

The Mechanical Ruggedness of DirectFET™

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Abstract

This paper outlines the mechanical tests performed on the DirectFET™, the reasons for these tests and the results obtained from them.

1. Introduction

The evolution of faster and more powerful processors is driving ICs to lower operating voltages and higher current requirements; simultaneously space requirements are getting tighter. This demand for higher power/current densities puts even greater emphasis on the need to reduce the size, and electrical and thermal resistance of the associated semiconductor devices delivering this power.

Up to now many of the power semiconductor devices have been incorporated into IC type packaging such as the SO8 package (see figure 1a). However it is becoming increasingly difficult to meet the thermal, electrical and geometrical needs with these package outlines.



Fig. 1a A Typical Mosfet Device (SO8) showing the thermal and electrical path.

Some innovations such as the Copper Strap SO8 and MLPs (Micro Lead Packages) have been able to help the situation somewhat but still the requirements increase.

The DirectFET™ package was specifically designed for this job [Ref.1]. Its design allows for a greater die to footprint ratio and reduced thermal and electrical resistance (see figure 1c). It is source mounted and incorporates a copper can (see figure 1b) as the drain contact on the back to allow for backside (dual-side) cooling. Due to these innovations, the die-free-package resistance has been reduced from 1.5mΩ (for a standard SO8) to 0.1mΩ (for DirectFET™).



Fig. 1b DirectFET™

Many of the new IC and Power Device packages use surface mount technology, where the attachment to the PCB has changed from being

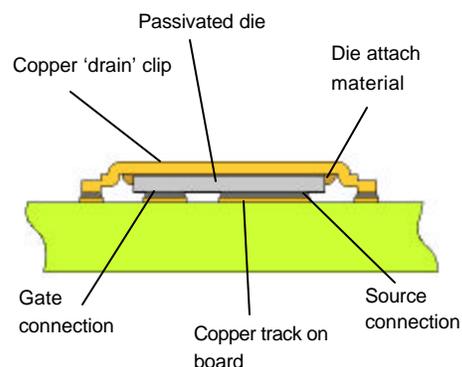
purely electrical to electrical-mechanical. This attribute is often overlooked when subjecting the devices to reliability tests.

With this in mind it was decided to subject it to a selection of suitable mechanical tests. These were to include bending, which could simulate stresses induced from the printed circuit board during board assembly, compression which would give maximum force values for the attachment of heat sinks or other similar heat exchangers to the back of the component, vibration which could approximate long term vibrations induced during the working life of the component, and shock or drop tests which simulate the extreme accelerations components on boards undergo during such situations.

Fig. 1c Cross-section of a DirectFET™

2. Bending Tests

These tests were carried out to determine the maximum bending strength of the DirectFET™ with



respect to deflection of the substrate/PCB, and to gain data of the influence different parameters (e.g. board material, board thickness solder type) would have on the results.

Ceramic capacitors were chosen as the benchmark for their reputation as being the most vulnerable component to adverse bending of the PCB [Ref 2].

For the purposes of this test a three-point bend test jig was designed and fitted to a Zwick tensile tester.

The tests were carried out in accordance with: EN 60068-2-21:1999 Test Ue₁

'Robustness of Terminations and Integral Mounting Devices: Substrate Bending Test'

It should be noted that the tests deviated from the standard in one respect. The Standard pitch for the lower two knife-edges is 90mm. However after the

first few initial tests, it became obvious that with a maximum possible deflection of 25mm there would be difficulty in deflecting the substrate enough to cause any failures in the DirectFET™. This pitch was reduced to 70mm. With respect to strain, it could be seen that over a 90mm pitch, 25mm deflection corresponds to 13mm deflection over a 70mm pitch.

Test Matrix

Control Conditions:

- 1.6 FR4 Printed Circuit Board
- 0.006" Solder Printing Screen
- 63Sn37Pb Solder Paste
- Bending Pressure from Backside

The following is a list of the other conditions in the matrix of tests:

- 0.8 FR4 Printed Circuit Board
- 0.010" Solder Printing Screen
- 96Sn4Ag Solder Paste
- Pressure from Front-side (Component side)
- Device orientation (DirectFET only)

The FR4 boards were built to *BS EN ISO 9001* and *CECC* approval, using UL approved (No. E161567) materials.

General procedures

- The test speed for all tests was 60mm/min (1mm/s)
- The tests were carried out in ambient room temperature (25°C)
- Maximum deflection obtainable was 25mm
- The test duration and deflection were initiated after 0.05N of force had been registered on the tester
- Board breakage was assumed to have occurred when the force dropped by 30%. (Note: 99.99% of board breakages were catastrophic)

Ceramic Capacitors

In the case of substrate bending from the backside of the board:

The substrate with component was deflected until a $\pm 20\%$ change from the initial Capacitance was registered as an indicator of failure. Note: More 90% of the samples tested failed catastrophically.

In the case of front side bending:

The substrate with component was initially deflected to 3mm then returned to the rest position with the Capacitance being measured during the return and at rest after. It was then subsequently deflected to 3.33mm and returned, again with the capacitance being measured on the return. This process continued, incrementing the deflection each time by $\frac{1}{3}$ mm until a shift of $\pm 20\%$ in the capacitance was measured. The current

increment was then taken as the failure deflection.

DirectFET™

In the case of substrate bending from the backside of the board:

The substrate with component was deflected until Gate leakage, a short circuit or an open circuit was detected. The test was then terminated and the current deflection noted.

In the case of front side bending:

The substrate with component was initially deflected to 8mm then returned to the rest position during which the component was monitored for Gate leakage, short circuits and open circuits. It was then subsequently deflected to 8.5mm and returned, again being monitored for the above criteria on the return. This process continued, incrementing the deflection each time by $\frac{1}{2}$ mm until failure occurred. The current increment was then taken as the failure deflection.

Note: The initial deflections of 3mm for Ceramic Capacitors and 8mm for DirectFET™ were established to start as close to the expected failure point as possible. As there was a greater failure range for the DirectFET™ the increments were larger so as to minimise their number and thus the affects of fatigue.

Strain Calculations

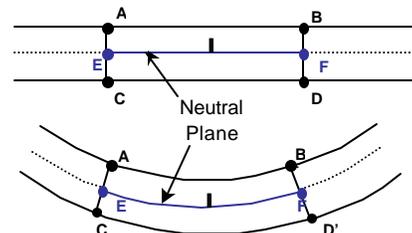


Fig. 2a Depiction of the Neutral Plane in a cross-section of PCB

Assuming total plasticity for the board material, the strain was calculated using the thickness of the board and the radius of curvature under bending. The radius can be calculated from the known deflection in the z-axis and the pitch of the lower knife-edges. Once the radius of curvature of the neutral plane has been established, it is just a simple task of calculating the ratio between that and the radius of curvature for either the top or bottom face of the board. This ratio is directly proportional to the change in length of any section of board assuming that the neutral plane is the original length (as it does not change) and both the top and bottom of the board are under compression and tension respectively.

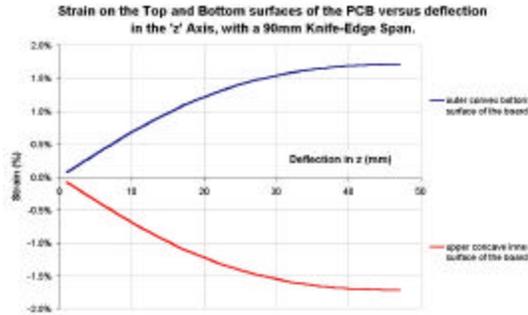


Chart. 2a Strain on the Top and Bottom Surfaces of the Printed Circuit Board versus deflection in the 'z' axis, over a 90mm Knife Edge Pitch

It can be seen from Chart 2a that for the region of deflection that we are interested in (0mm to 25mm) the relationship between deflection in the z-axis and surface strain on the board is virtually linear.

Results

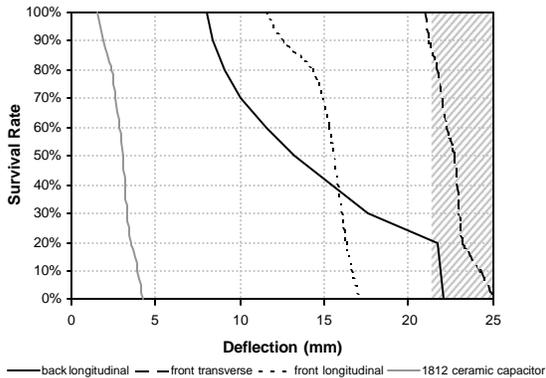


Chart. 2b Mortality curve showing the deflection against Survival Rate for the IRF6601 and a 1812 Ceramic Capacitor

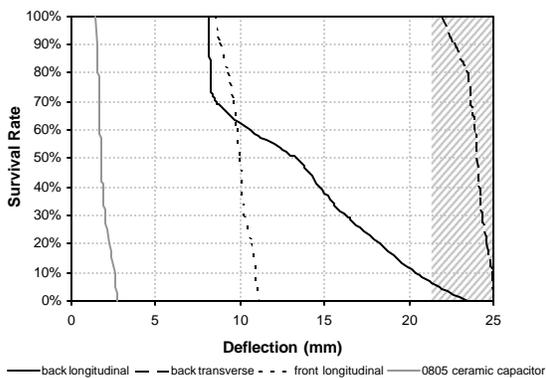


Chart. 2c Mortality curve showing the deflection against Survival Rate for the IRF6602 and 0805 Ceramic Capacitor

$$\text{Survival Rate} = \frac{N_{dt} - N_{df}}{N_{dt}} \times 100$$

Where: N_{dt} = Number of devices tested
 N_{df} = Number of devices failed

Note: The shaded areas indicate the point at which the substrates failed. No components survived beyond this.

Conclusions

In every case the DirectFET™ out-performed the Ceramic Capacitors and in most instances the DirectFET™ was seen to handle three to five times the deflection (thus three to five times the surface strain). Despite the similar appearance to the Ceramic Capacitors, the DirectFET™ is not just held to the board at each end, but has the added strength of the area array die attach in the middle.

3. Compressive Tests

DirectFET™ has been developed to enable dual side cooling. The attachment of heat sinks or the constant pressure of the component against the chassis of a PC case or cabinet will apply forces to the topside of the component.

This test was carried out to obtain the maximum possible force needed to cause mechanical and electrical failure in the device.

The Test Jig and Procedure

The Application Ram was machined from Stainless Steel and again mounted on the tensile/compressional tester, with the PCB, which was designed in house, sitting on an aluminium block (see Fig. 3a). The polyimide PCBs were manufactured by an external contractor, to BS EN ISO 9001 and CECC approval, using UL (No. E161567) approved materials. They were 1.6mm thick and had 2oz of copper finished in nickel gold. A Tektronix Inc. Curve Tracer (Type 576) was used to measure gate threshold during the testing of the DirectFET™ mosfet devices to indicate a point of failure. Gate threshold was chosen as the indicator because of its sensitivity.

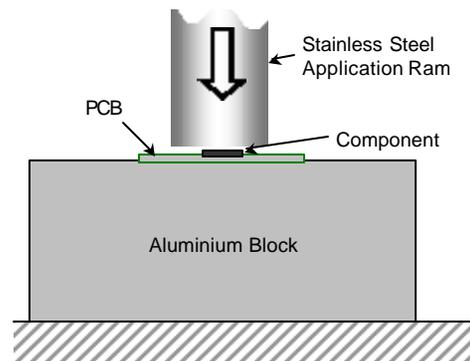


Fig. 3a The Compression Test Jig

The tests were carried out in ambient room temp (22°C) with gravity (1g) assumed to be 9.81m/s².

The test speed for all tests was 0.5mm/min (with a return velocity of 20mm/min where applicable) with each test being initiated after a force of 0.05N had registered on the tester. If no failure had been

detected, the tests were terminated at a maximum force of 1750N (equivalent 178.4Kg).

Continuous Pressure:

Pressure was applied to the topside of the component until a shift of $\pm 20\%$ was seen in the gate threshold (Vg-th).

Note: All components failed catastrophically giving much greater shift in Vg-th.

Stepped Pressure:

6601: Initially pressure was ramped up to 600N, then relieved and the component was allowed to return to neutral with the Gate Threshold being monitored during the whole cycle. The pressure was then ramped up to 700N and relieved, again with the Gate Threshold being monitored throughout. This process was repeated using 100N steps until the component failed.

6602: Initially pressure was ramped up to 400N, following the same procedure as above, except for the increment amount being reduced to 50N

Note: The initial pressures were determined to be as close to the expected failure range as possible, to minimise the number of cycles and thus eliminate any fatigue induced by the repetitive process.

Results

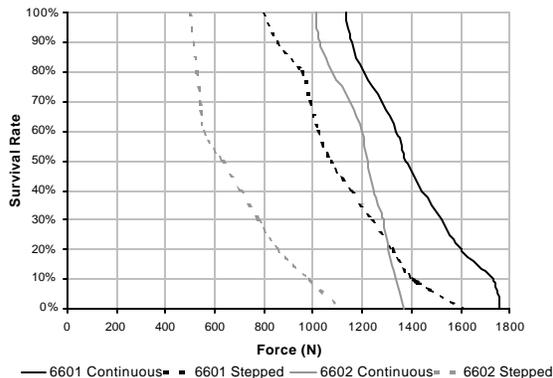


Chart. 3a Mortality Curve showing the Survival Rate of DirectFET™ against pressure in N

Conclusions

It can be seen on Chart 3a that results were very satisfactory. The lowest failure value from all the components tested was just over 50Kg. An average person weighs around 70Kg to 80Kg so it can be said with comfort that the DirectFET™ will withstand the forces involved in application of heat exchangers.

4. Vibration

The tests were carried out in accordance with: *BS 2011 Part 2.1 Fd "Random Vibration – wide band general requirements" 1973*

The tests were carried out in ambient room temp (22°C) with gravity (1g) assumed to be 9.81m/s^2 .

General procedures

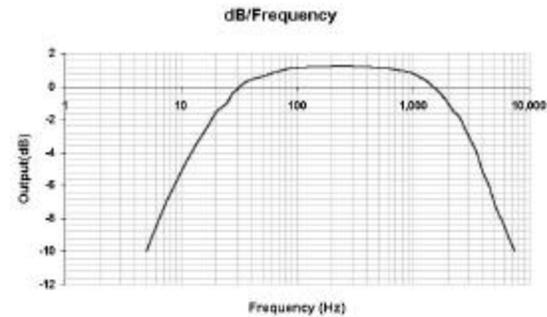


Chart. 4a Random Vibration Frequency Bandwidth

The components were subjected to 3 hours of random vibrations within a bandwidth of 20Hz to 2kHz (see Chart 4a), undergoing 3.2g_{rms} ($31.4\text{m/s}^2_{\text{rms}}$) with an Acceleration Spectral Density Value of $0.005\text{g}^2/\text{Hz}$ ($[0.48\text{m/s}^2]^2/\text{Hz}$)

The Test Matrix was simply with the components tested on board in each axis (x, y and z).

The polyimide PCBs were manufactured by an external contractor, to *BS EN ISO 9001* and *CECC* approval, using *UL* (No. E161567) approved materials. They were 1.6mm thick and had 2oz of copper finished in nickel gold.

Results

Attitude 1	0/16 Failures
Attitude 2	0/16 Failures
Attitude 3	0/16 Failures

Conclusions

The mass of the component (6601 - 800mg average) is negligible when considering the surface area attached to the board. It will never be great enough to put the solder attach under any significant amount of stress. With this in mind it is quite easy to see why there were no failures.

5. Drop/Shock Tests

These tests were carried out in accordance with *BS 2011: Part 2.1 Ed:1992 Test Ed: 'Free fall'*.

The devices were mounted on polyimide boards, which were manufactured by an external contractor to *BS EN ISO 9001* and *CECC* approval, using *UL* (No. E161567) approved materials. They were 1.6mm thick and had 2oz of copper finished in nickel gold. The boards were secured to a substantial aluminium block who's

descent during the fall was guided by an ultra low friction bearing onto a steel block from different heights and in five attitudes:

1. On the short edge of the device
2. On the long edge of the device
3. On the corner of the device
4. With device flat, on top of the substrate
5. With the device flat, underneath the substrate

The specified drop heights according to BS 2011 are **25mm**, 50mm, **100mm**, 250mm, **500mm** and **1000mm**.

Note the values in bold are the BSI preferred values. When no devices failed, we increased the drop height to 1500mm.

Results

Drop height (mm)	IRF6601		IRF6602	
	1000	1500	1000	1500
Attitude 1	0/10	0/10	0/10	0/10
Attitude 2	0/10	0/10	0/10	0/10
Attitude 3	0/10	0/10	0/10	0/10
Attitude 4	0/10	0/10	0/10	0/10
Attitude 5	0/10	0/10	0/10	0/10

Table. 5a Drop Test Results

Note: 10 devices were tested for each combination of height and attitude. Each device was dropped 20 times.

Conclusions

As with the vibration tests the same considerations applied here. As the components have such a low mass, with respect to the surface area attached to the board they were not subjected to any substantial forces of acceleration.

6. Summary

Throughout all the tests the DirectFET™'s performance was excellent. It has shown itself to be an extremely rugged device.

- In the case of board bending it is five times less susceptible to damage than ceramic capacitors that share the board
- It can withstand compressive forces up to 50N with ease, making it well suited to double sided cooling.
- It passed shock and Vibration tests with flying colours

Future work:

- Sinusoidal Vibration Testing
- Impact Testing

- Pull Testing
- Shear Testing

No problems with any of these are anticipated.

7. References

[1] 'DirectFET™ – A Proprietary New Source Mounted Power Package for Board Mounted Power' (PCIM 2001)

Andrew Sawle, Martin Standing, Tim Sammon, Arthur Woodworth
 Packaging R&D, International Rectifier, UK

[2] *Bending Strength Technical Data. (Chip Type Monolithic Ceramic Capacitor)*
 Murata

8. Standards

BS EN 60068-2-21:1999 / IEC 60068-2-21:1999
 Environmental testing — Part 2-21 Test U:

Robustness of terminations and integral mounting devices

ICS 19.040

BS 2011: Part 2.1 Fd:1973

Basic environmental testing procedures — Part 2.1
 Test Fd:

Random vibration — Wide band general requirements

BS 2011: Part 2.1 Ed:1992 / IEC 68-2-32:1975

Environmental testing — Part 2.1 Test Ed:
Free fall