

Introduction

Surface-mount assembly places unique demands on the development and manufacturing process by requiring different CAD symbols for printed circuit board (PCB) layout, different soldering processes for production (reflow vs. wave solder), and different test and reliability issues.

Socketing surface-mount devices allows you to ease some of the demands of surface-mount assembly. Conventional mounting techniques can be used on socketed devices, either by through-hole soldering them to a PCB or by mounting them onto a socketed carrier board for wire-wrap applications.

This application note discusses the following topics:

- Mechanical considerations for J-lead sockets
- Socket evaluation for J-lead packages
- Socket evaluation for quad flat pack (QFP) packages
- Socket evaluation for ball-grid array (BGA) packages (including FineLine BGA™ packages)
- Socket evaluation for pin-grid array (PGA) packages
- Packaging operations for wire-wrap applications
- Socket and insertion/extraction tool manufacturers

Mechanical Considerations for J-Lead Sockets

J-lead devices make contact with electrical sockets from either the bottom or the side of the leads. Depending on how the devices are held in place, the sockets can bend the leads and make the electrical contact unreliable. Accordingly, you must consider the type of package, the number of device insertions and removals, and the amount of lead deformation before choosing a socket.

Once a design enters the production phase, cost becomes a major concern. As a result, low-cost production sockets, designed to hold a device permanently and securely, are available. However, these sockets must exert a reasonable force on the device leads to prevent the device from popping out of the socket. After several insertions, this force can deform the leads, causing them to short out or fail to make contact and rendering the device unusable. Therefore, Altera strongly recommends using a burn-in socket during the design and development phases of a project, and a low-cost production socket during the production phase.



Burn-in sockets are zero-insertion-force (ZIF) sockets that do not deform a device's leads.

Production sockets must be chosen carefully. If a device must be removed more than 10 times, Altera recommends using non-deforming, low-insertion-force (burn-in) sockets. In high-stress environments (e.g., strong G-forces, thermal shock, and high humidity), sockets with high-insertion forces and optional retention clips are needed. To reduce the possibility of damaging device pins, most high-quality sockets include a standoff mechanism that prevents a device from being forced too far into a socket.

Socket Evaluation for J-Lead Packages

Altera tested available production sockets for use with 44-, 68-, and 84-pin windowed ceramic J-lead chip carrier (JLCC) packages. Although tests were performed using JLCC packages, the following information also applies to plastic J-lead chip carrier (PLCC) packages. Each socket was subjected to three tests:

- The change in the gap between the corner pins of each device was measured before and after each of 10 insertions.
- Each pin of the socket was wired in series and tested for open circuits lasting longer than 10 μ s. This open circuit test was performed while the socket was attached to a vibration block. The amplitude of vibration was 3.0 mm peak-to-peak at a frequency that oscillated between 10 Hz and 55 Hz in 1-minute cycles for 2 hours. The vibration test was performed on all three axes at a temperature of 70° C.
- The actual point of contact between the socket pin and the device lead was photographed to determine the direction of the forces and the amount of surface contact between them.

Altera tested sockets from eight manufacturers. Tables 1 through 3 show the results of the 44-, 68-, and 84-pin production sockets that passed the open-and-short circuit test. Sockets are ranked by their ability to maintain the device's pin integrity after multiple device insertions.

Table 1. Summary of 44-Pin Production Socket Analysis

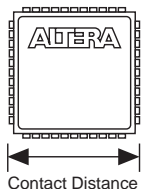
Vendor & Part Number	Comments
Thomas & Betts Corporation PCS-044A-1	Least pin deformation. Contact force has a downward component. No retainer clip option.
AMP, Inc. 821575-1	Moderate pin deformation. Contact force has a downward component. No retainer clip option.

Table 2. Summary of 68-Pin Production Socket Analysis

Vendor & Part Number	Comments
Thomas & Betts Corporation PCS-068A-1	Least pin deformation. Contact force has a downward component. No retainer clip option.
ITT/Cannon Corporation LCS-68-12	Low pin deformation. Contact force has a downward component. Has a retainer clip option.
AMP, Inc. 821574-1	Moderate pin deformation. Contact force has a downward component. No retainer clip option.

Table 3. Summary of 84-Pin Production Socket Analysis

Vendor & Part Number	Comments
Thomas & Betts Corporation PCS-084A-1	Least pin deformation. Contact force has a downward component. No retainer clip option.
ITT/Cannon Corporation LCS-84-12	Moderate pin deformation. Contact force has a downward component. Has a retainer clip option.
AMP, Inc. 822281-1 (for surface mount)	Moderate pin deformation. Contact force has a downward component. No retainer clip option. Designed for plastic packages.
AMP, Inc. 821573-1	Large pin deformation. Very tight fit. No retainer clip option. Due to pin deformation, Altera recommends a maximum of three insertions. Designed for ceramic packages.
FCI QILE-84P-410T	Large pin deformation. Very tight fit. No retainer clip option. Due to pin deformation, Altera recommends a maximum of three insertions.



Vendors may provide additional information about their products, such as material selection, prevention of solder ingress during wave soldering, or lead shape. Altera recommends qualifying sockets before committing to a particular vendor.

Table 4 shows the contact distances for Altera® packages. These measurements should be used to select a socket, preferably with internal stand-offs, for use with Altera devices.

Table 4. Device Contact Distances

Package	Pins	Contact Distance (Minimum mils)	Contact Distance (Maximum mils)
PLCC	20	385	395
PLCC, JLCC	28	485	495
PLCC, JLCC	44	685	695
PLCC, JLCC	68	985	995
PLCC, JLCC	84	1,185	1,195

Socket Evaluation for QFP Packages

Because QFP packages are more susceptible to lead deformation, production sockets must be rigorously qualified. Altera recommends using a burn-in socket for QFP packages because of the socket’s reliability. While sockets should always be qualified, Table 5 suggests sockets based on the number of pins and type of QFP package.

Table 5. Socket Vendor Information for QFP Packages

Package Type	Number of Pins	Socket Vendor	Part Number
Thin quad flat pack (TQFP)	32	Yamaichi	IC51-0324-1498
Plastic quad flat pack (PQFP)	44	Yamaichi	IC51-467-KS11258
TQFP	44	Yamaichi	IC51-0444-1568
PQFP	100	Yamaichi	IC51-1004-814-2
Ceramic quad flat pack (CQFP)	100	Yamaichi	IC51-1004-814-2
TQFP	100	Yamaichi	IC51-1004-809
PQFP	132	Yamaichi	IC51-1324-828
TQFP	144	Yamaichi	IC51-1444-1354-7
PQFP	160	Yamaichi	IC51-1604-845-4
PQFP	208	Yamaichi	IC51-2084-1052-11
Power quad flat pack (RQFP) (square heat sink)	208	Yamaichi	IC51-2084-1052-11
RQFP (round heat sink)	208	Yamaichi	IC51-1052KS-13087
CQFP	208	Yamaichi	IC51-1509-KS14057
RQFP (square heat sink)	240	Yamaichi	IC51-1655KS-13666
RQFP (round heat sink)	240	Yamaichi	IC51-2404-1655-2
RQFP	304	Yamaichi	IC51-3044-1471-2

Socket Evaluation for BGA Packages

Table 6 lists socket vendor information for Altera BGA and FineLine BGA packages.

Package Type	Ball Pitch (mm)	Number of Pins	Socket Vendor	Part Number
BGA	1.50	225	Enplas	BGA-225-1.5-01A
			Yamaichi	NP276-37206-AC03327
	1.27	256	CTi	8227-256-1-00
			CTi	8235-356-1-00
		356	CTi	8235-356-0-00
			CTi	8235-356-0-00
600	Yamaichi	NP276-100522-AC09796		
FineLine BGA	1.00	100	Loranger	110SQ-100B6617 (1)
		256	Loranger	170SQ-256B6618C (1)
		484	Loranger	230SQ-484B6617 (1)
		672	Loranger	270SQ-672B6617 (1)

Note:

- (1) These socket recommendations may change due to package enhancements. Please contact Altera Applications for more information.

Socket Evaluation for PGA Packages

Table 7 lists socket vendor information for PGA packages.

Number of Pins	Socket Vendor	Part Number
403	Yamaichi (1)	NP178-64401-KS14828
	AMP (1)	1-382320-7
	Berg Electronics	(2)
	Mill-Max	(2)
503	AMP (1), (3)	382876-6
	Yamaichi (1)	NP236-102002-AC01601
	3M/Textool (1)	2-0503-01357-050-019-002
	Berg Electronics	(2)
	Mill-Max	(2)
599	Yamaichi	NP236-102002-AC05625
	Berg Electronics	(2)
	Mill-Max	(2)

Notes:

- (1) ZIF sockets are available for 403- and 503-pin PGA packages.
- (2) This low-profile PCB socket has no standard part number. Contact the vendor for more information.
- (3) Although the socket was created for 560-pin PGA packages, it is compatible with 503-pin packages.

Table 8 lists socket tools for inserting and extracting PGA packages in non-ZIF sockets.

Table 8. Socket Tools for PGA Package Insertion & Extraction in Non-ZIF Sockets		
Action	Tool Vendor	Part Number
Insertion	Com-Kyl	181-MIC
Extraction	Com-Kyl	281-MIC

Packaging Operations for Wire-Wrap Applications

Wire-wrap applications require a through-hole mount that is compatible with the J-lead package. The sockets specified do not typically conform mechanically to most wire-wrap panels. Wire-wrap cards have machined receptacles in rows with 100-mil spacing between receptacles and 300-mil spacing between rows. Carrier boards provide an effective way to bridge the gap. Mounting a socket to a carrier board provides the convenience of wire wrap, while occupying a relatively small area on a device. Some carrier boards have signal routing with shorter paths or 45° bends to minimize signal reflection.

Table 9 shows telephone numbers for various socket manufacturers. Contact the appropriate manufacturer for additional information.

Socket & Insertion/Extraction Tool Manufacturers

Table 9. Socket & Insertion/Extraction Tool Manufacturers (Part 1 of 2)		
Product	Company	Telephone Number
Production sockets	3M/Textool Corporation	(800) 328-0411
	AMP, Inc.	(800) 522-6752
	Thomas & Betts Corporation	(508) 699-9800
	Framatome Connectors International (FCI)	(408) 946-9666
	ITT/Cannon Corporation	(714) 557-4700
	Berg Electronics	(510) 651-2700
	Mill-Max	(516) 922-6000
	IronWood Electronics	(612) 452-8100

Product	Company	Telephone Number
Test and burn-in sockets	3M/Textool Corporation AMP, Inc. Advanced Interconnections Corporation Dai-Ichi Seiko Company, Ltd. (Japan) Emulation Technology, Inc. Yamaichi Enplas IronWood Electronics	(800) 328-0411 (800) 522-6752 (401) 823-5200 (81) 0482-53-3131 (408) 982-0660 (408) 456-0797 (408) 749-8124 (612) 452-8100
Carrier boards and wire-wrap adapters	Advanced Interconnections Corporation Emulation Technology, Inc.	(401) 823-5200 (408) 982-0660
PGA socket insertion/extraction tools	Com-Kyl	(408) 734-9660

Conclusion

Information in this application note is based on tests performed by Altera and on information provided to Altera by various vendors. Altera assumes no liability for the use of third-party products mentioned in this document.



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