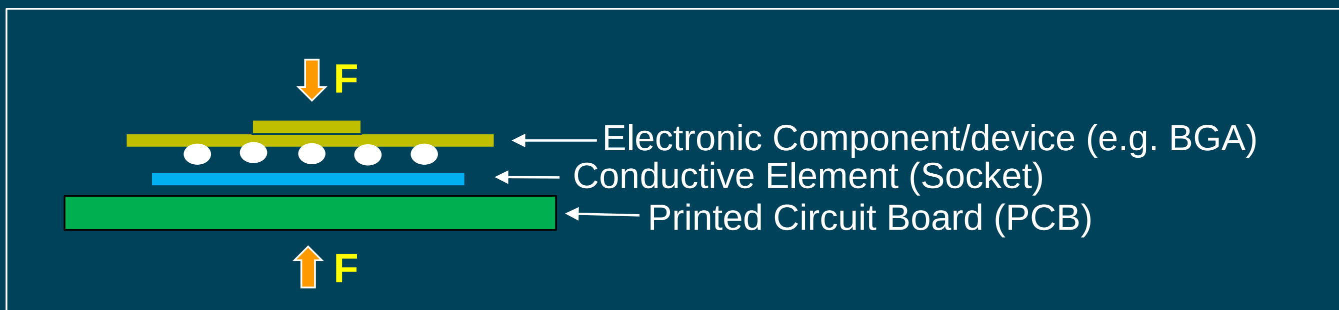
11. References

Section 1
Introduction and Background

Interconnect Socket Definition

- An electrically conductive interface element placed between an electronic component and a printed-circuit-board to make reliable interconnection between the device and PCB

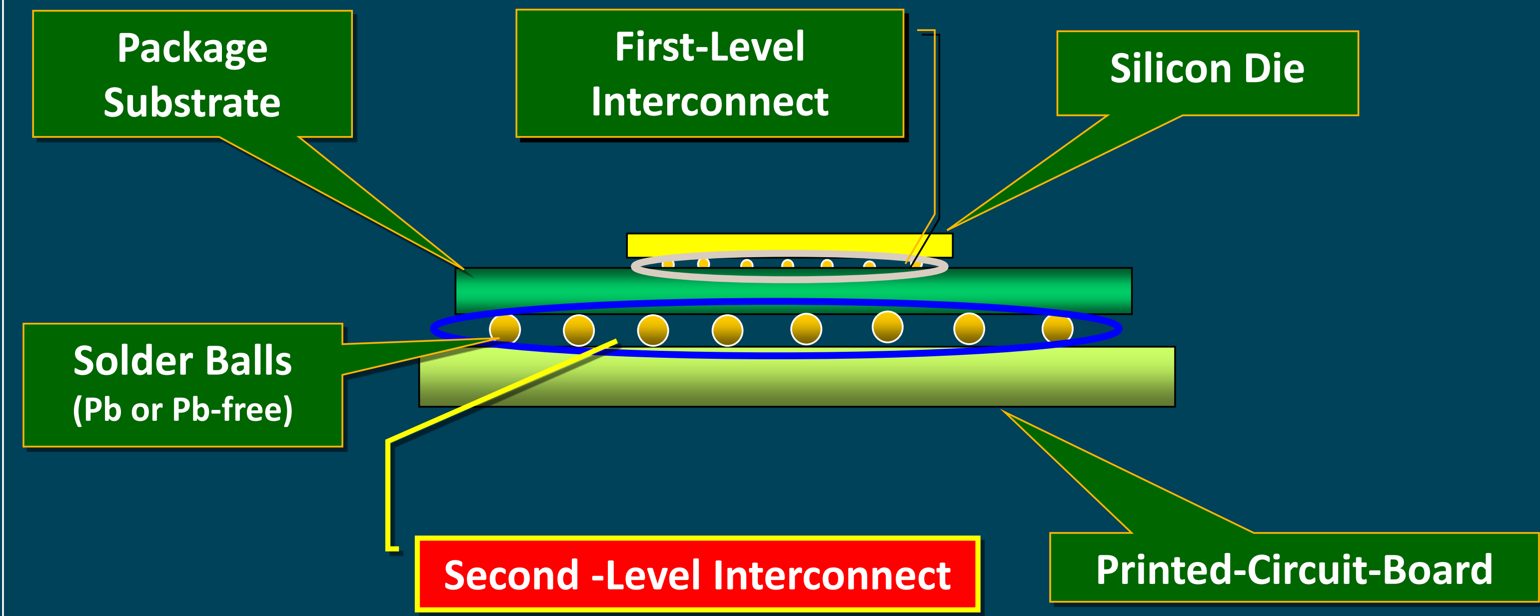
Types of sockets/connectors



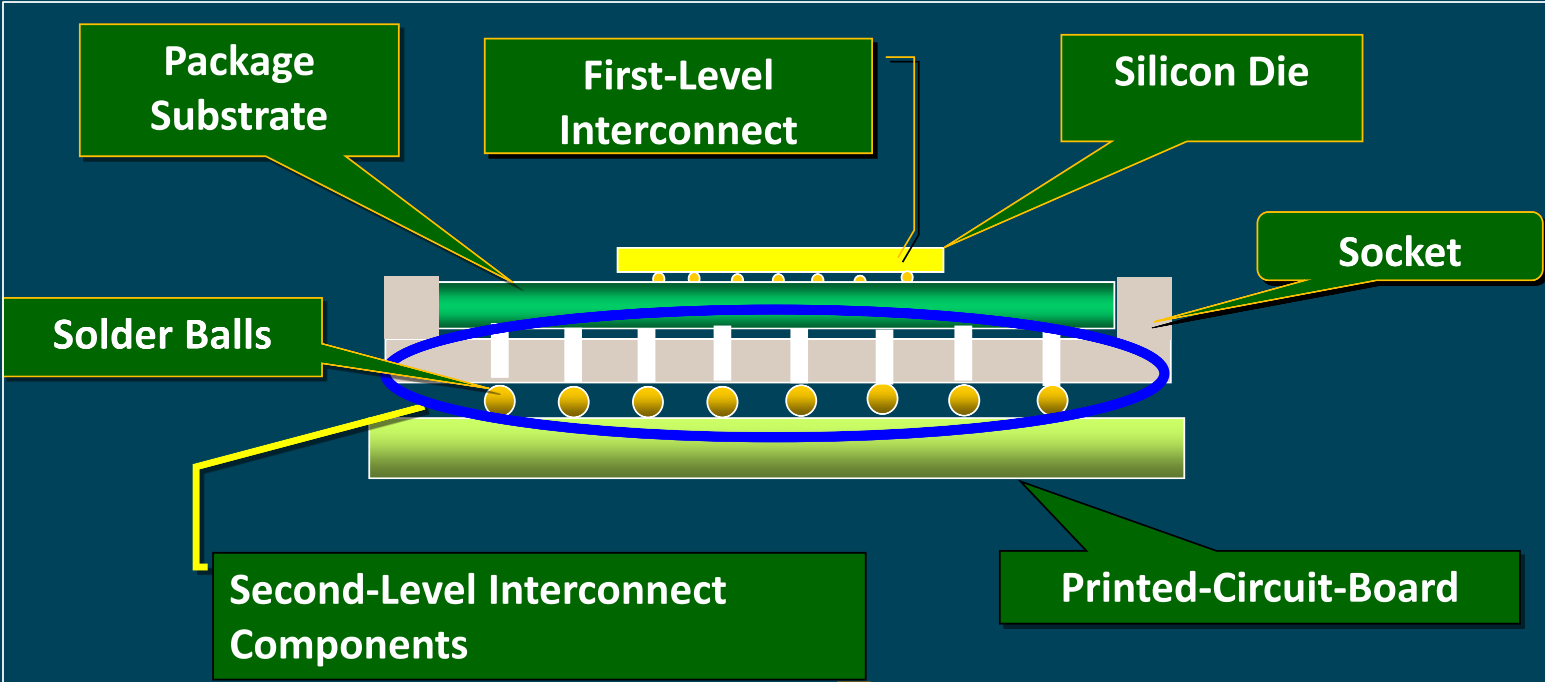
Interconnect Socket Schematic

What is Second-Level-Interconnect (SLI)

JEDEC Definition:



What is Second-Level-Interconnect (SLI)

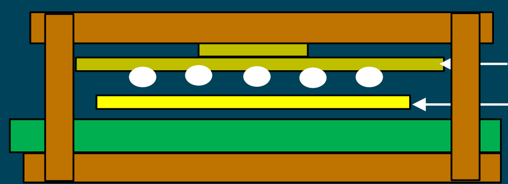


- ❑ Package substrate
- ❑ Package to socket to PCB interconnect system
- ❑ PCB fab

Interconnect System

❑ Interconnect System Solution:

- The Interconnect System is comprised of a conductive socket element and mechanical hardware system.
- The design of the mechanical hardware is dependent on the type of socket and mechanical properties of the socket



Interconnect Socketing System Schematic

Types and Benefits of Sockets

❑ Test Sockets:

- Testing multiple devices using the same socket attached to the same PCB -- cannot be done if the device is soldered
- Typically low volume quantities but requires hundreds of thousands of insertions/removal cycles for high-volume device testing

❑ Validation Sockets:

- Used during the first power-on of the new silicon. Validation of multiple silicon using the same socket attached to same PCB – Cannot be done if the device is soldered

Types and Benefits of Sockets

❑ Validation Sockets (Cont'd.)

- During subsequent silicon stepping changes
- Typically medium volume and requires medium number of insertion/removal cycles

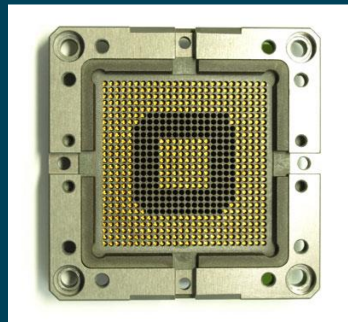
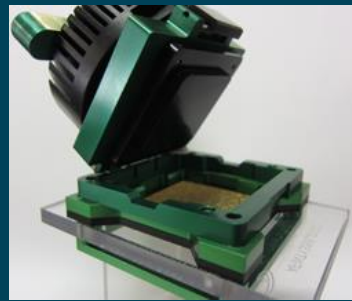
❑ Production Sockets for Products

- Allows PCBs assembled ahead of silicon arrival - Cannot be done if the device is soldered
- Low number of insertion/removal cycles but high volume quantity
- Low cost/unit
- High tooling cost

Examples of Different Types of Sockets

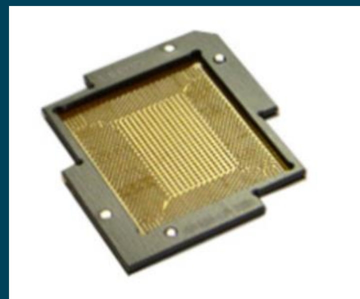
❑Test Sockets

- Typically uses pogo-pins

❑Validation Sockets

- Typically uses elastomeric contact pins

❑Production sockets

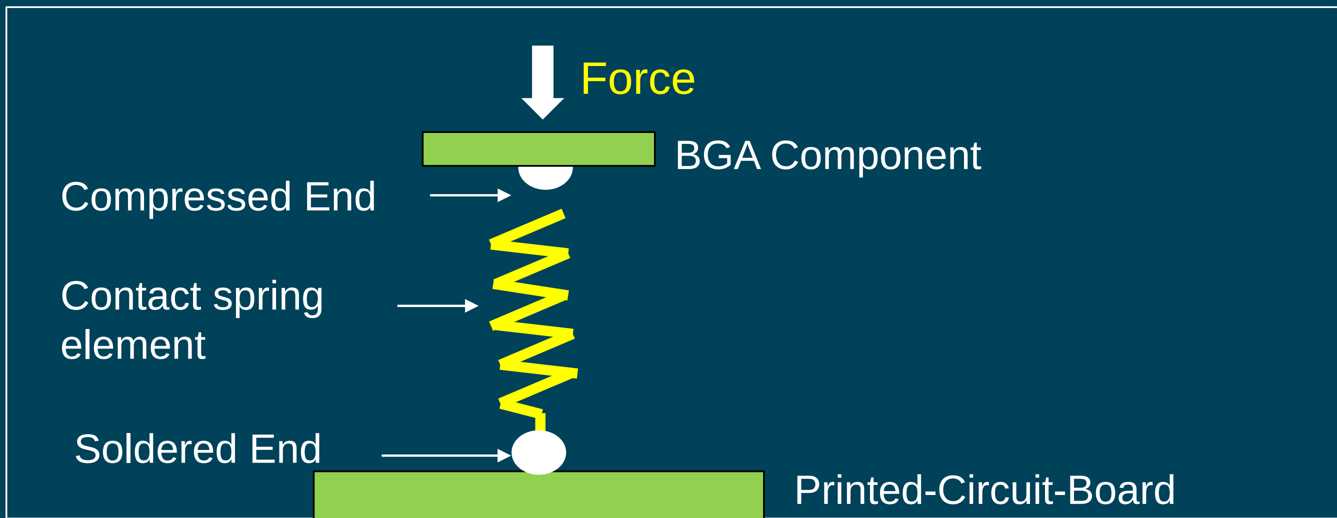
- Typically uses stamped-and - formed pins


Section 2
Contact Element Fundamentals

Single-compression Socket

Definition:

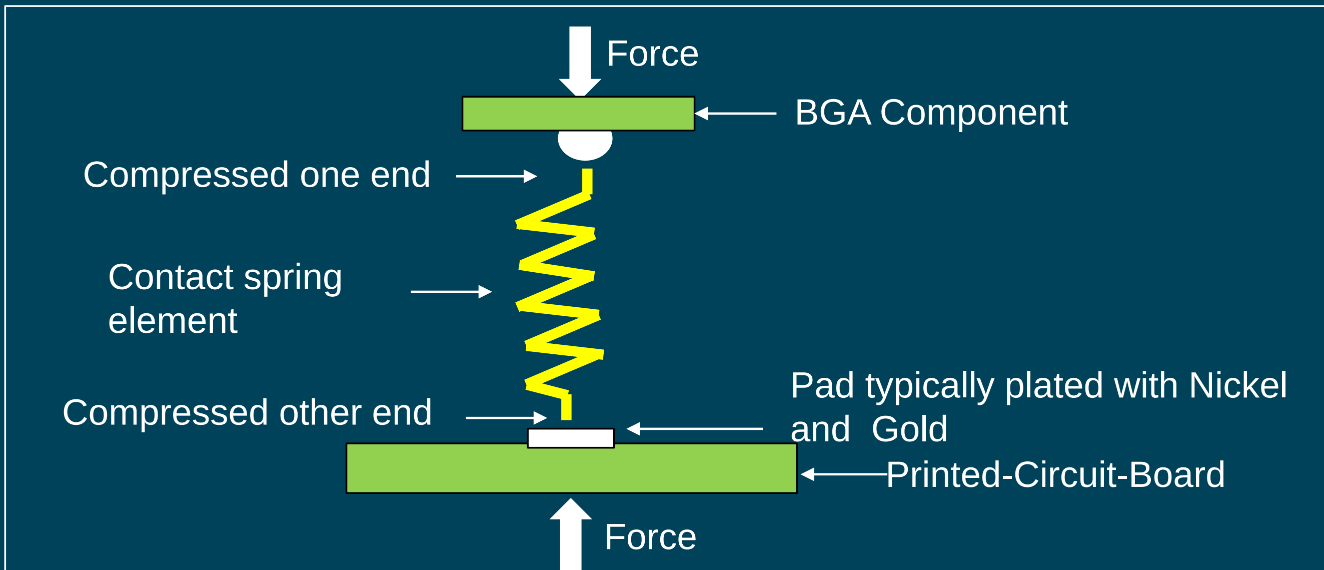
Socket is defined as a single-compression socket when the contact element is soldered to the surface of one device (typically of a PCB) and compressed at the other end where it interfaces with the second device (typically a BGA component)



Dual-compression Socket

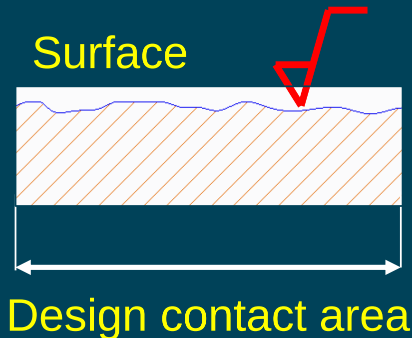
Definition:

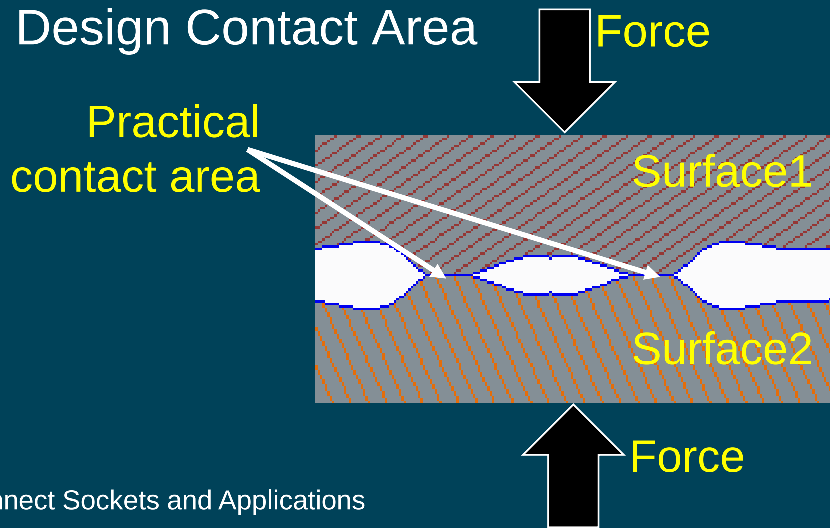
Socket is defined as a dual-compression socket when the contact element is compressed between the two surfaces to make electrical connection. These surfaces are typically PCB at one end and BGA device at the other end.



Contact Resistance Theory

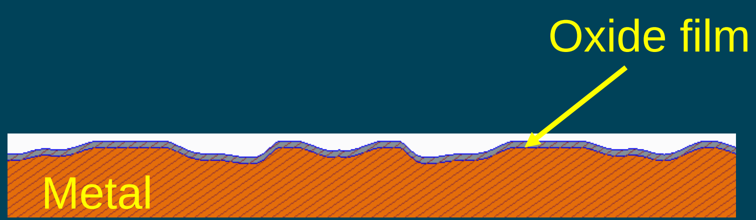
- ❑ Contact resistance occurs between
  - ❑ Interconnect pin surface and PCB pad surface
  - ❑ Interconnect pin surface and solder ball surface
- ❑ Higher contact resistance results in thermal and electrical losses
- ❑ Practical surfaces have surface roughness due to manufacturing operations
- ❑ Practical Contact Area << Design Contact Area

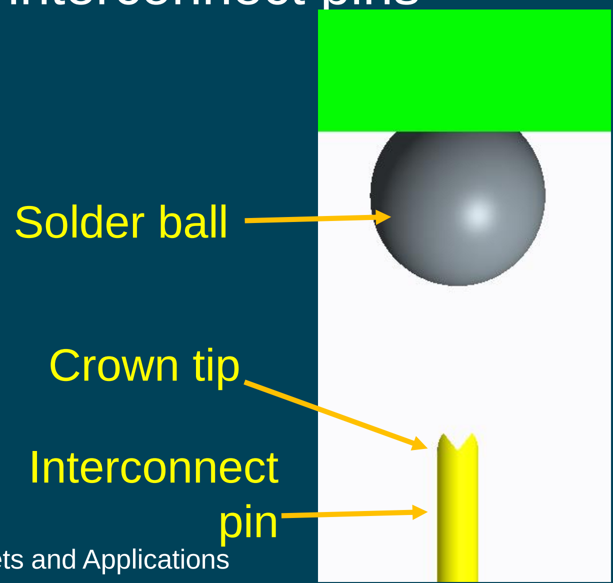




Contact Resistance Theory (Cont'd.)

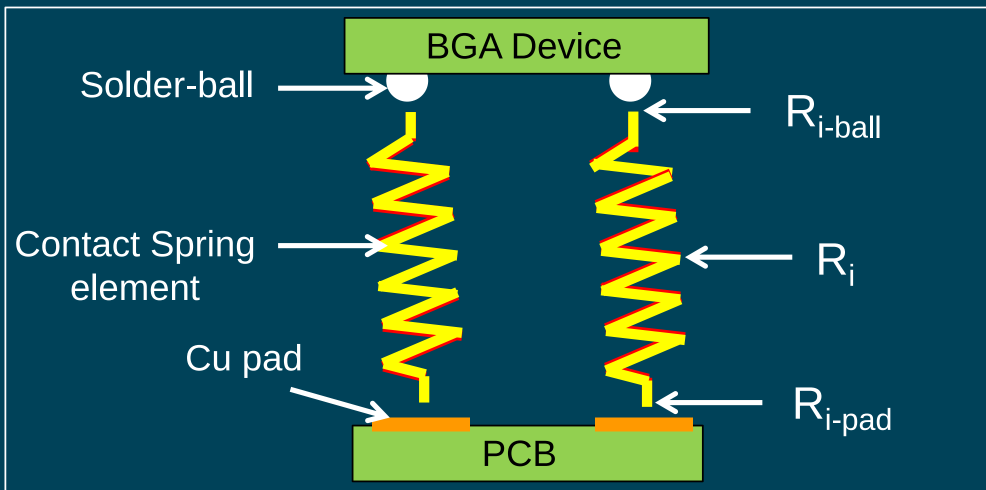
- ❑ Thin film forms on metal surfaces (Cu, W, Ag, etc) due to oxidation
- ❑ Interconnect pin wiping action is used to break oxide film lowering contact resistance
- ❑ Interconnect pin punctures into oxide film lowering contact resistance for vertical interconnect pins

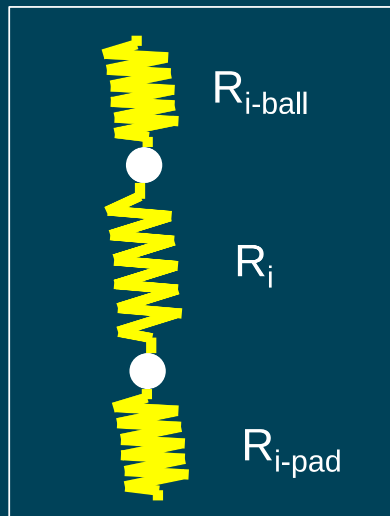




Contact Resistance Theory (Cont'd.)

- Total Contact Resistance = $R_{i\text{-}ball} + R_i + R_{i\text{-}pad}$
  - $R_{i\text{-}ball}$: Contact resistance between interconnect and ball
  - R_i: Bulk resistance of interconnect
  - $R_{i\text{-}pad}$: Contact resistance between interconnect and PCB pad





Contact Resistance Theory: Bulk Resistance

- Bulk Resistance $R_i = \frac{\rho L}{A}$
  - ρ: Resistivity of the interconnect material (Ω-m)
  - L: Length of the interconnect (m)
  - A: Cross-sectional area of interconnect (m^2)

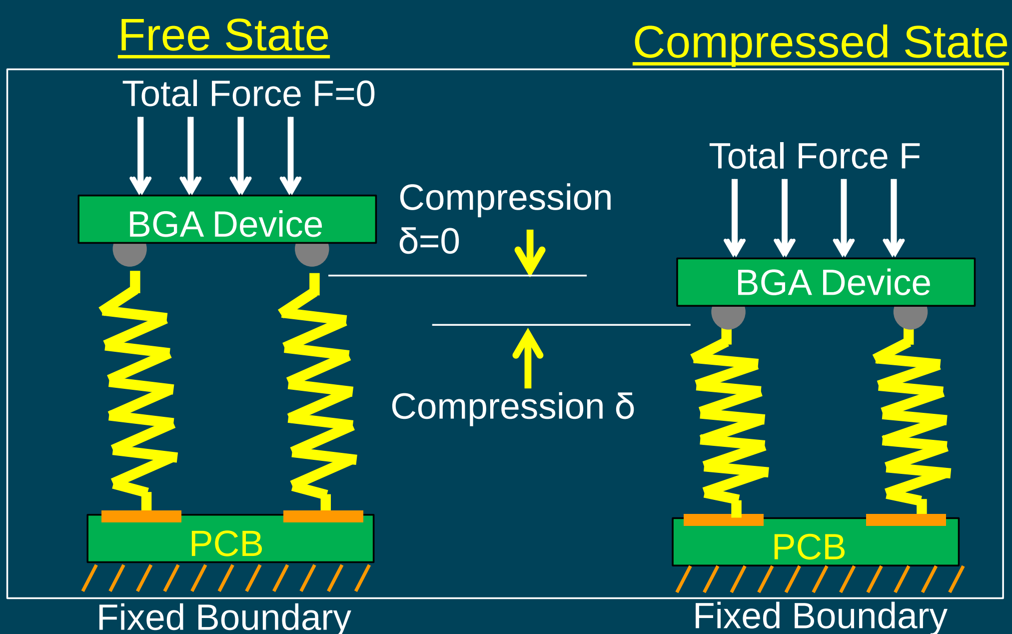
Material	Resistivity(Ω-m) at 20°C	Bulk Resistance (mΩ) at 20°C
Copper	1.68×10^{-8}	2.05
Silver	1.59×10^{-8}	1.94
Gold	2.44×10^{-8}	2.98
Tungsten	5.6×10^{-8}	6.84
Stainless Steel	69×10^{-8}	84.34

Assumption:

Length of interconnect: 6mm
Diameter of interconnect: 0.25mm

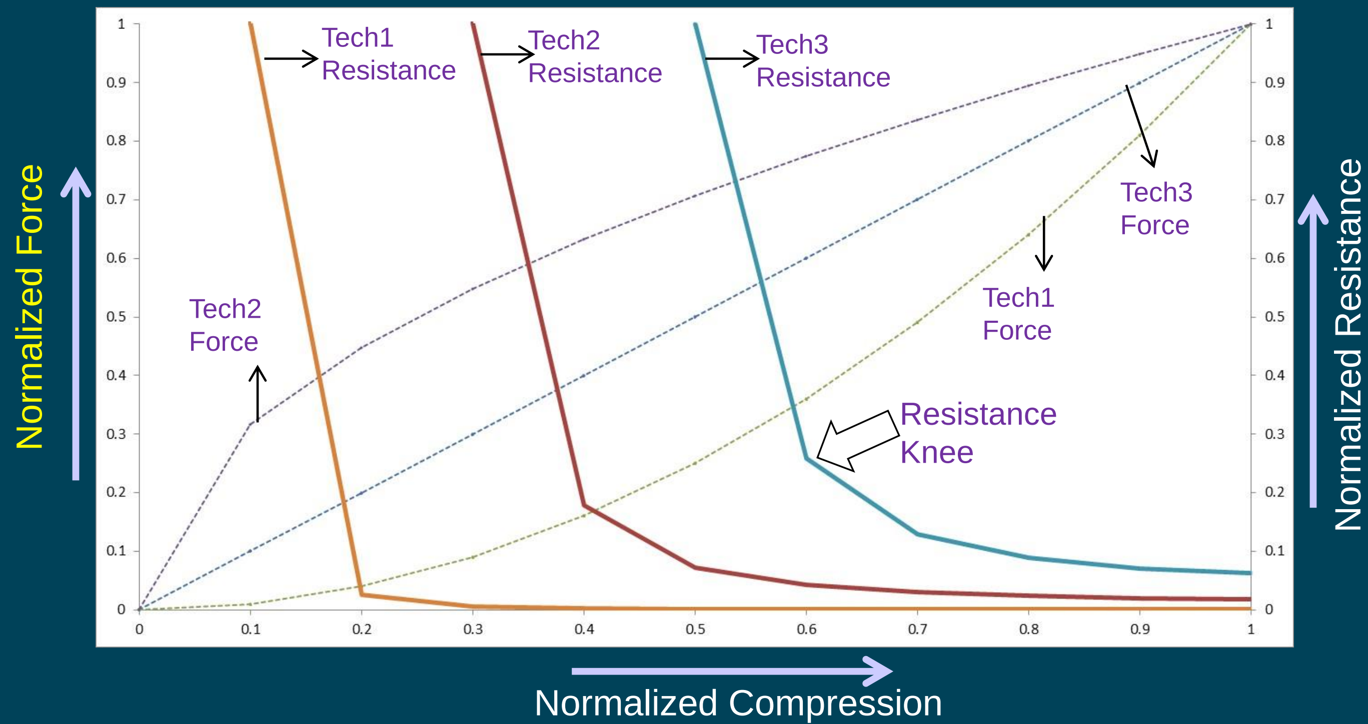
Contact Resistance: Relationship with Force

- ❑ Linear or non-linear behavior of Force/Load and Compression relationship
  - Analyzed using Finite Element Analysis and experimentally validated
- ❑ Total Resistance and Force/Load relationship is experimentally measured



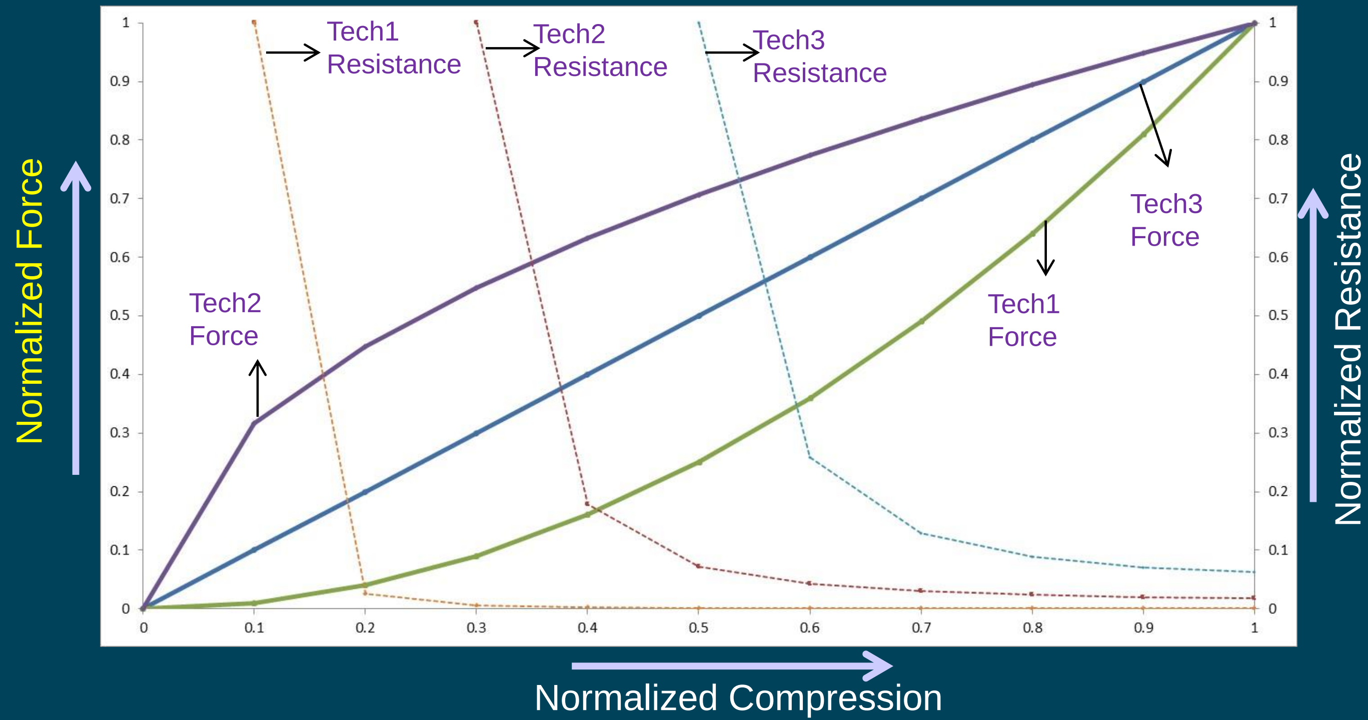
Contact Resistance: Relationship with Force (Cont'd.)

- Higher Force/Load typically yield in lower Total Resistance
  - Breaking through oxide layers' at solder-ball and/or PCB interfaces



Contact Resistance: Relationship with Force (Cont'd.)

- Normal Force and Compression can be non-linear relationship

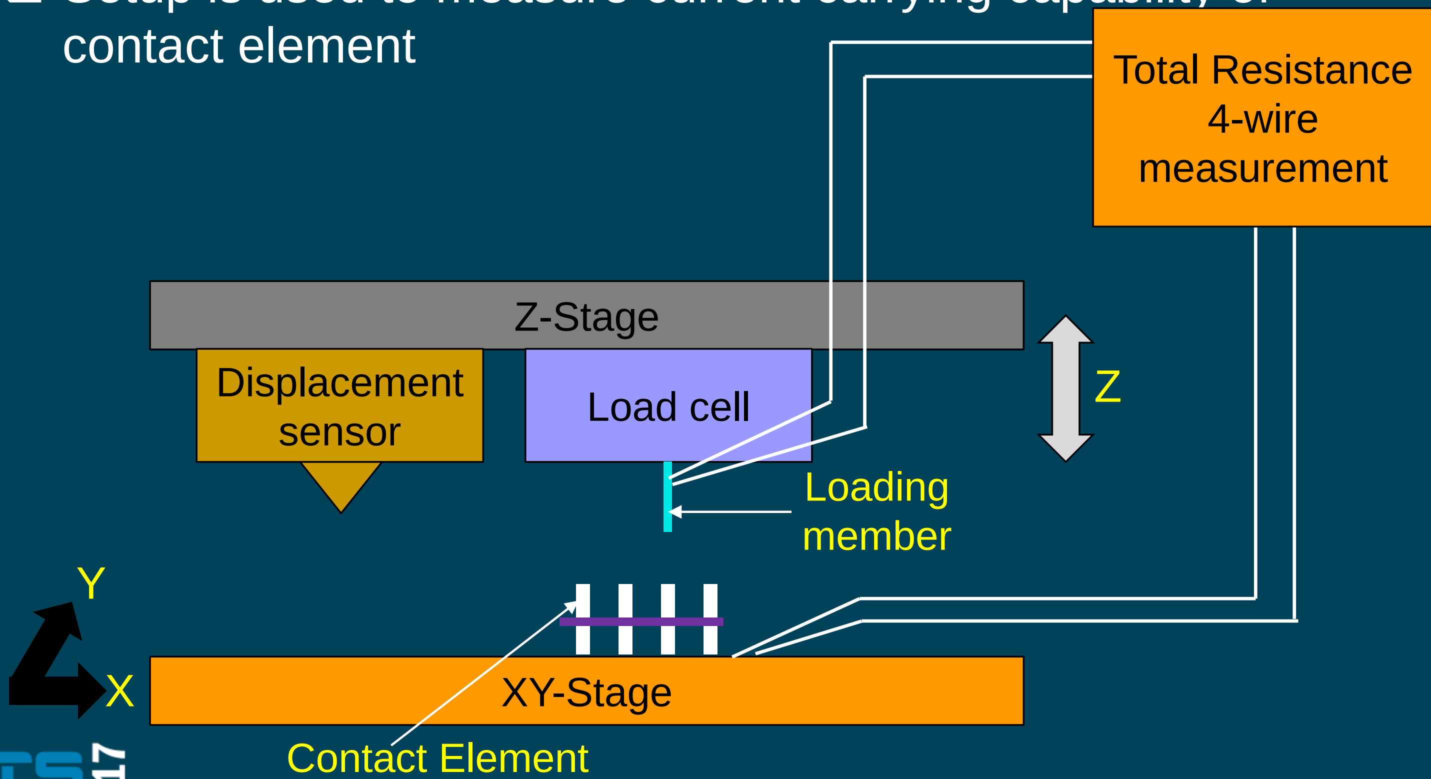


Contact Element Characterization

- ❑ Important to characterize contact element performance prior to building an array/socket
  - Typically performed by building a small coupon with 1-4 contact elements
- ❑ Mechanical characterization includes
  - Force Vs Compression at room & at high temperature (>100ºC)
  - Maximum force/compression to yield/set
  - Number of cycles to failure (material yielding, tip plating wear, etc)
- ❑ Electrical characteristics include
  - Total resistance of contact element at room and at high temperature (>100ºC)
  - Current carrying capability at room and at high temperature (>100ºC)

Contact Element Characterization: Experimental Setup

- ❑ Total resistance is measured using 4-wire setup
  - Removing path resistance
- ❑ Setup is used to measure current carrying capability of contact element



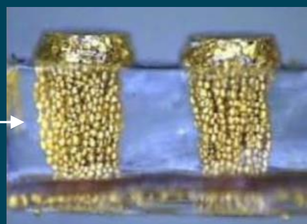
Section 3
Types of Contacts

Polymer-based Contacts

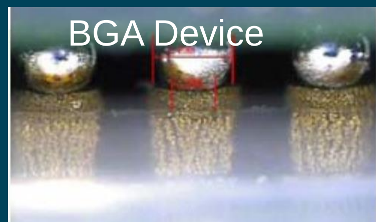
Two types of Contacts:
1. Polymer filled with metal powder
2. Polymer with embedded metal spring element

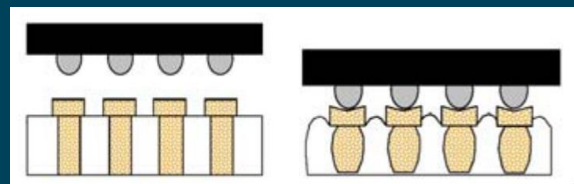
1. Polymer filled with conductive metal powder

Metal powder (Ag or Au) →
Polymer →



Courtesy: ISC





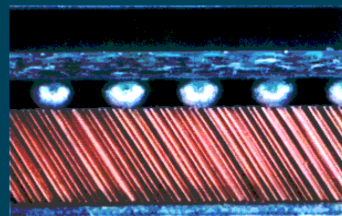
Primary Advantages:
- No ball damage
- Easily replaced as needed
- Custom and mixed pitch
- Excellent electrical characteristics
- Can be scaled down to <0.4mm

Polymer-based Contacts (Cont'd.)

1. Polymer filled with Conductive metal powder

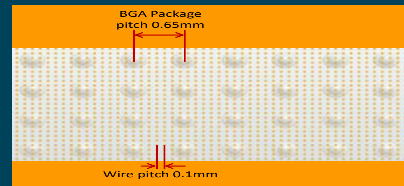
Shin-poly technology

- A Matrix of vertical wires suspended in a non conductive polymer.
- Suspended in 2 configurations, GB (vertical wires) and MT (angled wires).
- Both with wire pitches as small as .03 mm. (approx. 1mil)

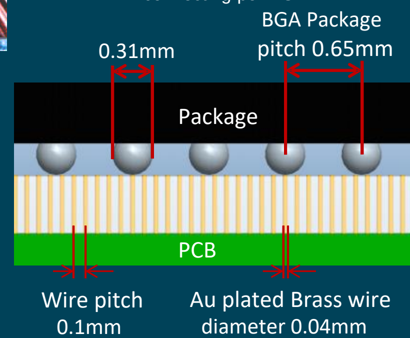


MT Matrix

Courtesy: Shin-Etsu Polymer



compression of polymer showing number of wires connecting per BGA



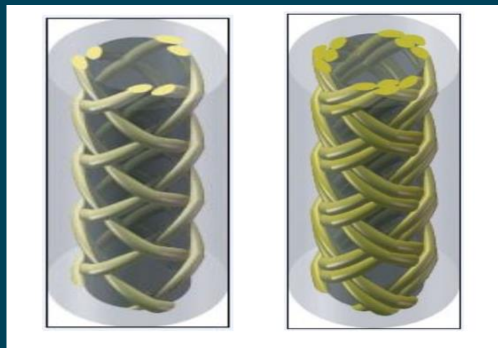
Schematic of stack-up

Primary Advantages:

- Extremely Low Height
- Custom and mixed pitch
- Excellent electrical characteristics
- Can be scaled down to <0.4mm

Polymer-based Contacts (Cont'd.)

2. Polymer with metal spring element:



Courtesy: HCD

6-wire spring 12-wire spring

Continuous wire spring structure supported by elastomer

Primary Advantages:

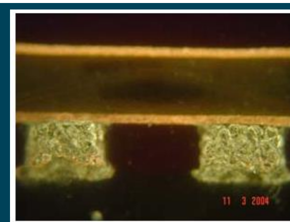
- Drop in replacement for pogo pins
- Consistent resistance value
- Custom and mixed pitch
- Can be scaled down to 0.4
- Higher cycle life than metal-filled polymers

Particle Interconnect

- Particle Interconnect uses sharp, metallized, particles which have been screened by size.
- They are attached onto contact pads on the surface of conductor using standard masking and electroplating processes.
- The sharp, embedded particles create a "micro bed-of-nails" of "conductive sandpaper" that makes many parallel electrical paths by penetrating through any oxide without requiring a wiping action as conventional contacts.

Courtesy: PITek.US

Close-up of Particle Interconnect pads shows controlled stacking of particles to a desired height with clearance between individual particles.

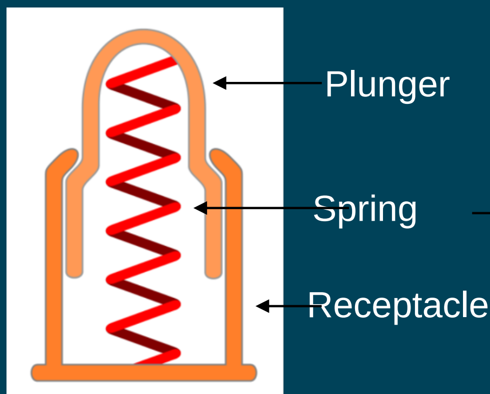


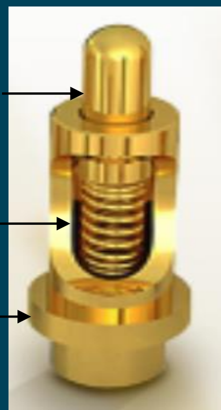
Courtesy: PITek.US

<u>Primary Advantages:</u>
- Extremely Low Height
- Custom and mixed pitch
- Excellent electrical characteristics
- Can be scaled down to <0.4mm

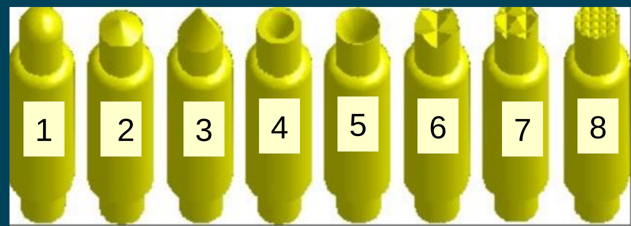
Spring-loaded Pins

- Spring-loaded contact (typically known as pogo-pin) is a device used to establish electrical interconnection between two surfaces. These surfaces could be pads of the printed-circuit boards or solder balls of BGA devices





Typical Plunger Shape Types



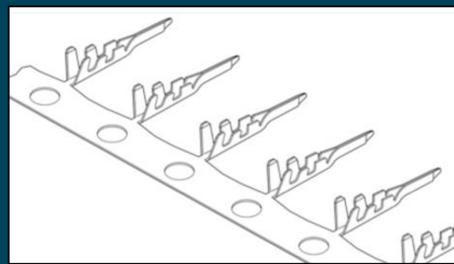
<u>Primary Advantages:</u>

- High cycle life
- Consistent resistance value and reliable interconnection
- Can be scaled down to 0.4 and less
- Can withstand higher temperatures

Stamped-and-Formed Contacts

Typical Process:

- ❑ Made from reels of flat stock material
- ❑ Strips run through stamping and forming die to form socket contacts
- ❑ Contacts are electro-plated and inserted into the housing



Example of stamped and formed contacts on a carrier strip

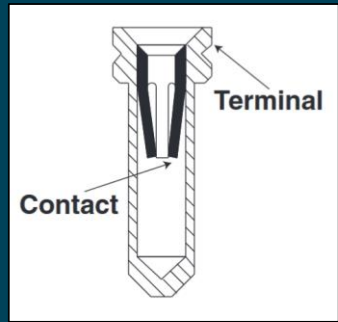
cLGA®
Dual-compression contact
Courtesy: Amphenol InterCon Systems

Primary Advantages:

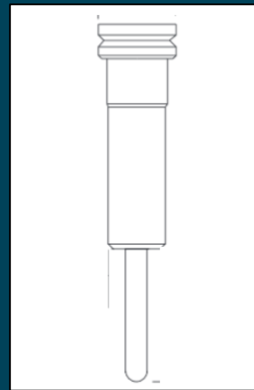
- Low-cost
- High-volume application
- Applications include production sockets, crimped contacts, etc.

Pin and Socket Contacts

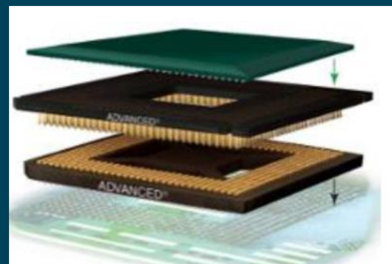
- Pin and socket type of contacts are typically made on a screw machine
- They are comprised of two parts – Female receptacle and Male header
- Standard contacts can be inserted into a variety of housings to create IO connectors, sockets and board-to-board connectors.



Female Receptacle



Male Header



Courtesy: Advanced Interconnection

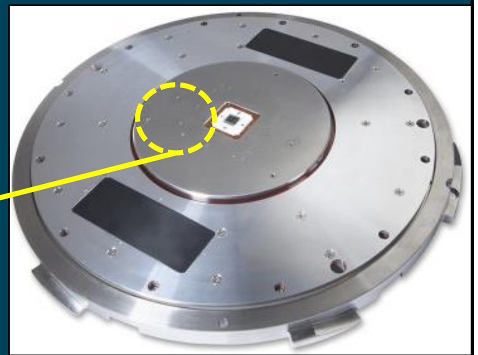
<u>Primary Advantages:</u>

- Consistent and reliable contact resistance
- Low tooling cost
- Medium cycle life (insertion/removal)
- Application includes validation socket and board to board interconnect

MEMs-based Vertical Interconnect

- ❑ Made from 2D MEMs process
- ❑ Contacts are plated
- ❑ One end is soldered down
- ❑ Tips puncture into silicon (Cu) bump

Probe Card



Example of vertical interconnect assembled to probe card

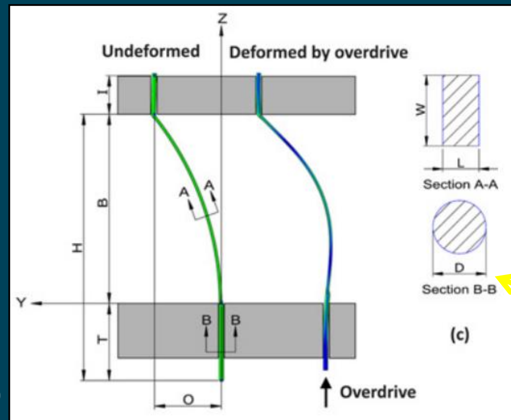
Primary Advantages:

- Low force <10gf
- Ultra-fine pitch <150um
- High cycle life
- Application include silicon testing

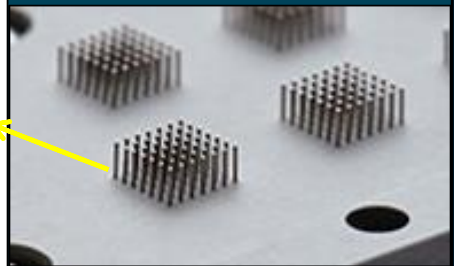
Courtesy: FormFactor Inc

Buckling-based Interconnect

- ❑ Manufactured from Flat/round wire spool or 2D MEMs
- ❑ Floating pin or one end is soldered
- ❑ Contacts are plated
- ❑ Tips puncture into silicon (Cu) bump



Probe Card



Example of Buckling based interconnect assembled to probe card

<u>Primary Advantages:</u>

- Low force <10gf
- Ultra-fine pitch <200um
- High cycle life
- Application include silicon testing

Courtesy: Buckling Beam Solutions

Summary

Type of Contact	Benefits
Polymer-based contacts (filled with metal powder) individual contacts	-Electrical characteristics -Can be scaled down to <0.4mm
Polymer-based conductive sheet	-Electrical Characteristics, Can be scaled down to <0.4mm, Alignment of sheet to the pads
Polymer based contacts with metal spring element	-Higher cycle life than metal-filled polymer, Consistence resistance value
Particle Interconnect	-Electrical Characteristics, Can be scaled down to <0.4mm,Custom and mixed pitch
Spring-loaded Contacts	-High cycle life, scaled down to <0.4mm, consistence resistance
Stamped and formed contacts	-Low cost, High-volume application, consistence resistance
Pin and Socket Contact	-Consistence resistance, low tooling cost
MEMs-based Vertical Interconnect	-High cycle life, low force, ultra fine pitch <0.15mm
Buckling-based Interconnect	-High cycle life, low force, ultra fine pitch <0.20mm

Section 4
Contact Element Material

Contact Material Selection Factors

- ❑ Material Availability
- ❑ Specific Performance
- ❑ Manufacturability
- ❑ Cost Effectiveness

Socket Contact Selection

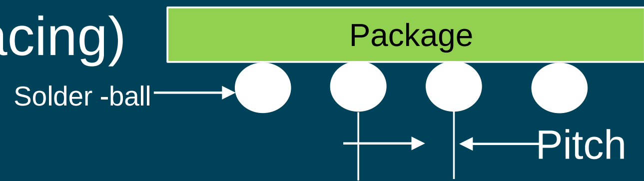
High-level Selection Flow

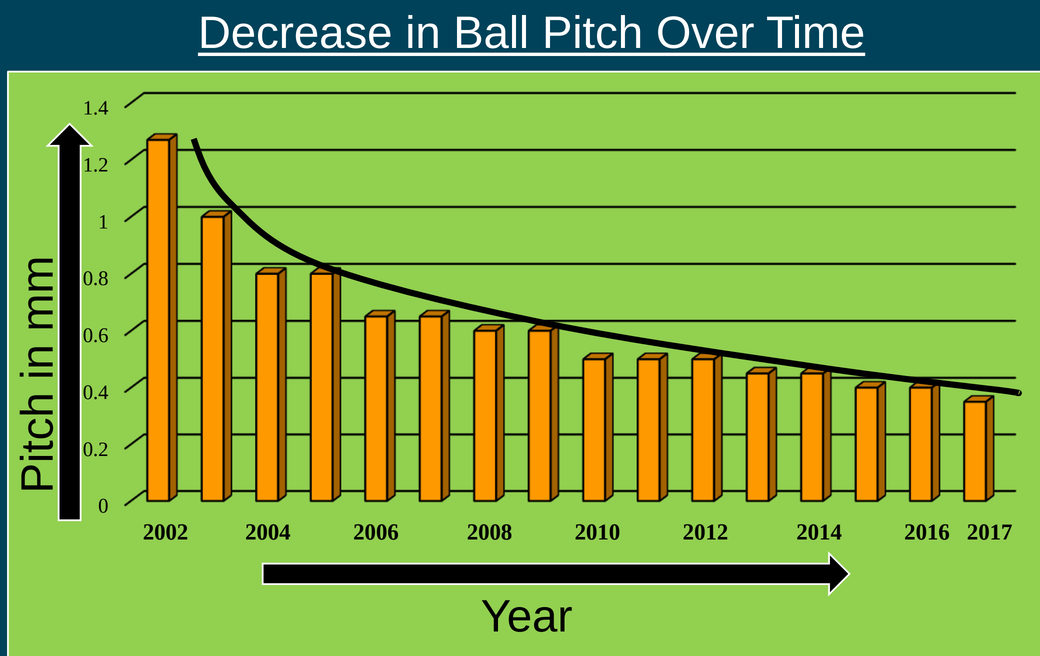
1. Understand Industry Trends
2. Define socket contact requirements
3. Select contact material

1. Understand Industry Trends

❑Contact size

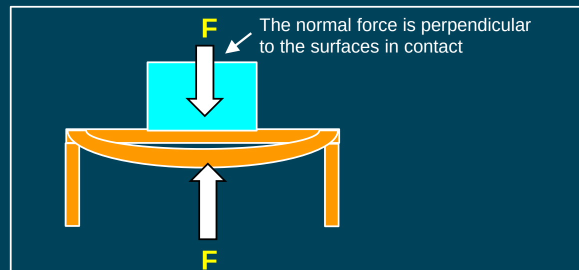
- Pitch (Center to center spacing)
- Tighter tolerances





1. Understand Industry Trends (Cont'd.)

- ❑ Lower normal force
    - Minimize deflection of the socket substrate, mechanical hardware and PCB
    - Meet reliability requirements



- ❑ Growing number of pins/socket
    - Exceeding 100 contacts/inch and exceeding 2,000 contacts/socket

1. Understand Industry Trends (Cont'd.)

- ❑ Single or Dual-compression mount
  - Reliable solder joint (for single compression mount)
  - Provide repeated insertion removal cycles without taking a set
- ❑ Higher operating temperatures
  - Infotainment systems > 130ºC
- ❑ Shorter development and Manufacturing lead time
  - Faster to design and faster to manufacture
- ❑ Price
  - Lower product cost

2. Define Socket Contact Requirements

2a. Mechanical

2b. Electrical

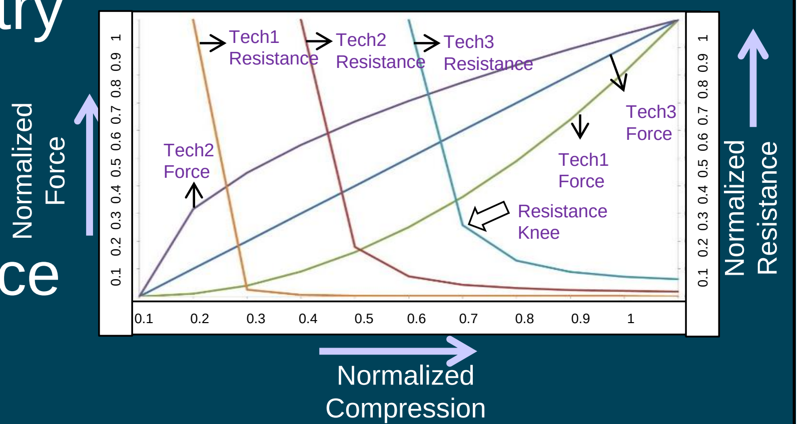
2c. Material

2d. Attachment Process

2e. Environment

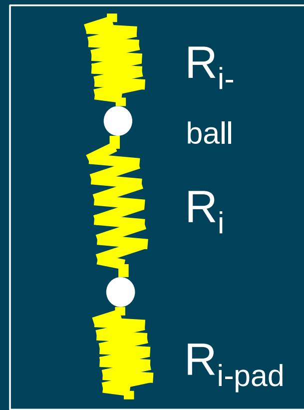
2a. Mechanical Requirements

- ❑ Mating surface material and contact area
  - PCB mating surface , Device (BGA) mating surface
- ❑ Contact material geometry
  - Contact area
  - Contact normal force
  - Insertion/extraction force



2b. Electrical Requirements

- ❑ Total socket resistance
  - Contact resistance
  - Bulk resistance



- ❑ Current carrying capacity
  - Higher conductivity materials allow greater current flow with less temperature rise
  - Current carrying capacity depends on contact geometry, contact material and normal force

2b. Electrical Requirements (Cont'd.)

❑ Signal Properties

- Signal to ground ratio -- ratio determines connector noise
- Capacitance – energy stored in an electrical field between two charged objects – coupling between two conductors
- Impedance -- The ratio of voltage to current of an electrical signal propagating through a circuit component.

2b. Electrical Requirements (Cont'd.)

❑ Signal Properties

- Inductance -- Energy stored in a magnetic field generated by the current looping through an electrical circuit.
- Propagation delay -- The signal delay caused by the connector capacitance. Reduced connector length reduces the propagation delay.
- Cross-talk -- Signals from one line leaking into another conductor because of capacitance or inductive coupling or both.

2c. Material Requirement

- Primary required properties
  - Low contact and bulk electrical resistance
  - Corrosion resistance
  - Low frictional forces – reduces wear and increases cycle life
  - Good spring properties
  - Lower cost
- Typical base contact material
  - Metal – Copper alloys
  - Elastomer – Silicon rubber

2c. Material Requirement (Cont'd.)

- Base Material requirement:
  - Yield strength. Determines beam deflection allowed within elastic range
  - Conductivity – minimized bulk resistance
  - Hardness – reduces wear and increases cycle life
- Contact interface plating materials:
  - Gold (Au)
    - Hard gold or soft gold over Nickel under-plating. Hardness is per knoop hardness – electrolytic gold -- 30 to 40 micro-inches
    - ENIG – Immersion gold over Nickel– 3 to 10 micro-inches of gold

2c. Material Requirement (Cont'd.)

❑ Contact Interface Plating Materials:

- Palladium (Pd) and alloys
  - ➢ Usually over-plated with thin soft gold (approx. 10 micro-inches)
  - ➢ Pd and its alloys have higher hardness and durability than gold (Au)
- Tin (Sn) and its alloys
  - ➢ Thickness ranges depending on the process
    - ❑ Hot dipping
    - ❑ Electro plating

2c. Material Requirement (Cont'd.)

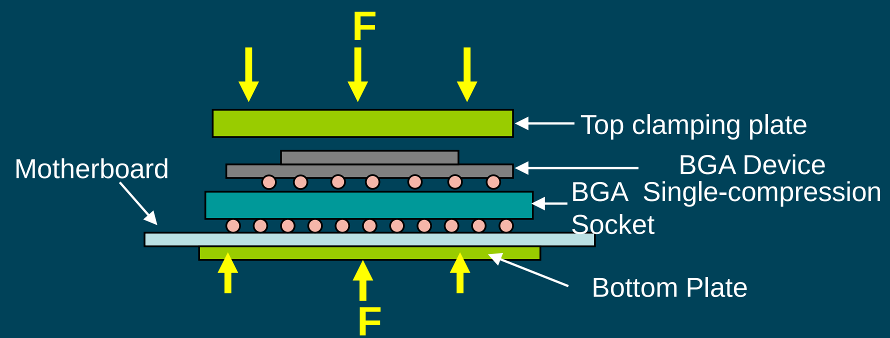
- Contact interface plating materials:
  - Silver Ag
    - Typically used on the elastomeric contacts – silicon rubber as base material
  - Nickel (Ni)
    - Common material for under-plating
    - Typical thickness 150 to 200 micro-inches
- Types of plating processes:
  - Electrolytic plating
  - Electroless plating
  - Hot Dipping

2c. Material Requirement (Cont'd.)

- Housing Material:
  - Typically thermoplastics (polymer-based) is used to support contacts
    - Provide environmental protection
  - Critical property requirement of housing include:
    - Withstand soldering temperatures with low acceptable warpage (Pb-free process)
    - Dimensional stability
    - Moisture resistance

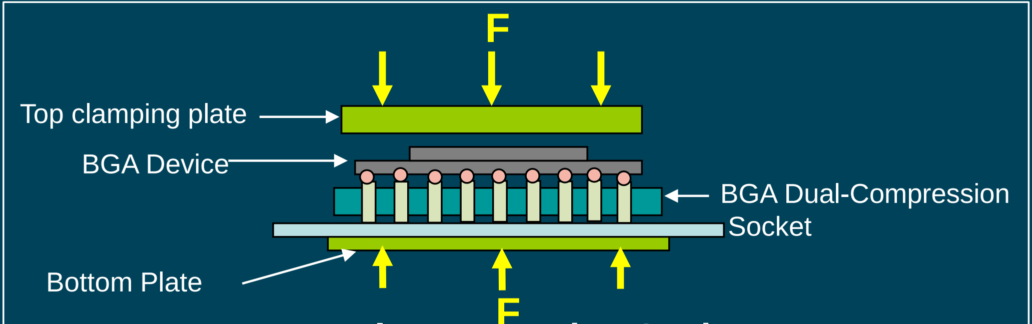
2d. Contact Attachment Process

1. Soldering to PCB, mechanically attaching to device



Soldered-down Socket

2. Mechanically attaching to PCB and Device



Dual-compression Socket

2d. Contact Attachment Process (Cont'd.)

1. Soldering to PCB, mechanically attaching to device

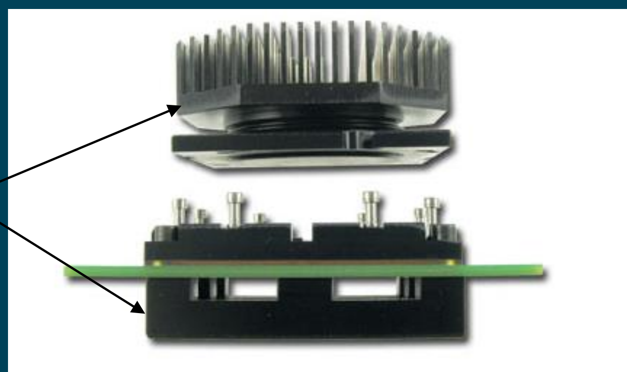
- Solder process
  - Convection reflow
  - Vapor-phase reflow
  - Manual soldering
  - Wave soldering

- Mechanical attaching to device
  - Requires custom hardware to make connectivity through compression

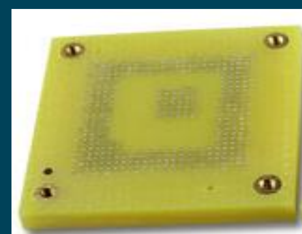
2d. Contact Attachment Process (Cont'd.)

2. Mechanical Attachment to PCB

- Solderless contacts. Compression mount on both PCB and device end
- Require custom hardware to make connectivity to PCB and device through compression
- Require higher force to make electrical connection than soldering one end and mechanically attaching other



Courtesy: Ironwood Electronics


Dual Compression, solderless socket

2e. Contact Environmental Requirements

- Common applications include:
  - Consumer
  - Automotive
  - Aircraft
  - Military
  - Computer
  - Telecommunication

2e. Contact Environmental Requirements (Cont'd.)

	Typical operating temperature conditions – Can vary depending on application		**Typical life – Can vary depending on application**
Category	**Minimum ºC**	**Maximum ºC**	**Approx. Years**
Consumer	0	+100	~ 3
Computer	0	+100	~5
Automotive	-50	+100 to +150	~10
Aircraft	-50	+125	~20
Military	-50	+125	~10
Telecommunication	-40	+100	~15

Types of Tests:

- ❑ Temperature and humidity
- ❑ Gaseous
- ❑ Vibration
- ❑ Shock

3. Contact Material Selection

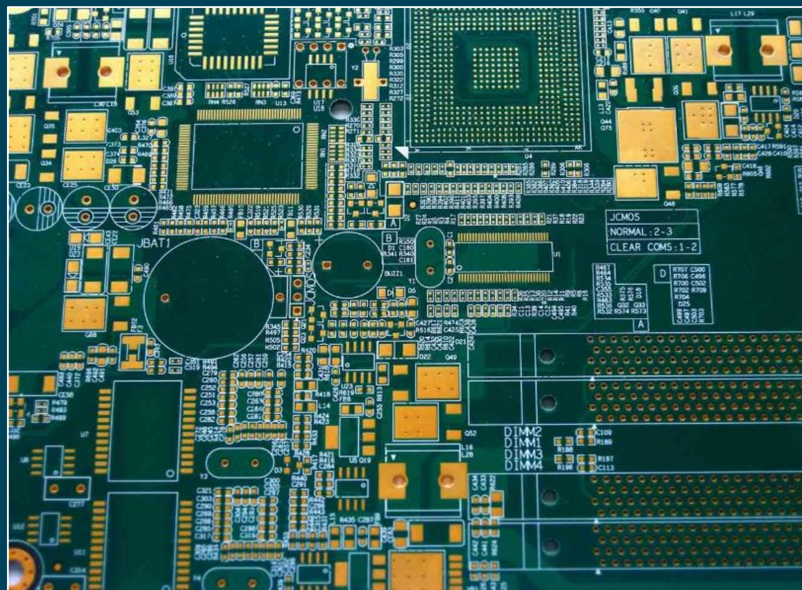
- Contact material plays a significant role in design optimization

Primary Requirements	Contact Material Property
• Cycle life/Durability	• Contact finish, Resistance to taking set
• Reliability	• Contact finish, Stress relaxation
• SI and Current carrying capacity	• Electrical and thermal conductivity
• Deflection under load	• Modulus of elasticity, yield strength
• Normal force	• Modulus of elasticity, mechanical tolerances

Section 5
Printed Circuit Board (PCB) & Hardware Requirement

PCB Surface Finishes

- Overview:
  - PCB surface finish plays an important role in achieving reliable interconnection between the component or device and bare PCB

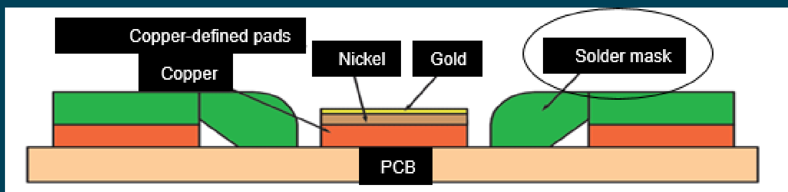


PCB Surface Finishes (Cont'd.)

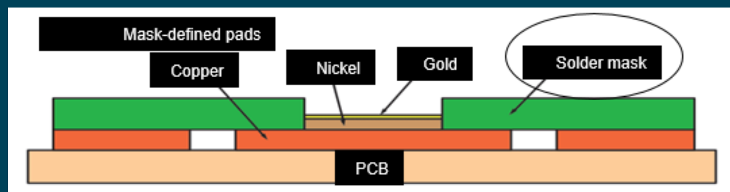
- The primary purpose of the surface finish are:
  - Connectivity between the PCB and component devices
  - Protect the copper area from oxidation prior to assembly (soldering or using interconnect sockets)
  - Promote reliable interconnection for long-term performance

PCB Surface Finishes (Cont'd.)

- Two types of PCB pads:
  1. Copper defined: Solder-mask opening larger than the metal pad
  2. Solder-mask defined: Metal pad larger than the solder-mask opening



Copper-defined Pads



Mask-defined Pads

Primary Factors in Selecting PCB Finish

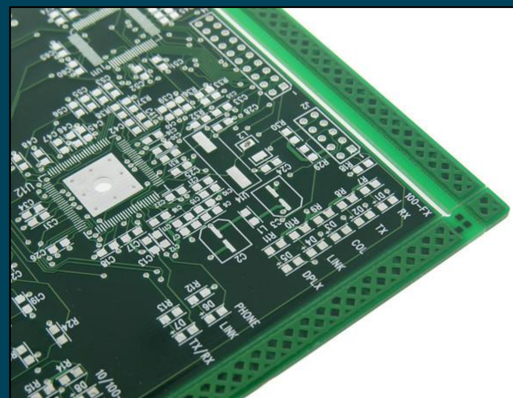
- Cost
- RoHS compliant
- Assembly methods
- Durability
- Environment
- Shelf life
- Testability
- Reliability

Types of Surface Finishes

- Standard Hot Air Solder Level (HASL) & Lead-Free HASL
- Organic Solderability Preservative (OSP)
- Immersion Silver
- Immersion Tin
- Gold:
  - Gold – ENIG -Electroless Nickel Immersion Gold
  - Hard Gold
- Electroless Nickel Electroless Palladium Immersion Gold (ENEPIG)

Standard HASL and Lead-Free HASL

- **Typical Finish:**
  - Standard HASL: Typically Tin-Lead (Sn-Pb)
    - Melts at 183ºC
    - Shelf life: >12 months – very good
  - Lead-free HASL: Typically Tin-Copper (Sn-Ag-Cu), Tin-Copper-Nickel (Sn-Cu-Ni)
    - Melts at 217ºC to 228ºC
    - Shelf life: approx. 12 months



- **Typical Thickness:**
  - 70-200 micro-inches
  - IPC specifies complete coverage of SMT pads

Standard HASL and Lead-Free HASL (Cont'd.)

❑ Advantages:

- Low cost
- Readily and widely available
- Easy to rework – Low cost

❑ Disadvantages:

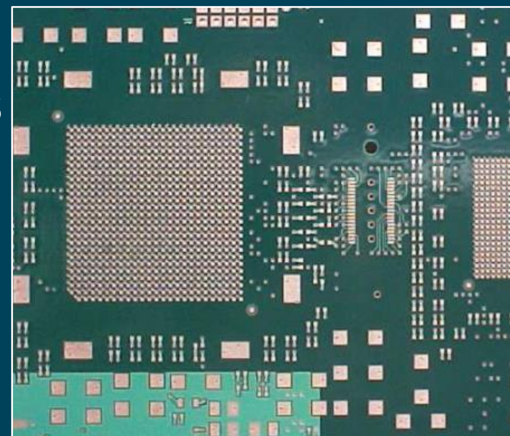
- Uneven surface
- Not good for direct socket interconnection
- Not good for thermal shock
- Potential of solder bridging is high

❑ High-level Typical Process:

❑ Clean → Microetch → Apply Flux → Solder Dip → Knife leveling → Rinsing

Organic Solderability Preservatives (OSP)

- Typical Finish
  - Organic Solderability Preservatives
  - Applied directly on Copper



- Typical Thickness:
  - Thin coating : 4-20 micro-inches
  - Finish typically is not specified on the fab drawing

Organic Solderability Preservatives (OSP) (Cont'd.)

❑ Advantages:

- Lead-free
- Flat and planar surface
- Simple process and easy to manufacture
- Easy to rework – Low cost

❑ Disadvantages:

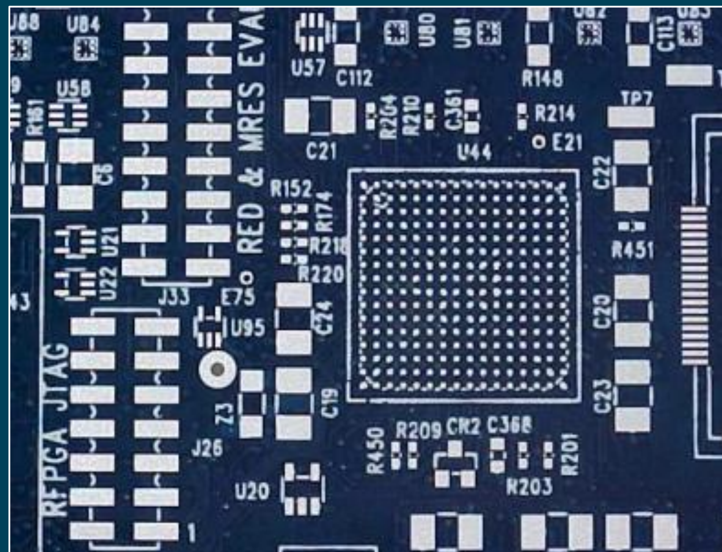
- Short shelf life, less than 6 months
- Exposed Copper during final assembly
- Bare exposed Copper can cause socket interconnect reliability issues

❑ High-level Typical Process:

- Clean → Microetch → Flood OSP → Rinse

Immersion Tin

- ❑ Typical Thickness:
  - 20-50 micro-inches
- ❑ Advantages:
  - Flat Surface
  - Lead-free
  - Easy to rework
  - 6 month shelf life



Immersion Tin (Cont'd.)

❑ Disadvantages:

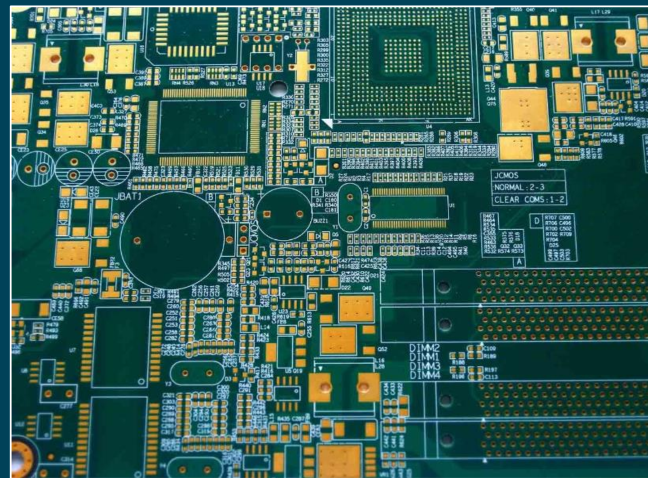
- High potential for damage during handling
- Exposed tin can corrode – cause interconnect socket issues during direct socket connection
- Tin whiskers

❑ High-level Typical Process:

- Clean → Microetch → Predip → Apply Tin → Post dip →Rinse

Gold – ENIG

- Typical Thickness:
  - Nickel: 100-200 micro-inches
  - Gold: 3-10 micro-inches



- Advantages:
  - Flat Surface
  - Lead-free
  - Approx. 12 month shelf life
  - Good for direct socket interconnection

Gold – ENIG (Cont'd.)

❑ Disadvantages:

- Medium high cost
- Not reworkable
- Complicated process

❑ High-level Typical Process

- Clean → Microetch → Catalyst → Electroless Nickel →Rinse →Immersion Gold → Rinse

Gold – Hard Gold

- Typical Thickness:
  - Nickel: 125-150 micro-inches
  - Gold: 25-30 micro-inches

- Advantages:
  - Durable surface
  - Lead-free
  - Excellent for direct socket interconnection
  - Long shelf life

Gold – Hard Gold (Cont'd.)

- Disadvantages:
  - Very high cost
  - Extra processing → labor intensive
  - Plating / Bus bars

- High-level Typical Process:

  Apply Resist → Clean → Microetch → Electroless Nickel → Rinse → Electrolytic Gold → Rinse → Strip Resist → Clean

Immersion Silver

❑ Typical Thickness:

- 8-15 micro-inches of pure Silver

❑ Advantages:

- Excellent Solderability
- Good for direct socket interconnect
- 6-12months shelf life

❑ Disadvantages:

- Sensitive to handling
- Medium High cost

❑ High-level Typical Process:

- Clean → Microetch → Electroless Nickel →Rinse → Immersion Silver → Rinse

Electroless Ni / Electroless Pd/ Immersion Au (ENEPIG)

- Finish/Thickness:
  - Nickel: 120-240 micro-inches
  - Palladium: 4-20 micro-inches
  - Immersion Gold : 3-10 micro-inches
- Advantages:
  - Forms better solder joints with SAC Alloys (Pb free)
  - Palladium eliminates potential corrosion
  - 12months shelf life
  - Good for direct socket interconnection

Electroless Ni / Electroless Pd/ Immersion Au (ENEPIG) (Cont'd.)

❑ Disadvantages:

- Does not form good joints with Sn/Pb alloys
- High cost

❑ High-level Typical Process:

- Clean → Microetch → Electroless Nickel → Electroless Palladium →Immersion Au

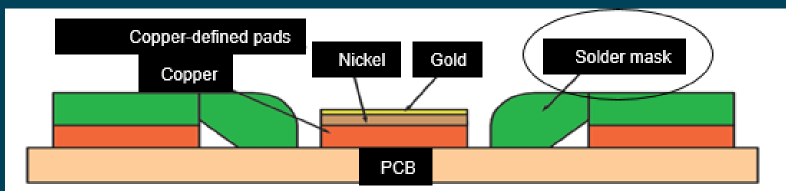
Comparison of Surface Finishes

Type	Planarity	Solderability	Dual Compression Contact	Typical Cost
HASL	Poor	Good	Poor	Low
OSP	Good	Good	Poor	Low
Immersion Tin	Good	Good	Poor	Low
Immersion Ag	Good	Good	Good	Medium
Gold - ENIG	Good	Good	Very Good	Medium
Gold-Hard Gold	Good	Good	Excellent	Very High
ENEPIG	Good	Good	Excellent	High

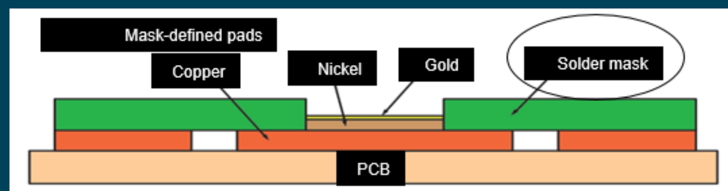
Overview of PCB Solder-mask

❑ Primary Purpose of Solder-mask:

- Prevent solder shorts under components
- Prevent socket interconnect shorts
- Prevent corrosion to underlying circuitry
- Plating resist for surface finishes



Copper-defined Pads

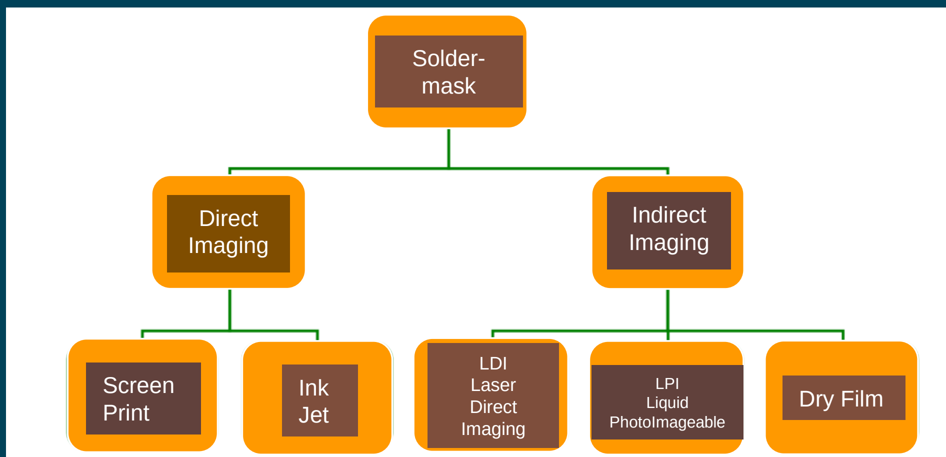


Mask-defined Pads

Solder-mask Considerations for Socket Connectivity

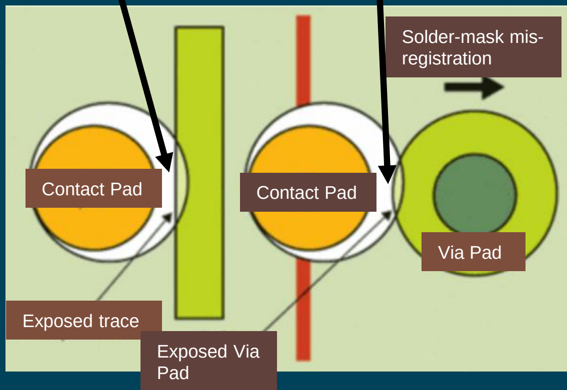
- Feature size of the solder-mask
- Registration of the solder-mask
- Tolerance on the feature size
- Thickness of the solder-mask

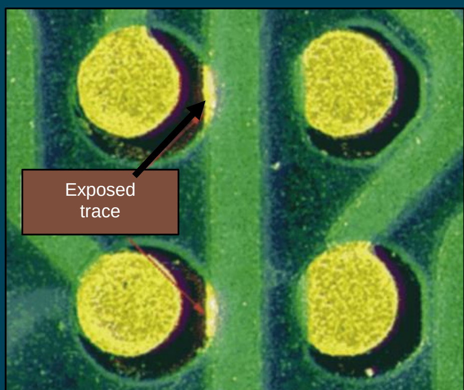
Typical Solder-mask Process



Importance of Solder-mask (SM) Registration

Potential Socket contact short in this area



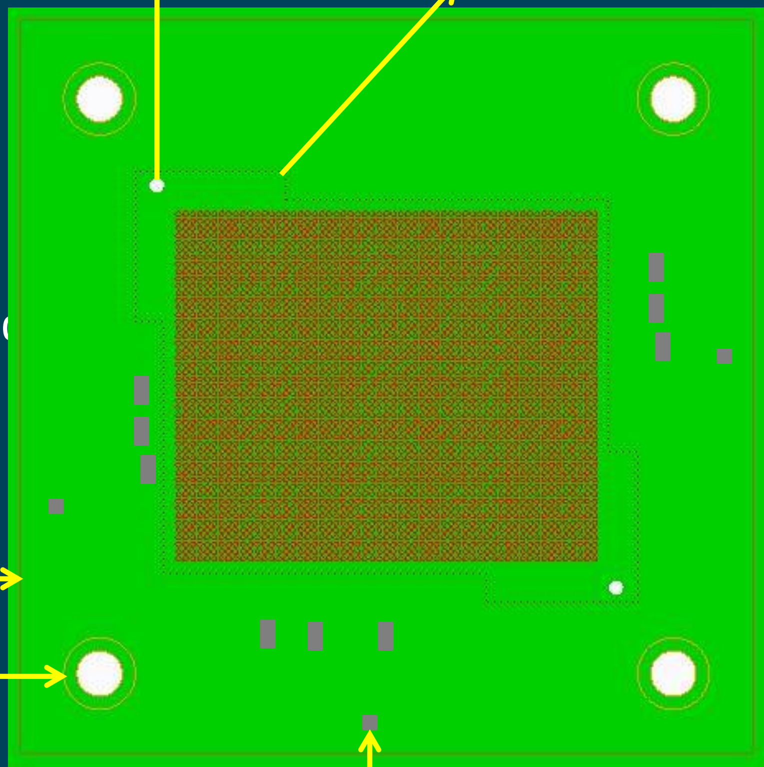


SM Tolerance Considerations
-- Size
-- Position
-- Thickness (primarily for sockets with short working range)

PCB Mechanical Keep-out for Socket

❑ Parameters to include in fab drawing

- Alignment hole location
- Socket body/frame
- Mounting hole location
- Surface mount components around
- Pad diameter
- Surface Finish



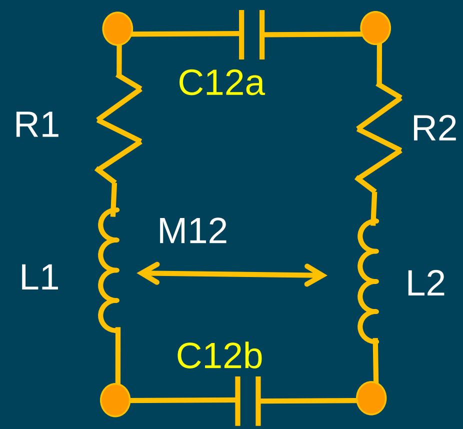
Section 6
Electrical Requirements

Impedance of the Socket

- In simple form, impedance (Zo) can be expressed in terms of inductance and capacitance
  - Zo = sqrt (L/C) (lossless impedance equation)
  - L (pin inductance) is a function of the pin geometry, socket pitch and pin length
  - C (pin capacitance) is a function of the pin geometry, socket pitch, pin length and dielectric material
- Impedance matching to system interconnect is essential in minimizing return loss for high-speed applications

Equivalent Circuit of the Socket

Example of BGA socket equivalent circuit
(2 pins are shown)



- To accurately model or calculate the impedance of one pin, the surrounding pins need to be accounted for

Notation:

C12a (BGA side): mutual capacitance between adjacent pins

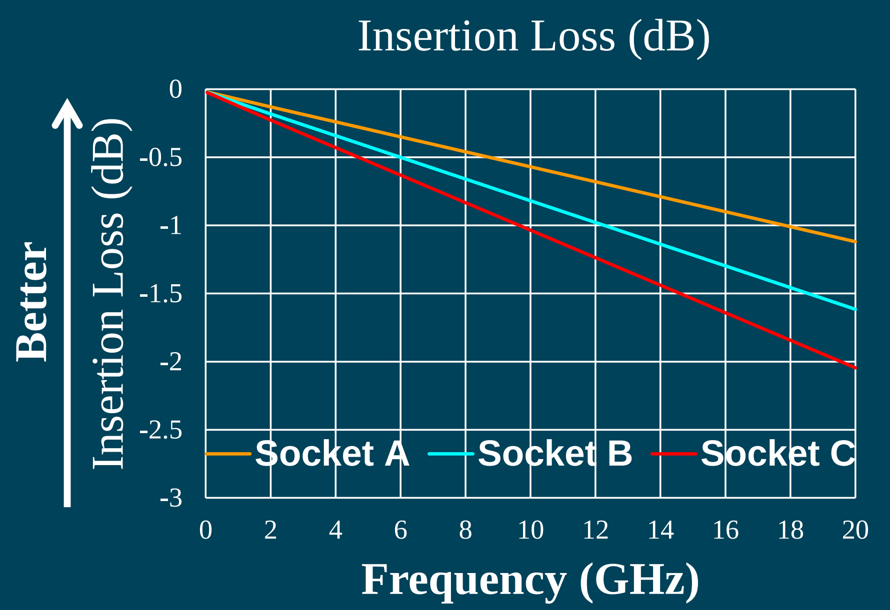
C12b (PCB side): mutual capacitance between adjacent pins

L1, L2: pin inductances

M12: mutual inductance

R1, R2: pin resistances

Socket Pin Insertion Loss

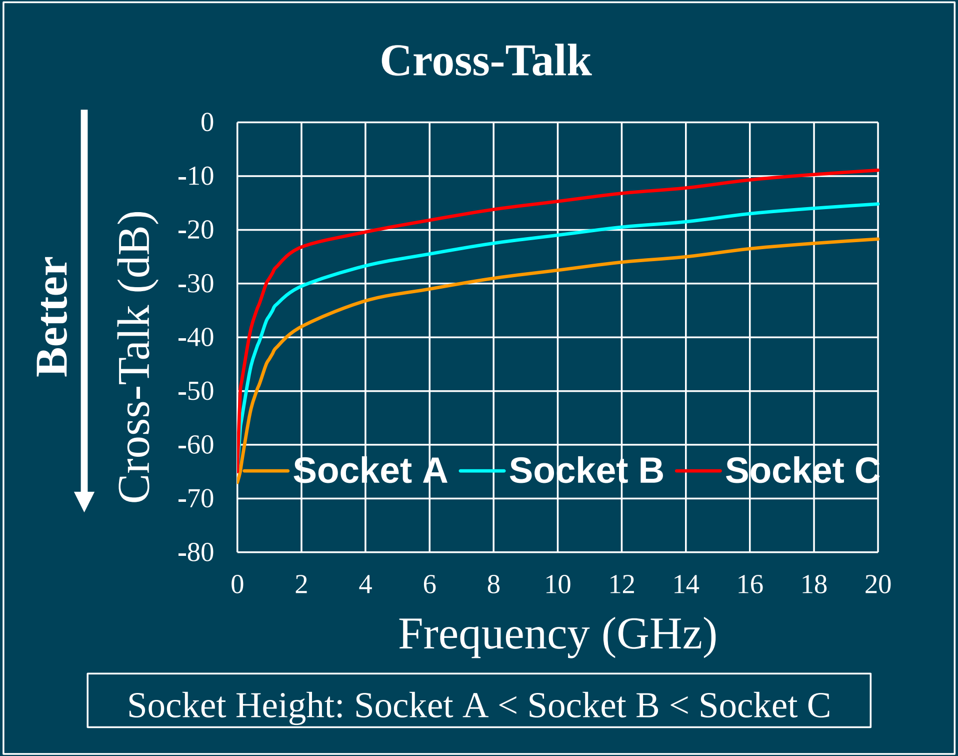


Socket Height: Socket A < Socket B < Socket C

- Insertion loss is proportional to socket pin length and contact resistance
- The longer the pin, the higher insertion loss for the same material
- The socket material also plays a role in insertion loss
- The lower loss material yields lower insertion loss

Low Insertion is preferred for signal integrity performance

Socket Pin-to-Pin Cross-Talk



- Cross-talk is proportional to the socket pin length
- The longer the pin length, the higher the cross-talk
- It is critical to have a low height socket for high-speed applications
- Socket signal pin-map also plays a critical role in reducing cross-talk
- The higher signal-to-gnd ratio, the lower the cross-talk

Minimal Cross-Talk is preferred for signal integrity performance

Current Carrying Capacity

- Current carrying capacity is a very important electrical requirement of a socket. It must meet an application requirement for reliable operations

- The ability of socket pin contact to carry current is primarily limited by the maximum allowable operating temperature and the pin contact material and contact geometry

Section 7
Interconnect Socket and System Design

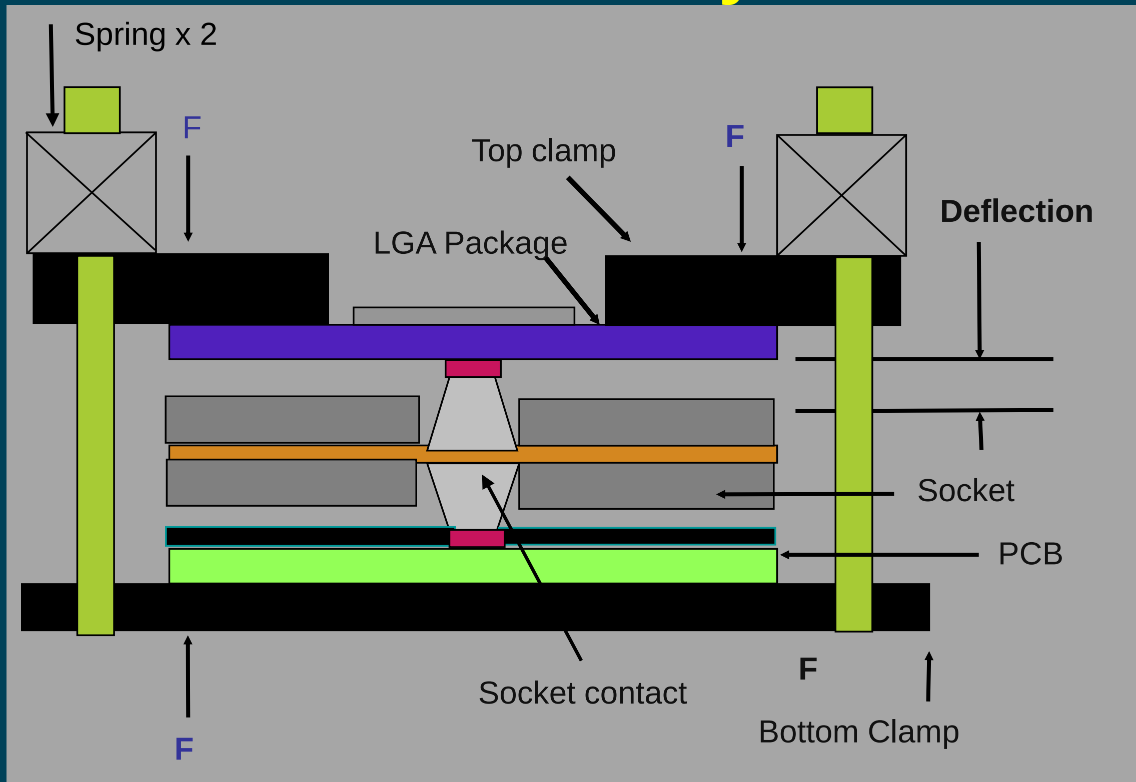
Types of Interconnect Systems

- Two Types of Interconnect Systems

1. Load-based System
   - Required compression of the contact material is achieved by applying measured load using mechanical hardware system
   - Typically used where contacts have low working range

2. Deflection-based System
   - Required compression of the contact material is achieved by using a fixed mechanical stopper
   - Typically used where contacts have high working range

Load-based System

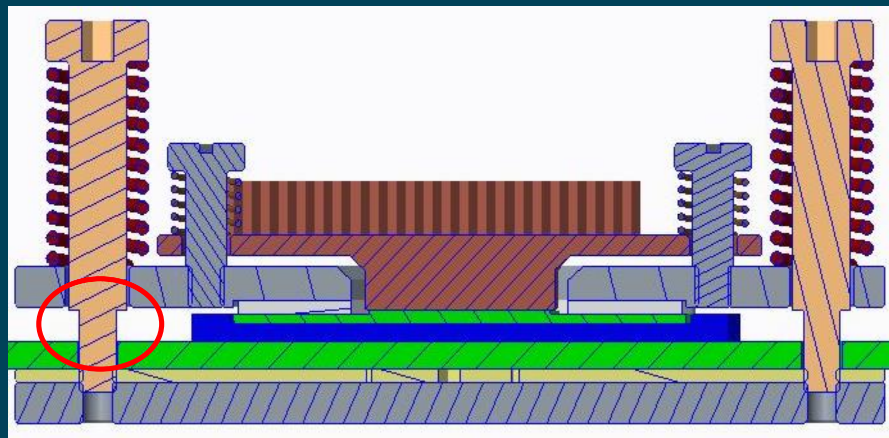


Schematic

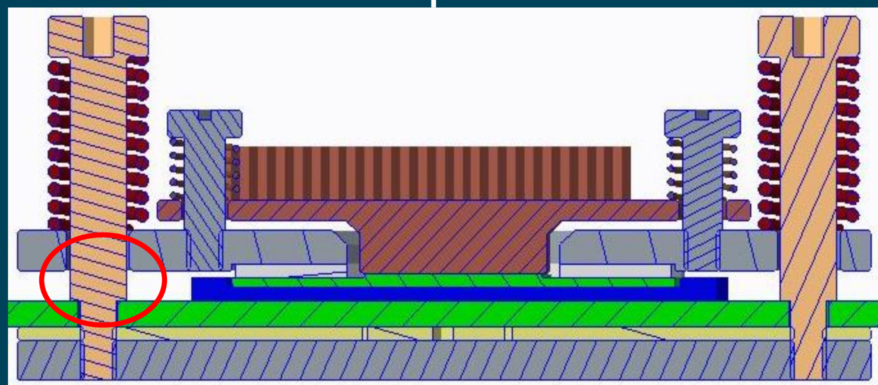
Example:
- Polymer socket contacts-- Typical working range < 0.005”

Load-based System (Cont'd.)

Uncompressed



Compressed



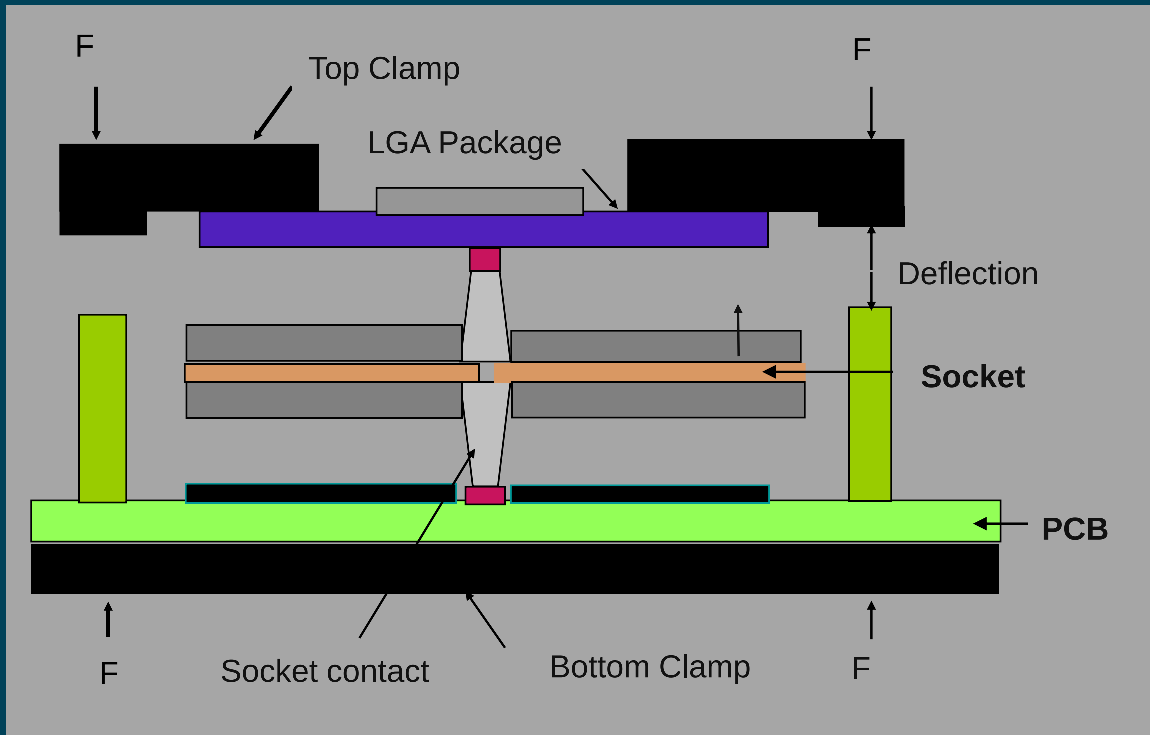
❑ Primary Advantages:

- Typically use spring screw retention system
- Spring accounts for thickness variations in retention system, socket, and package

❑ Limitations:

- High BOM cost
- Typically used for sockets with low working range <200um

Deflection-based System



Schematic

Example:
-- Pogo pins, stamped and formed contacts -- Typical working range = 0.010”-0.015”

Deflection Based System (Cont'd.)

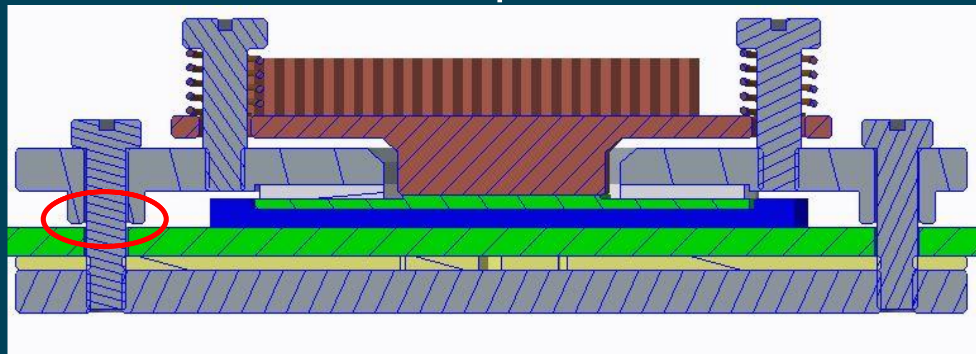
❑ Primary Advantages:

- Socket acts as compliant member accommodating thickness variation in retention parts
- Low BOM cost

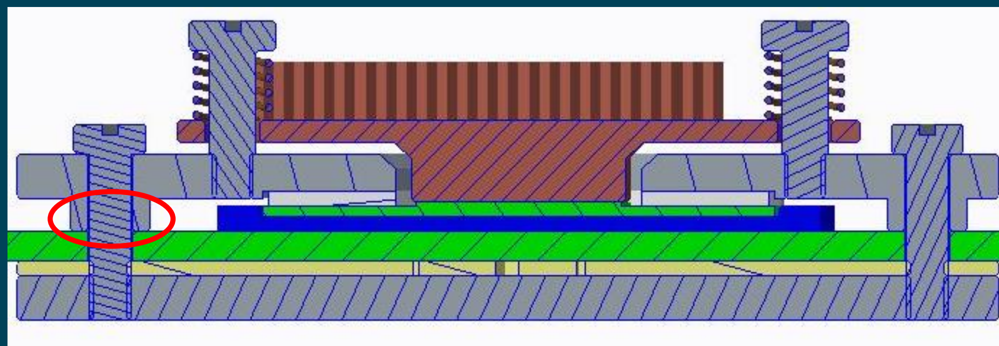
❑ Limitations:

- Typically used for sockets with high working range >250um
- Typically use a pattern for tightening retention screws
- Require tight thickness and flatness control for retention hardware

Uncompressed



Compressed



Socket Design Parameters

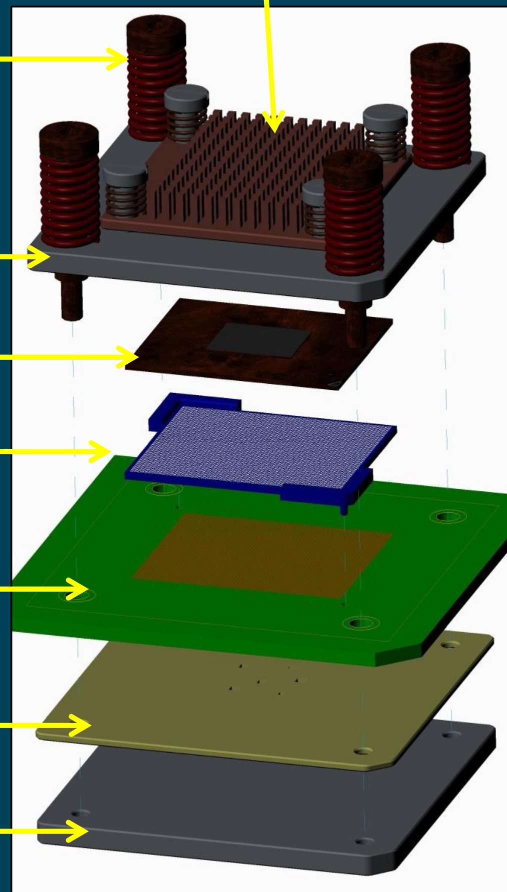
- Thermo-Mechanical
  - Compression and Force
  - Cycle life / durability
  - Operating temperature
  - BGA vs LGA
  - Pitch
  - PCB keep-out and plating
  - Hard stops preventing pin over-compression

Socket Design Parameters (Cont'd.)

- ❑Electrical
  - •Impedance
  - •Inductance
  - •CCC
  - •Contact resistance
- ❑Cost
- ❑Lead time

Mechanical Hardware Design

- ❑ Spring Screw Retention accommodate z-stack tolerances
- ❑ Split loading for bare die devices
  - Periphery loading
  - Heat sink loading
- ❑ Stiffener plate insulator openings accommodate surface mount components bottom side of PCB
- ❑ Top plate insulator openings accommodate surface mount components on DUT



Mechanical Tolerances

❑ Z-stack tolerance analysis:

- Spring based loading: Spring compressed height variation
- Displacement based loading: Interconnect compressed height variation

❑ XY tolerance analysis:

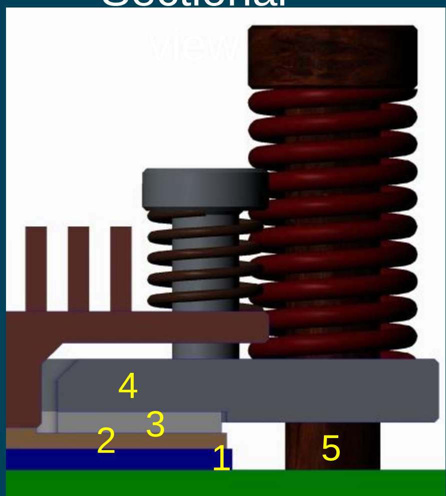
- Alignment accuracy of interconnect pin to PCB pad
- Alignment accuracy of interconnect pin to Device ball or pad
  - ➢ Monte Carlo based: David Shia, Intel Corporation; 2007 Burn-in and Test Socket Workshop
  - ➢ https://www.bitsworkshop.org/archive/archive2007/2007s6.pdf
- For HVM test, alignment accuracy and repeatability of handler

Mechanical Z-Tolerance: Example

❑ Z-stack tolerance analysis:

- Spring based loading: Spring compressed height variation

Sectional view



#	Component	Nominal Dimension (mm)	Tolerance +/- (mm)	Cpk	n-σ	1-σ
1	Compressed socket height	-1	0.025	1.33	4	0.006
2	Package Substrate thickness	-0.75	0.05	1.33	4	0.013
3	Top plate insulator	-1	0.1	1.33	4	0.025
4	Top plate thickness	-2.5	0.1	1.33	4	0.025
5	Shoulder screw height	18	0.1	1.33	4	0.025
	Compressed spring height	12.75	0.375	Worst Case		
			0.046	RSS(1σ)		
			0.137	RSS(3σ)		
			0.182	RSS(4σ)		

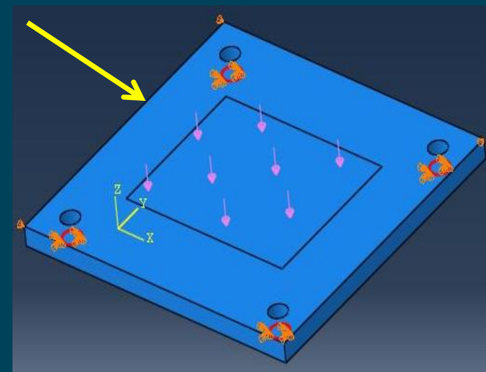
Force-Deflection Analysis

- Finite Element Analysis is used for:
  - Optimization (thickness) of mechanical hardware components (stiffener plate, top plate, etc)
  - Interconnect array deflection distribution to ensure min deflection meets CRES criterion
  - Device warpage under mechanical load, thermal load, etc
- Commercially available tools
  - ANSYS, Mechanica, Abaqus, etc.

Force-Deflection Analysis: Example

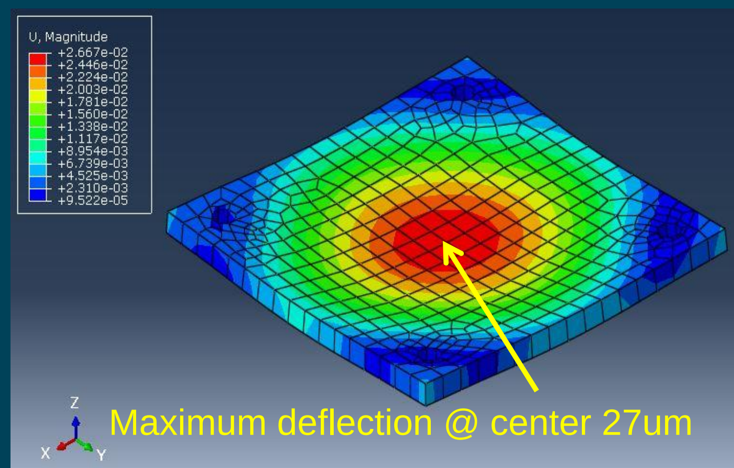
❑ First order approximation: individual components of the hardware analyzed for deflection

Pressure load



❑ Example: Stiffener plate

- Material: Steel; E=200Gpa; v=0.3; Linear Elastic
- Force: 400N
- Linear Brick element used
- Deflection criterion: 30um max



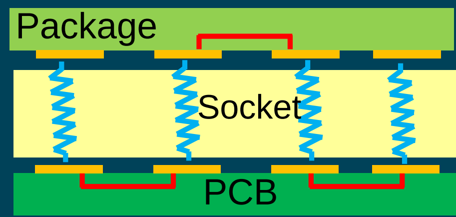
Section 8
Socket Interconnect System Testing

Socket Electrical Measurements

- ❑ Contact resistance measurement
- ❑ Signal integrity S-parameters measurements, which contain the following data:
  - Impedance of the socket
  - Insertion loss, return Loss
  - pin-to-pin cross-talk

Contact Resistance Measurement

- Contact resistance board and package are designed to validate retention system and measure pin total resistance (bulk + contact)



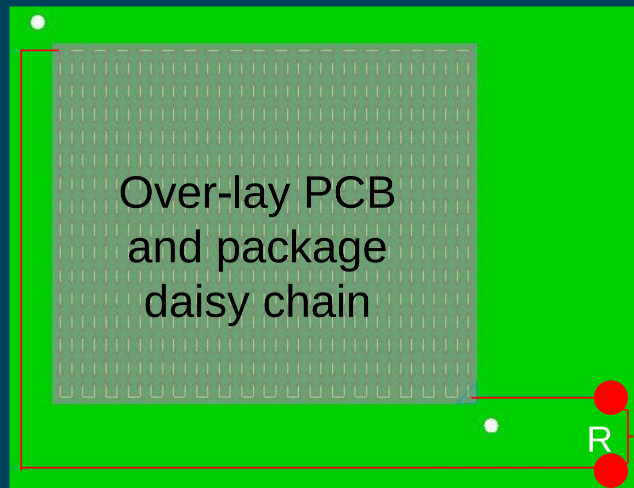
PCB daisy chain

- Contact resistance board can be designed with multiple loops
  - Helps in debugging areas which are electrically open
  - Electrical open indicates more PCB or package deflection. Insufficient stiffness of back plate and/or top plate

Package daisy chain

Contact Resistance Measurement (Cont'd.)

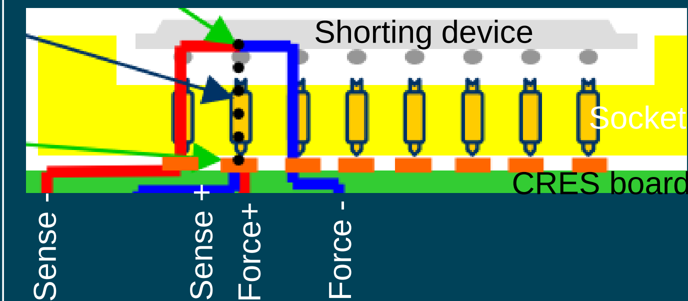
- ❑ Matching daisy chain package needs to be designed
- ❑ Package is soldered down to daisy chain board. Measured resistance is $R_{soldered}$
- ❑ Total resistance per pin
  - $(R-R_{soldered})$/number of pins

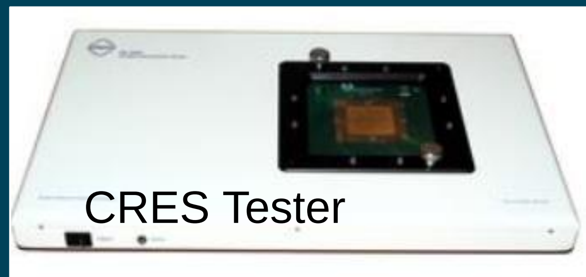


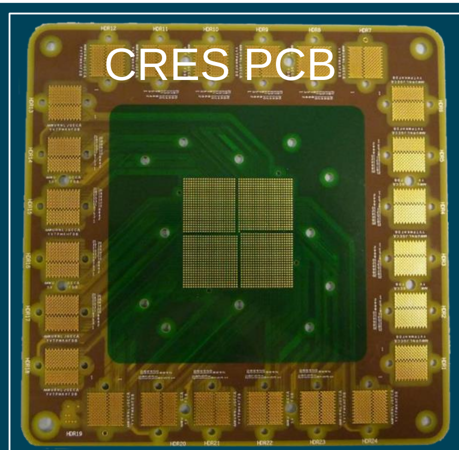
Contact Resistance Measurement (Cont'd.)

- Custom PCB is designed with 4-wire Kelvin measurement to measure single pin CRES in an array

Schematic of 4-wire measurement in an array

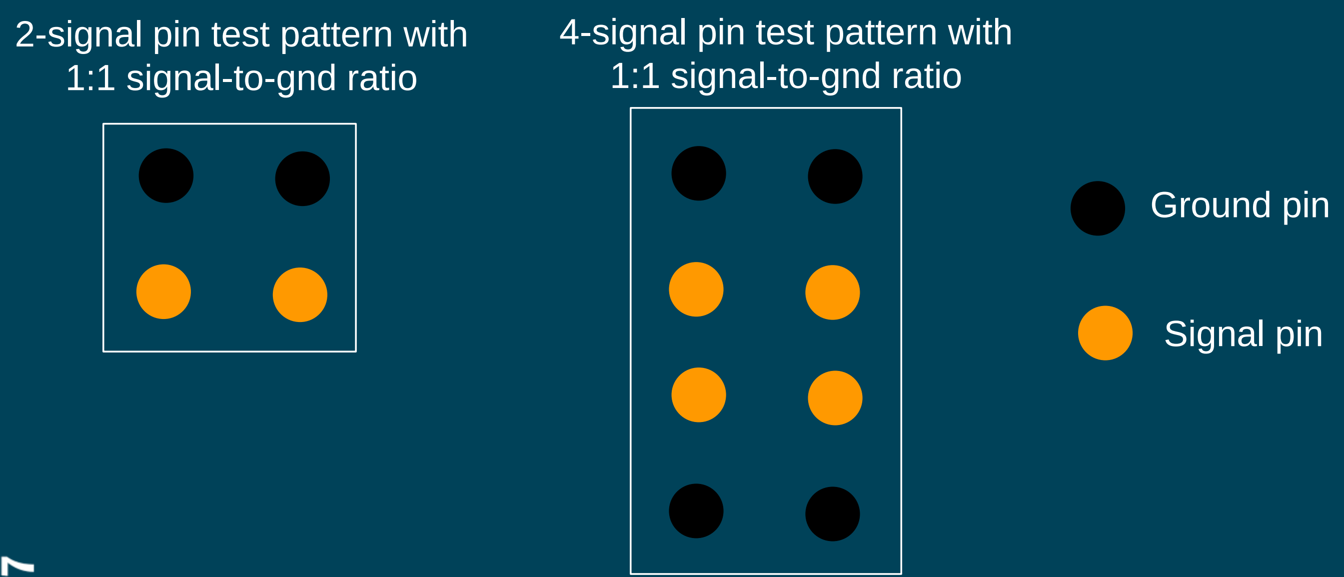






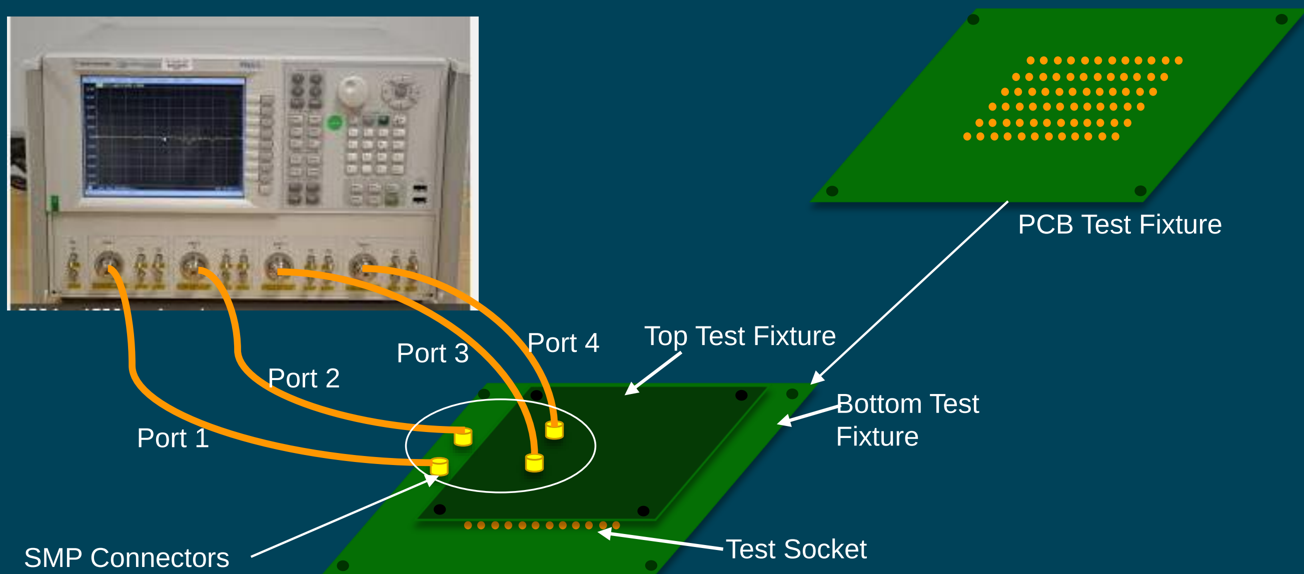
Signal Integrity Measurement

- Signal integrity S-parameter measurements characterize the electrical performance of the socket in terms of impedance, insertion loss, return loss and pin-to-pin cross-talk in frequency domain
- Identify a signal test pattern for testing. Examples below show 2-signal pin and 4-signal pins test patterns



Signal Integrity Measurement (Cont'd.)

- Diagram below shows an example of connecting a VNA (Vector Network Analyzer) test equipment to test fixtures measuring the s-parameters of two socket pins through 4-port measurements

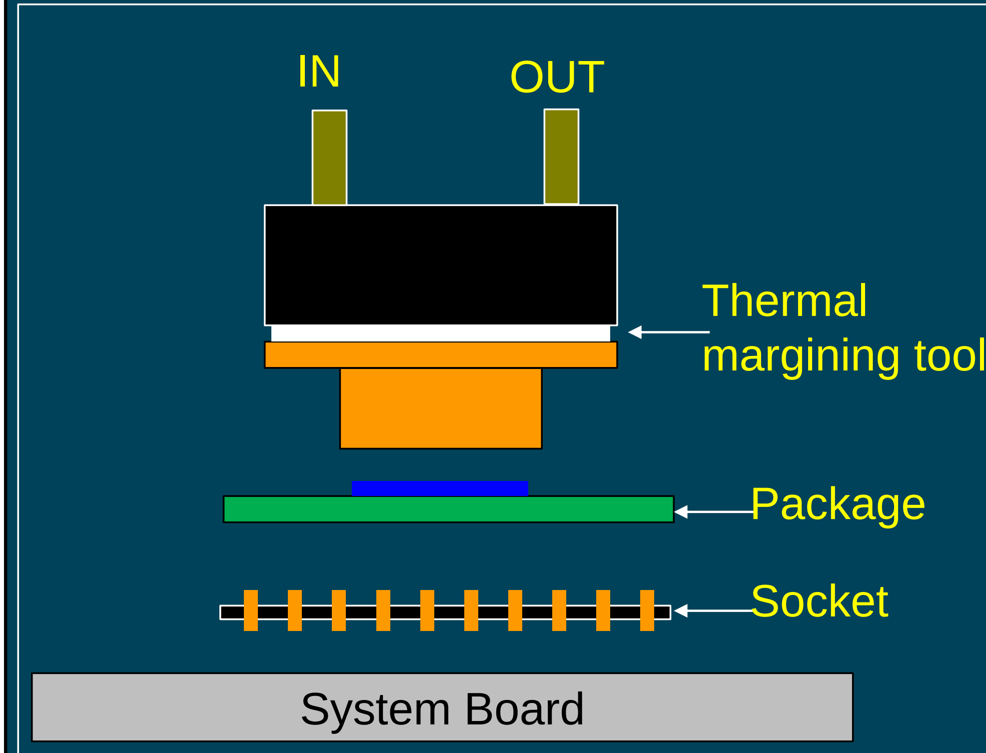


System Qualification

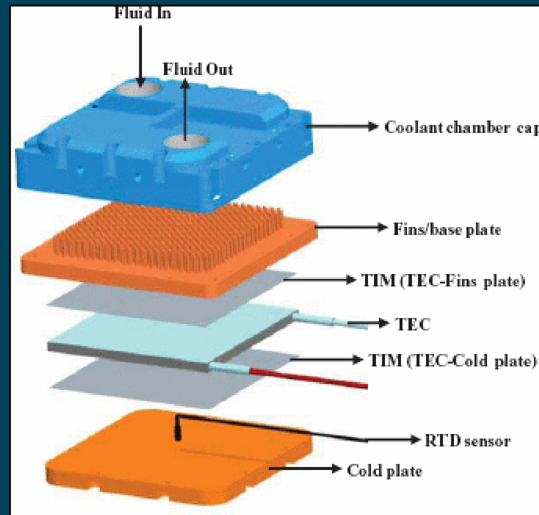
- System Level Validation and testing
  - At normal operating conditions
    - Normal operating conditions; passive heat sink or active heat sink
    - Extreme operating conditions; Thermal margining tool
  - Long-term aging tests
    - Environmental chamber – system is subjected to environmental test conditions

Thermal margining tool for CPU

System Qualification (Cont'd.)



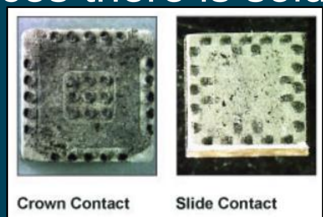
Schematic of system test



Exploded view of thermal margining tool

Maintenance: Repair & Cleaning

- Repair
  - Polymer sockets are harder to repair for damaged contacts
  - Dual compression pogo-pins can be replaced for bent pins caused by uneven loading
- Cleaning
  - Cleaning is essential for good CRES
  - Polymer socket contacts are cleaned using light brush and/or low pressure dry air
  - For HVM high volume test sockets, cleaning is done in-situ using cleaning coupons
  - For BGA devices there is solder migration from solder ball on to pin-tips



Section 9
Real World Example (Team Exercise)
& Summary of Technologies

Team Exercise

- Divide into 4 teams
- Each team is given set of requirements
- Discuss within team and come up with socket choice meeting the requirements
- Report – out the choice with justification

Team-A: Requirements

- **Package parameters:**
  - Package size: 12 mm X 12 mm
  - Die size: 5 mm X 7 mm
  - Package pitch: 0.65 mm
  - LGA pads with ENIPEG plating
- **Requirements:**
  - Cycle life: <100 cycles
  - Operating temperature: 15ºC to 75ºC
  - Electrical length <1.5 mm
  - Mechanical hardware: Standalone retention solution
  - Low cost
  - Lead time <4weeks

Team-B: Requirements

- **Package parameters:**
  - Package size: 12 mm X 12 mm
  - Die size: 5 mm X 7 mm
  - Package pitch: 0.65 mm
  - LGA pads with ENIPEG plating
- **Requirements:**
  - Cycle life: >100K cycles
  - Operating temperature: -10°C to 100°C
  - Electrical length < 6 mm
  - Handler compatible mechanical hardware for cycling
  - Lead time < 12 weeks

Team-C: Requirements

- **Package parameters:**
  - Package size: 12 mm X 12 mm
  - Die size: 5 mm X 7 mm
  - Package pitch: 0.65 mm
  - LGA pads with ENIPEG plating
- **Requirements:**
  - Cycle life: < 20 cycles
  - Operating temperature: -10°C to 100°C
  - Electrical length < 5 mm
  - Mechanical hardware: Standalone retention
  - End of life 5-7 years
  - High volume
  - Lead time < 24weeks

Team-D: Requirements

- **Package parameters:**
  - Package size: 12 mm X 12 mm
  - Die size: 5 mm X 7 mm
  - Package pitch: 0.65 mm
  - LGA pads with ENIPEG plating
- **Requirements:**
  - Cycle life: <10K cycles
  - Operating temperature: -10 °C to 100°C
  - Electrical length < 4 mm
  - Handler compatible mechanical hardware for cycling
  - Lead time < 12 weeks

Summary of Socket Technologies

	Relative Comparison of Three Technologies		
Factors	Polymer-based	Screw-Machine	Stamped-formed
Typical material	Silicon rubber filled with metal powder	Beryllium Copper	Beryllium Copper
Scalability <0.4mm pitch	Very Good	Good	Good
Electrical height	Low	Medium to High	Medium
Cost/pin	Medium	High	Low
Wiping action	No	Yes	Yes
Compliance/working range	Low	High	High
Cycle life (insertion/removal)	Low	High	Medium
Solderability to PCB	Poor	Good	Very Good

Summary of Socket Technologies (Cont'd.)

	Relative Comparison of Three Technologies		
Factors	Polymer-based	Screw-Machine	Stamped-formed
Single Vs Dual compression	Dual only	Single and dual	Single and dual
Material compression set	Medium	None	Very low
Typical lead time	Short	Medium	Long
Volume application	Low to Medium	Low	High
Tooling/NRE	Low	Medium	High
Real-world application	Validation	Test	Production/Test
Cycle time to design	Short to medium	Short to medium	Long
Serviceability	Low (difficult)	High (easy)	Low (difficult)

Section 10
Design to Production Activities
&
Check-list

Socket Design to Production Activity GANTT

#	ACTIVITY	RELATIVE TIMELINE
1	Understand product requirement	
2	Create Product Requirement Document	
3	Research and define type of socket contacts to be used and select	
4	Design Socket and Mechanical Hardware based on PRD -- Include FEA analysis	
5	Define PCB requirements and special mechanical tolerances, if any	
6	Design Test boards for testing sockets -- Signal Integrity and contact resistance	
7	Create detailed mechanical drawings including tolerances	
8	Obtain quotes, order and receive parts – Socket, hardware, test boards, etc.	
9	Assemble and test socket assemblies for continuity using test boards	
10	Test for resistance stability with number of insertions	
11	Conduct Signal Integrity tests using SI test boards	
12	Conduct Environmental tests – temperature and humidity cycling	
13	Revise socket and hardware designs per test results as required	
14	Finalize drawings and release design for production	

Time line depends on the complexity and number of design revisions

Process Steps and Check-list

No	Process Step	Check-List
1	Understand product requirement	❑ Electrical and Signal integrity ❑ Socket cycle life ❑ Socket+ hardware cost ❑ Environmental
2	Create Product Requirement Document (PRD)	❑ Socket cycle life ❑ Socket Cost ❑ Environmental test conditions ❑ SI requirements ❑ Keep-Out Volume requirements both for socket and hardware
3	Research and define type of socket contact to be used and select	❑ Review Supplier socket specifications – cycle life, cost, signal integrity data ❑ Get preliminary quotes ❑ Select the best option based on PRD requirements
4	Design Socket and Mechanical Hardware based on PRD	❑ Force-deflection analysis to ensure robust and right material selected for hardware design ❑ SI analysis done to ensure socket meets electrical requirements ❑ Right amount of socket element deflection ❑ Right mechanical tolerances and hardware is manufacturable

Process Steps and Check-list

No	Process Step	Check-List
5	Define PCB requirements and special mechanical tolerances if any	❑ PCB surface finish ❑ PCB tolerances -- both absolute and positional ❑ Solder-mask requirements, if any ❑ PCB board material – dielectric constant (Dk), Dissipation factor (Df) ❑ Socket/hardware keep-out volume defined meeting PRD
6	Design Test boards for testing sockets	❑ Daisy chain test boards for contact resistance testing ❑ Daisy-chain packages or test boards for contact resistance testing ❑ SI measurement test boards
7	Create detailed mechanical drawings including tolerances	❑ Hardware material call-out (E.g. Al, Steel, etc.) ❑ Positional and absolute tolerances ❑ Surface finish/plating of the material
8	Obtain quotes, order and receive parts – Socket, hardware, test boards	❑ Obtain quote for prototypes and production – sockets, hardware, test boards. ❑ Order both sockets, hardware and test boards

Process Steps and Check-list

No	Process Step	Check-List
9	Assemble and test socket assemblies for continuity using test boards	❑ Inspect all sockets and hardware parts to ensure they meet the specifications ❑ Inspect test boards for tolerances and surface finish
10	.Check for resistance stability with number of insertions	❑ Record resistance/contact ❑ Disassemble and reassemble sockets and component/device. ❑ Record resistance ❑ Repeat disassembly and reassembly and record resistance at every cycle. ❑ Determine the socket life based on the PRD requirement of change in resistance from the initial resistance.
11	Conduct Signal Integrity tests	❑ Socket Impedance ❑ Socket pin insertion loss ❑ Socket pin-t-pin Cross talk ❑ Current carrying capacity/pin
12	Conduct Environmental tests – temperature and humidity cycling	❑ Extreme high and low temperature testing depending on the application. Also duration depends on application ❑ Thermal shock – Temperatures depend on the application ❑ Humidity – Typically 85%RH

Process Steps and Check-list

No	Process Step	Check-List
13	Revise socket and hardware designs per test results as required	❑ Changes made to the socket and socket hardware per test results ❑ Force-deflection analysis and SI analysis done if required
14	Finalize drawings and release design for production	❑ New keep-out volume defined and made sure it meets PRD ❑ Positional and absolute tolerances ❑ Surface finish/plating of the material ❑ Final design meets PRD

Section 11
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