AN10343

MicroPak soldering information

Rev. 2 — 30 December 2010

Application note

Revision history

Rev	Date	Description
v.2	20101230	text and graphics updated to latest standards

Contact information

For more information, please visit: **http://www.nxp.com**

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1. Introduction

NXP Semiconductors' PicoGate and MicroPak packages are approximately ten to fifteen times smaller than conventional SO14 packages, providing significant miniaturization in space-constrained applications. They are available in a wide range of logic functions with a wide range of choices and deliver the right levels of performance.

PicoGate and MicroPak devices include single-, dual-, and triple-gate functions and are housed in 5-, 6-, 8- and 10-pin packages with selectable functions. To support the widest range of applications, every product in the portfolio is specified for high-temperature operation (−40 °C to +125 °C). Since they perform the most popular functions and either meet or exceed competitive specifications, they eliminate single-source problems.

Driven by applications with a very small circuit board mounting area, the PicoGate logic family offers the most popular logic functions for space-constrained systems such as cellular phones, pagers, and portable consumer products (CD players, VCRs, cameras, hard disks, notebook computers, PC cards, CD ROMs, and Personal Digital Assistants (PDAs)). They can also be used as simple glue/repair logic to implement last minute design changes or to eliminate dependence on intricate line layout patterns and to simplify routing.

This application note describes the following mounting methods for MicroPak packages:

- MicroPak footprint
- SOT886/833-1 MicroPak on WLCSP/BGA footprint and vice versa
- SOT996-2 MicroPak on VSSOP8 footprint and vice versa

2. MicroPak Overview

2.1 Package description

The MicroPak package is a near Chips Scale Package (CSP) Land Grid Array (LGA) type plastic encapsulated package with a copper lead frame base. The package has no leads or bumps with peripheral land terminals at the bottom of the package. The terminals are soldered to solder lands on the Printed-Circuit Board (PCB), after solder paste is deposited.

An overview of released MicroPak packages is given in Table 1.

Table 1.   Overview MicroPak packages
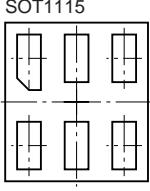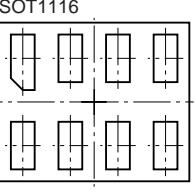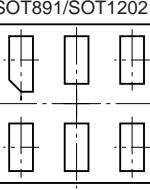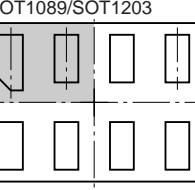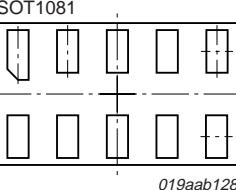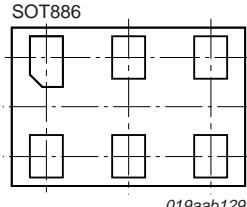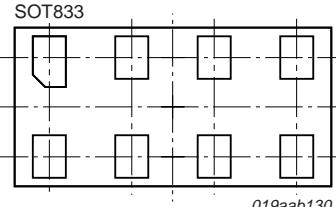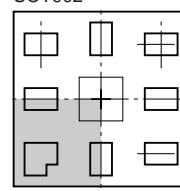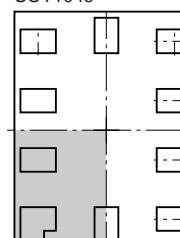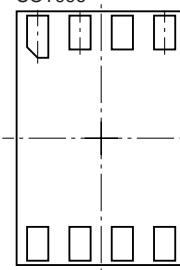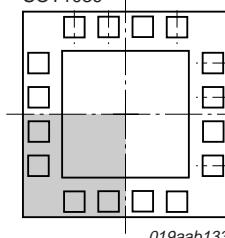
Properties		Number of pins			
Pitch [mm]	Height [mm]	5 or 6	8	10	16
0.3	0.35	SOT1115	SOT1116	-	-
		SOT1115 019aab124	SOT1116 019aab125		
0.35	0.5/0.35	SOT891/SOT1202	SOT1089/SOT1203	SOT1081-1	-
		SOT891/SOT1202 019aab126	SOT1089/SOT1203 019aab127	SOT1081 019aab128	

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Table 1. **Overview MicroPak packages** *…continued*

Properties		Number of pins			
Pitch [mm]	Height [mm]	5 or 6	8	10	16
0.5 (Dual-in-Line)	0.5	SOT886	SOT833-1	-	-
		019aab129	019aab130		
0.5	0.5	-	SOT902-1	SOT1049-1	SOT1039-1
			019aab131	019aab132	019aab133
0.5 (VSSOP8 replacement)	0.5	-	SOT996-2	-	-
			019aab134		

3. MicroPak soldering information

3.1 Solder paste

The following solder pastes were used in the evaluation and gave satisfactory results:

- PbSn paste: Alpha Metals Omnix 5002 (62 % Sn, 36 % Pb, 2 % Ag)
- SAC paste: Alpha Metals Omnix 310 (95.5 % Sn, 4 % Ag, 0.5 % Cu)

Both these solder pastes are 'no-clean'; due to the small stand-off height of the MicroPak, proper cleaning underneath the package is not possible.

Both Pb or Pb-free solder can be used, although it is advised to use Pb-free solder paste as this is required by European legislation from July 2006 onwards.

A wide variety of Pb-free solder pastes is available, containing combinations of tin, copper, antimony, silver, bismuth, indium, and other elements. The different types of Pb-free solder pastes have a wide range of melting temperatures. Solders with a high melting point may be more suitable for the automotive industry, whereas solders with a low melting point can be used for soldering consumer IC packages.

The most common substitute for SnPb solder, is Pb-free paste SAC, which is a combination of tin (Sn), silver (Ag), and copper (Cu). These three elements are usually in the range of 3 % to 4 % of Ag and 0 % to 1 % of Cu, which is near eutectic. SAC typically has a melting temperature of around 217 $^\circ$C, and requires a reflow temperature of more than 235 $^\circ$C.

Table 2.   Typical solder paste characteristics

Solder (near eutectic alloys)	Melting temperature	Minimum peak reflow temperature
SnPb	183 $^\circ$C	215 $^\circ$C
SAC	217 $^\circ$C	235 $^\circ$C

A no-clean solder paste does not require cleaning after reflow soldering and is therefore preferred, provided that this is possible within the process window. If a no-clean paste is used, flux residues may be visible on the board after reflow.

For more information on the solder paste, please contact your solder paste supplier.

3.2 Moisture sensitivity level and storage

The MicroPak components have a very good package moisture resistance. The Moisture Sensitivity Level (MSL) according to JEDEC-STD-020D is MSL1.

Table 3.   Pb-free process - Package classification reflow temperatures (from J-STD-020D)

Package thickness	Volume (<350 mm^3)	Volume (350 mm^3 to 2000 mm^3)	Volume (>2000 mm^3)
<1.6 mm	260 $^\circ$C	260 $^\circ$C	260 $^\circ$C
1.6 mm to 2.5 mm	260 $^\circ$C	250 $^\circ$C	245 $^\circ$C
>2.5 mm	250 $^\circ$C	245 $^\circ$C	245 $^\circ$C

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3.3 Stencil

Table 4 gives the recommended electroformed stencil thickness for MicroPak packages with a terminal pitch of greater than or equal to 0.5 mm, between 0.4 mm to 0.5 mm and less than or equal to 0.4 mm. Side wall roughness of the apertures should be smooth to improve the solder paste release.

Table 4. **Typical stencil thicknesses**

IC package pitch	Stencil thickness
≥0.5 mm	150 μm
0.4 mm to 0.5 mm	100 μm or 125 μm
≤0.4	100 μm

3.4 MicroPak placement

The required placement accuracy of a package depends on a variety of factors, such as package size and the terminal pitch, but also the package type itself. During reflow, when the solder is molten, a package that has not been placed perfectly may center itself on the pads: this is referred to as self-alignment. Therefore, the required placement accuracy of a package may be less tight if it is a trusted self-aligner. It is known, for example, that BGAs are good at self-alignment, as the package body essentially rests on a number of droplets of molten solder, resulting in minimal friction.

Table 5 gives typical placement tolerances as a function of the IC package terminal pitch.

Table 5. **Typical placement accuracies**

Package terminal pitch	Placement tolerance
≥0.65 mm	100 μm
<0.65 mm	50 μm

3.5 Reflow soldering

The most important step in reflow soldering is reflow itself, when the solder paste deposits melt and soldered joints are formed. This is achieved by passing the boards through an oven and exposing them to a temperature profile that varies in time. A temperature profile essentially consists of three phases:

1. Preheat: the board is warmed up to a temperature that is lower than the melting point of the solder alloy

2. Reflow: the board is heated to a peak temperature that is well above the melting point of the solder, but below the temperature at which the components and board's Organic Solderability Preservative (OSP) finish are damaged

3. Cooling down: the board is cooled down rapidly, so that soldered joints freeze before the board exits the oven

The peak temperature during reflow has an upper and a lower limit:

- Lower limit of peak temperature; the minimum peak temperature must be at least high enough for the solder to make reliable solder joints; this is determined by solder paste characteristics; contact your paste supplier for details

- The upper limit of the peak temperature must be lower than:

– the maximum temperature the component can withstand according to the specification

– the temperature at which the board or the components on the board are damaged (contact your board supplier for details)

Examples of a general purpose Pb-free reflow profile are shown is Figure 1 and Table 6.
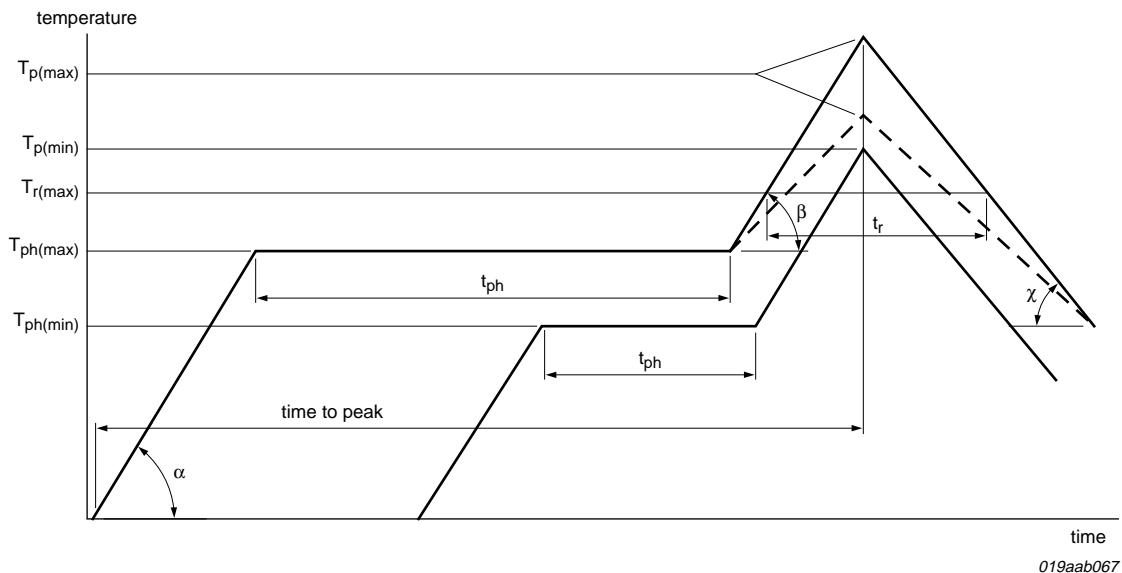
Fig 1.   Example of a general purpose Pb-free reflow profile

Table 6.   Explanation of the reflow temperature profile

Parameter	Value(s)	Typical value(s)	Remark
α	1 °C/s to 5 °C/s	2 °C/s	determined by component and board type and finish
ß	1°C/s to 5 °C/s	1.5 °C/s	determined by component and board type and finish
X	−2 °C/s to +6 °C	-	determined by component and board type and finish
$T_{ph(min)}$ to $T_{ph(max)}$	120 °C to 200 °C	160 °C	depends on the solder paste used - contact your solder paste supplier
t_{ph}	0 s to 180 s	100 s to 180 s	depends on the solder paste used - contact your solder paste supplier
t_r	30 s to 90 s	40 s to 70 s	depends on board finish and solder paste voiding behavior - contact your board and solder paste supplier
$T_{p(min)}$	235 °C	-	temperature measured in the solder at the coldest spot [1]
$T_{p(max)}$	260 °C	245 °C	depends on the board and the board finish in case of OSP and the most temperature-sensitive component used on the board [1]
reflow atmosphere	-	-	general purpose reflow is under air atmosphere, nitrogen reflow is allowed

[1]   Delta between $T_{p(min)}$ and $T_{p(max)}$ preferably limited to 10 °C.

Additional soldering information and guidelines for board-mounting of surface-mount IC packages are described in *AN10365 'Surface mount reflow soldering description'*.

3.6 MicroPak soldering information for WLCSP/BGA footprint

Figure 2 shows the recommended solder land pattern for mounting the MicroPak XSON6 (SOT886) package. Using this pattern results in a very good electrical and mechanical connection which can also be inspected and tested for continuity. Using the land grid array package eliminates the co-planarity issues of leaded and WLCSP/BGA type devices.

The 6-pad MicroPak package available from NXP Semiconductors is alternately second-sourced by Fairchild Semiconductors. Although the footprint for the Texas Instruments WLCSP/BGA package is physically smaller, the MicroPak very easily fits the same footprint. Figure 3 shows the recommended solder land pattern for the WLCSP/BGA package and the footprint of the MicroPak SOT886.

Placing the WLCSP/BGA package on the MicroPak footprint is not recommended. As can be seen in Figure 4, the larger land pattern for the MicroPak may cause solder starvation due to the limited amount of solder in the package solder ball. Solder paste would help, although there will be limited mechanical contact. This is true for the larger Pb-free WLCSP/BGA balls. Even less mechanical contact is achieved with the smaller PbSn WLCSP/BGA balls. Figure 5 shows the recommended solder land pattern for the WLCSP/BGA package and the footprint of the MicroPak SOT833-1.
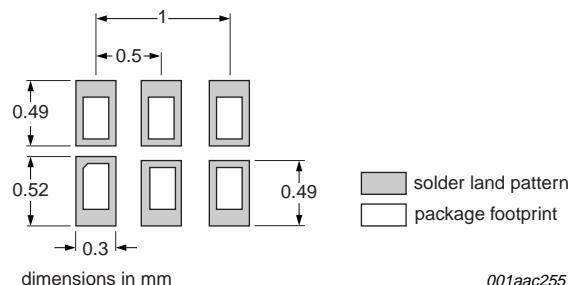
Fig 2.   MicroPack footprint
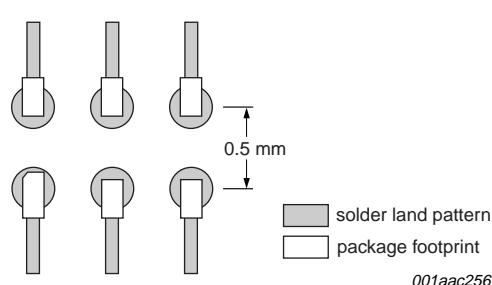
Fig 3.   MicroPack SOT886 on BGA footprint
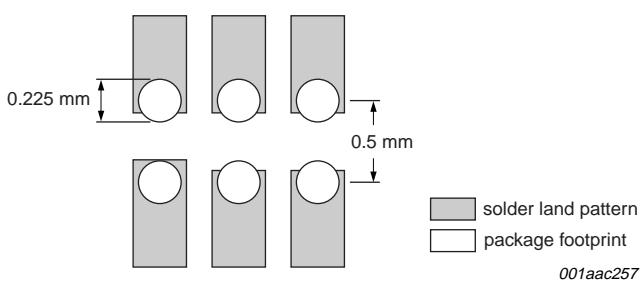
Fig 4.   BGA on MicroPack footprint
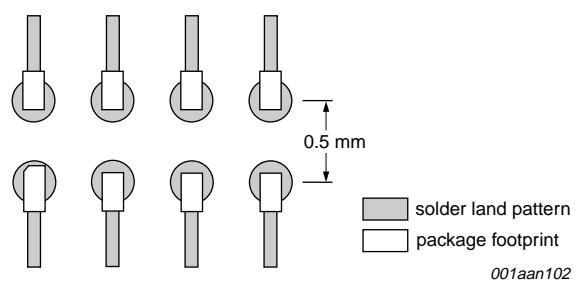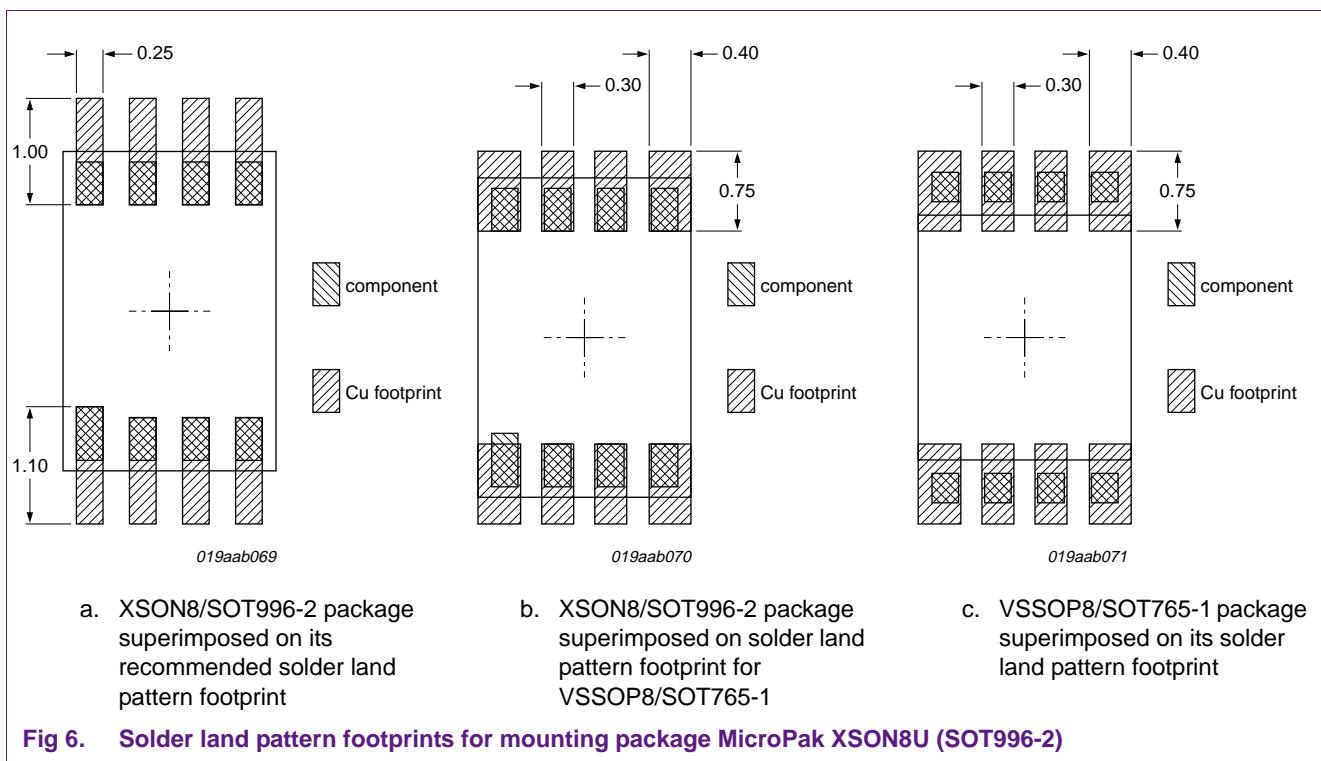
Fig 5.   MicroPack SOT833-1 on BGA footprint

3.7 SOT996-2 MicroPak soldering information for VSSOP8 footprint

Figure 6a shows the recommended solder land pattern footprint for mounting the MicroPak XSON8 (SOT996-2) package. Using this pattern results in a very good electrical and mechanical connection which can also be inspected and tested for continuity. Figure 6b shows how the MicroPak XSON8 (SOT996-2) package fits the VSSOP8 (SOT765-1) solder land pattern footprint. Figure 6c shows the VSSOP8 (SOT765-1) package on its VSSOP8 solder land pattern footprint.

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a. XSON8/SOT996-2 package superimposed on its recommended solder land pattern footprint

b. XSON8/SOT996-2 package superimposed on solder land pattern footprint for VSSOP8/SOT765-1

c. VSSOP8/SOT765-1 package superimposed on its solder land pattern footprint

Fig 6. **Solder land pattern footprints for mounting package MicroPak XSON8U (SOT996-2)**

4. Manual repair of leadless MicroPak

In general, replacing a defective component on a soldered board, during repair or rework, can be carried out either manually or with a dedicated repair station.

The rework process should consist of the following steps:

1. Dry bake the board and the new component, if necessary
2. Mark the position of the old component
3. Remove the old component
4. Prepare the site
5. Print solder paste on the new component
6. Reflow the solder paste on the new component
7. Place the new component on the board
8. Solder the new component
9. Visual inspection, electrical measurement, and X-ray inspection

The above steps are summarized in Figure 7.

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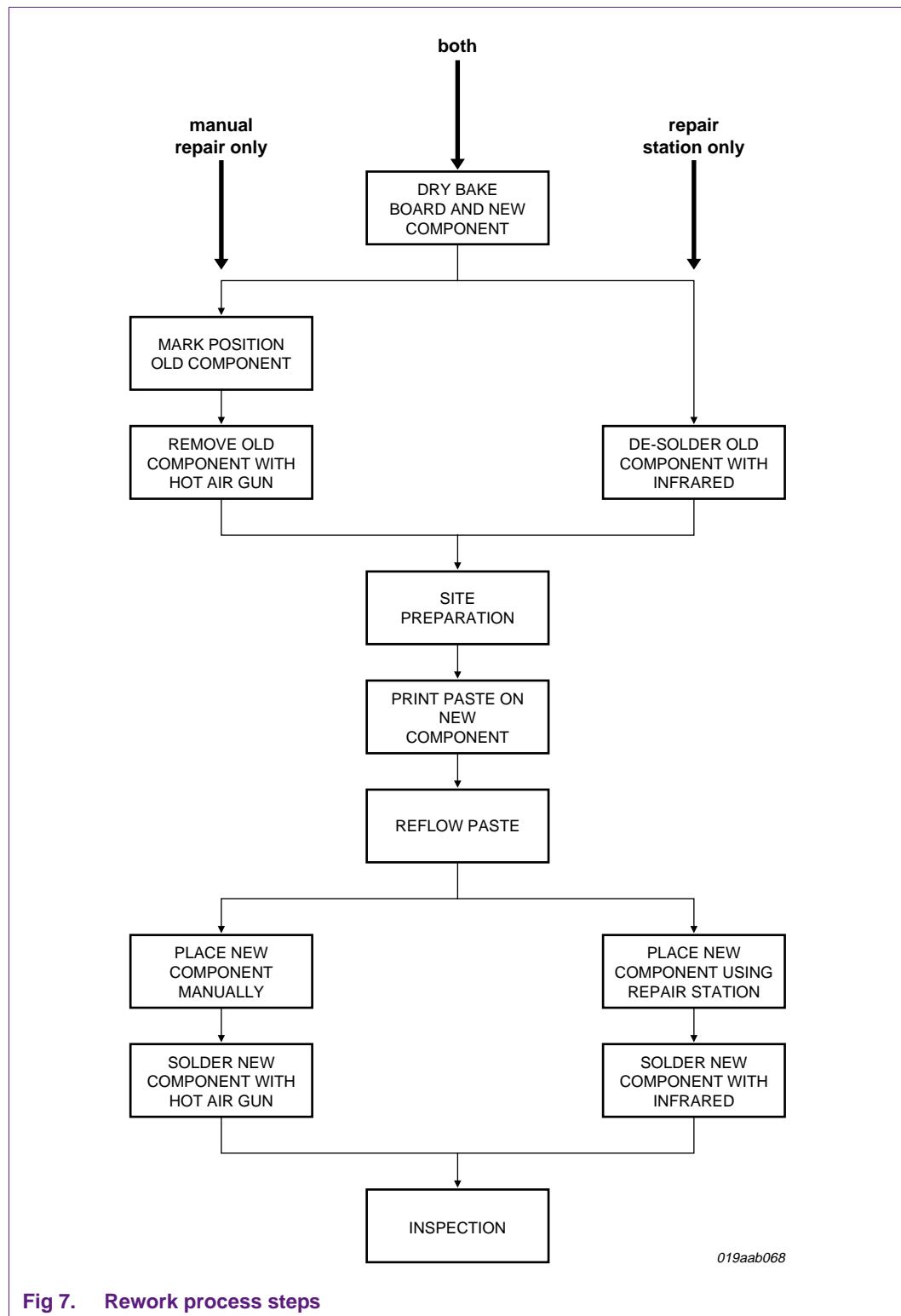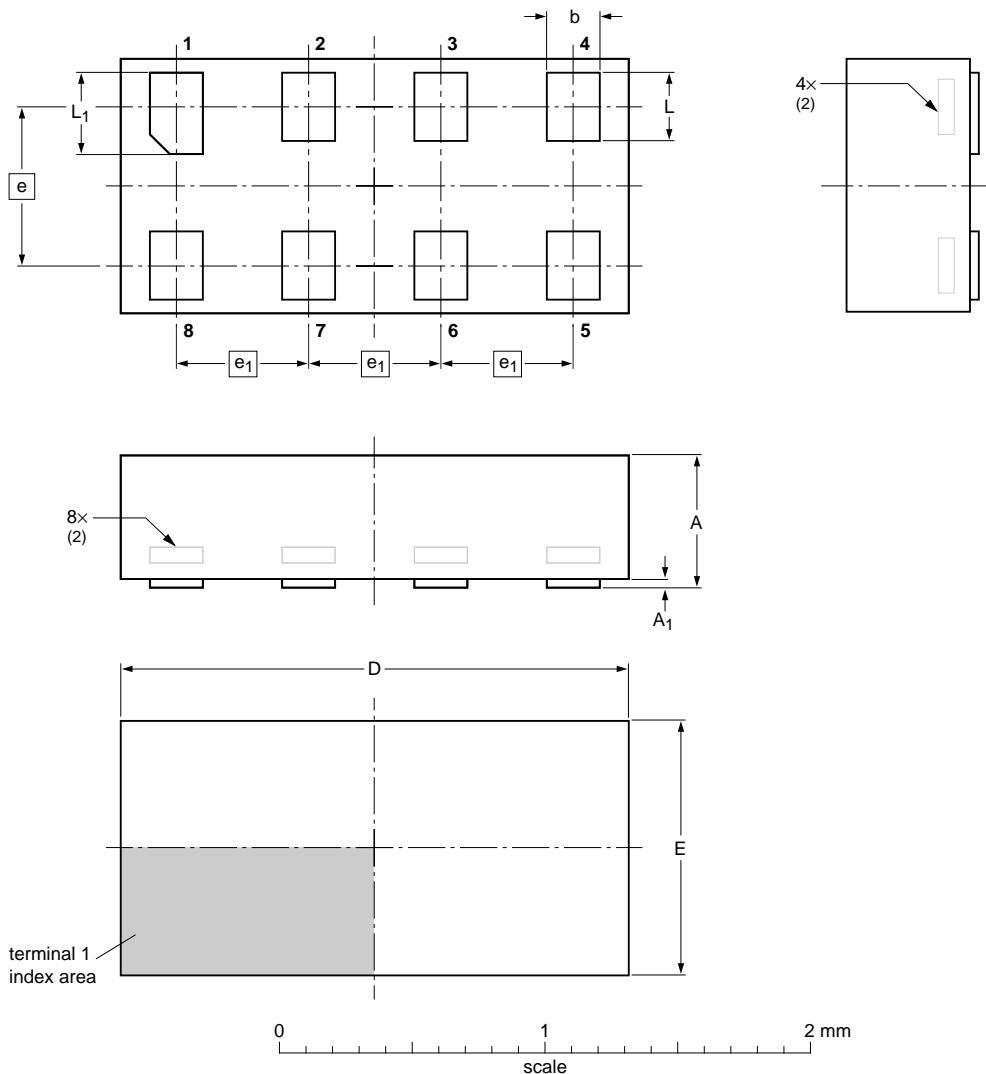
Fig 7.   Rework process steps

5. Package outline and PCB footprint

The package outline drawing and recommended soldering footprint of the released packages are shown in Figure 10 to Figure 19. The soldering footprints are only recommended and may be different for specific application requirements.

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XSON8: plastic extremely thin small outline package; no leads; 8 terminals; body 1 x 1.95 x 0.5 mm **SOT833-1**

DIMENSIONS (mm are the original dimensions)

UNIT	A[1] max	A₁ max	b	D	E	e	e₁	L	L₁
mm	0.5	0.04	0.25 0.17	2.0 1.9	1.05 0.95	0.6	0.5	0.35 0.27	0.40 0.32

Notes
1. Including plating thickness.
2. Can be visible in some manufacturing processes.

| OUTLINE VERSION	REFERENCES				EUROPEAN PROJECTION	ISSUE DATE
	IEC	**JEDEC**	**JEITA**			
SOT833-1	- - -	MO-252	- - -			~~07-11-14~~ 07-12-07

Fig 8. SOT833-1 (XSON8) package outline
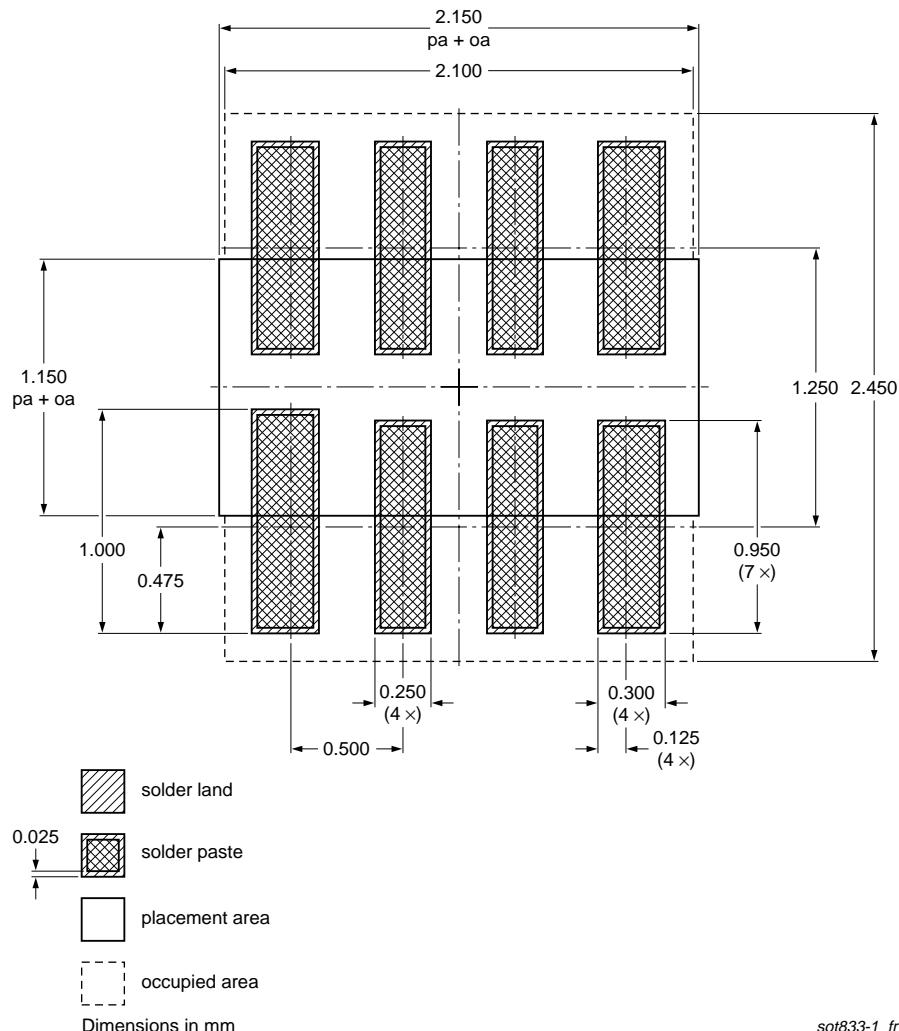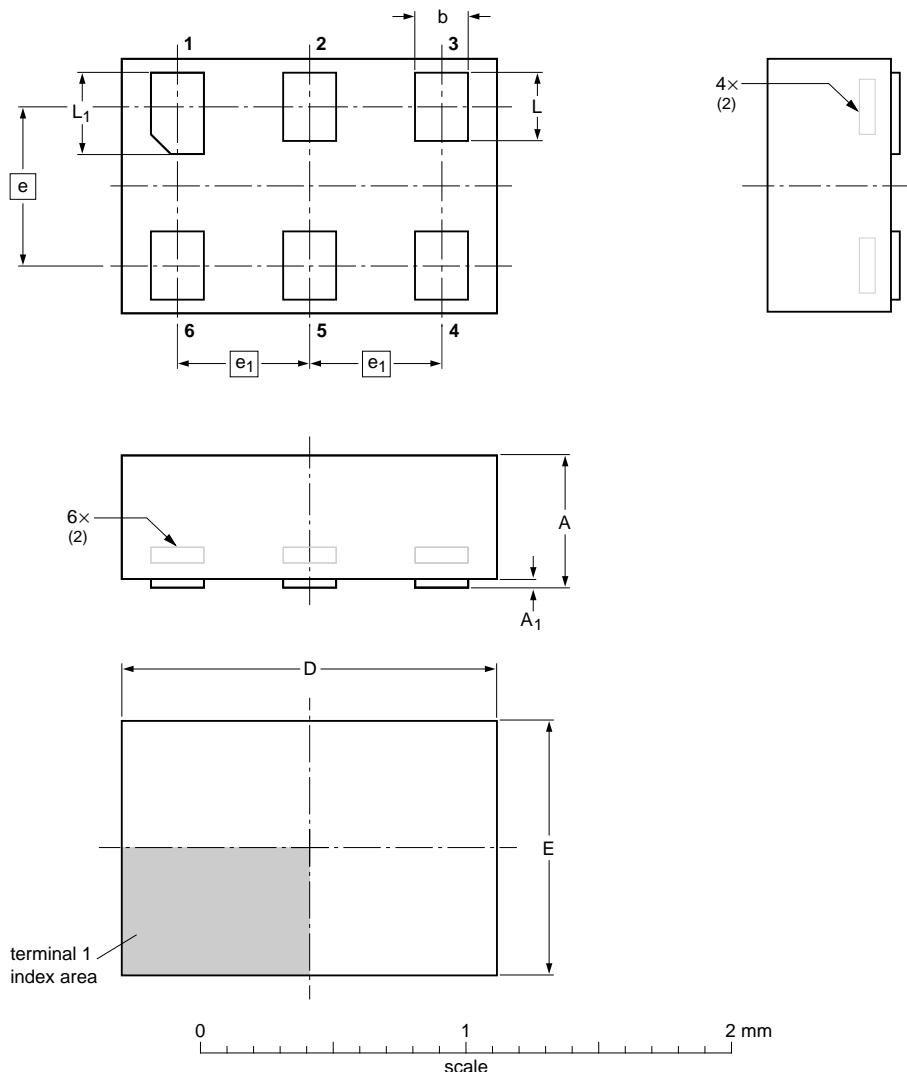
Fig 9.   SOT833-1 (XSON8) solder footprint

XSON6: plastic extremely thin small outline package; no leads; 6 terminals; body 1 x 1.45 x 0.5 mm **SOT886**

DIMENSIONS (mm are the original dimensions)

UNIT	A[1] max	A_1 max	b	D	E	e	e_1	L	L_1
mm	0.5	0.04	0.25 0.17	1.5 1.4	1.05 0.95	0.6	0.5	0.35 0.27	0.40 0.32

Notes
1. Including plating thickness.
2. Can be visible in some manufacturing processes.

OUTLINE VERSION	REFERENCES				EUROPEAN PROJECTION	ISSUE DATE
	IEC	**JEDEC**	**JEITA**			
SOT886		MO-252				~~04-07-15~~ 04-07-22

Fig 10. SOT886 (XSON6) package outline
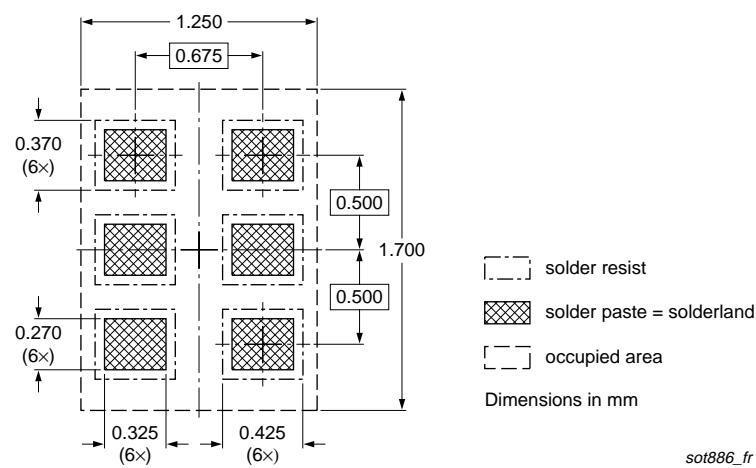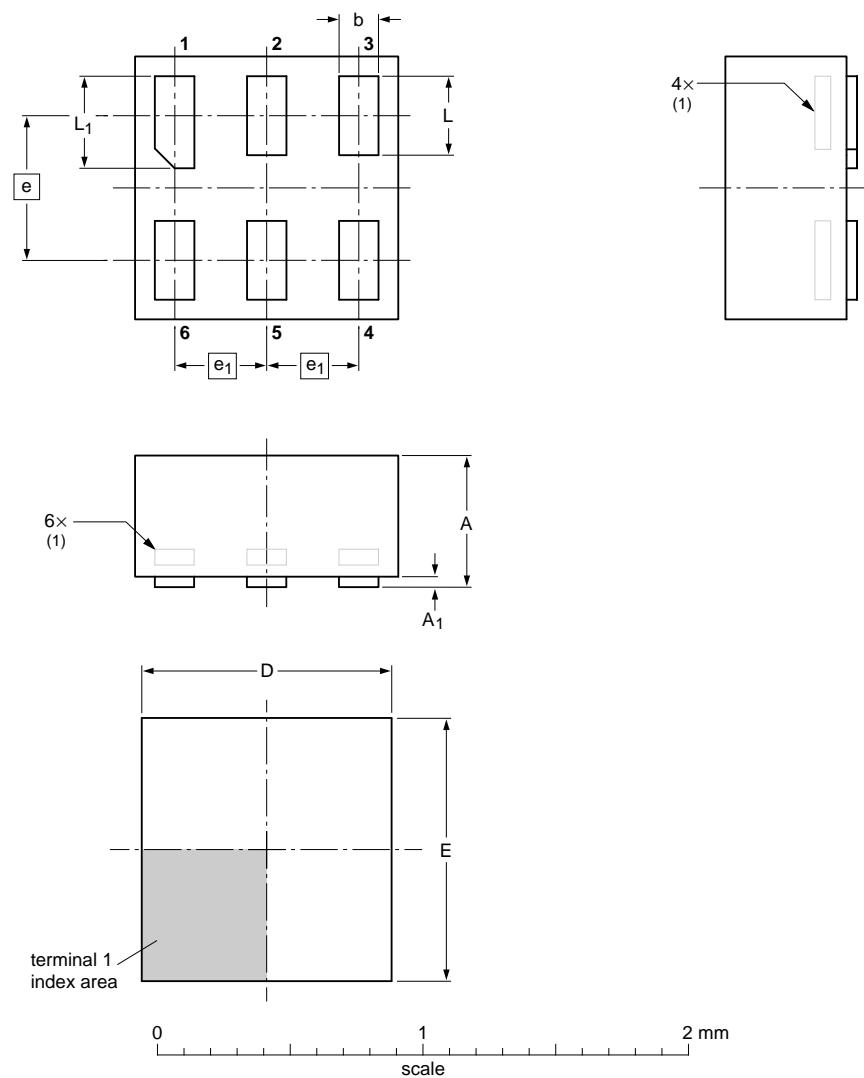
**Fig 11. SOT886 (XSON6) solder footprint**

XSON6: plastic extremely thin small outline package; no leads; 6 terminals; body 1 x 1 x 0.5 mm **SOT891**

DIMENSIONS (mm are the original dimensions)

UNIT	A max	A$_1$ max	b	D	E	e	e$_1$	L	L$_1$
mm	0.5	0.04	0.20 0.12	1.05 0.95	1.05 0.95	0.55	0.35	0.35 0.27	0.40 0.32

Note

1. Can be visible in some manufacturing processes.

| OUTLINE VERSION	REFERENCES				EUROPEAN PROJECTION	ISSUE DATE
	IEC	JEDEC	JEITA			
SOT891						05-04-06 07-05-15

Fig 12. SOT891 (XSON6) package outline

Fig 13.   SOT891 (XSON6) solder footprint

**XQFN8U: plastic extremely thin quad flat package; no leads;
8 terminals; UTLP based; body 1.6 x 1.6 x 0.5 mm** SOT902-1

DIMENSIONS (mm are the original dimensions)

UNIT	A max	A$_1$	b	D	E	e	e$_1$	L	L$_1$	v	w	y	y$_1$
mm	0.5	0.05 0.00	0.25 0.15	1.65 1.55	1.65 1.55	0.55	0.5	0.35 0.25	0.15 0.05	0.1	0.05	0.05	0.05

OUTLINE VERSION	REFERENCES				EUROPEAN PROJECTION	ISSUE DATE
	IEC	JEDEC	JEITA			
SOT902-1	- - -	MO-255	- - -			~~05-11-25~~ 07-11-14

Fig 14. SOT902-1 (XQFN8U) package outline

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Fig 15.   SOT902-1 (XQFN8U) solder footprint

XSON8U: plastic extremely thin small outline package; no leads;
8 terminals; UTLP based; body 3 x 2 x 0.5 mm

SOT996-2

DIMENSIONS (mm are the original dimensions)

UNIT	A max	A$_1$	b	D	E	e	e$_1$	L	L$_1$	L$_2$	v	w	y	y$_1$
mm	0.5	0.05 0.00	0.35 0.15	2.1 1.9	3.1 2.9	0.5	1.5	0.5 0.3	0.15 0.05	0.6 0.4	0.1	0.05	0.05	0.1

OUTLINE VERSION	REFERENCES				EUROPEAN PROJECTION	ISSUE DATE
	IEC	JEDEC	JEITA			
SOT996-2	- - -		- - -			07-12-18 07-12-21

Fig 16. SOT996-2 (XSON8U) package outline

Fig 17. SOT996-2 (XSON8U) solder footprint

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HXQFN16U: plastic thermal enhanced extremely thin quad flat package; no leads; 16 terminals; UTLP based; body 3 x 3 x 0.5 mm

SOT1039-1

terminal 1 index area

detail X

terminal 1 index area

0   2.5   5 mm

scale

DIMENSIONS (mm are the original dimensions)

UNIT	A max	A₁	b	D	Dₕ	E	Eₕ	e	e₁	e₂	L	L₁	v	w	y	y₁
mm	0.5	0.05 0.00	0.35 0.25	3.1 2.9	1.95 1.75	3.1 2.9	1.95 1.75	0.5	1.5	1.5	0.35 0.25	0.1 0.0	0.1	0.05	0.05	0.1

OUTLINE VERSION	REFERENCES				EUROPEAN PROJECTION	ISSUE DATE
	IEC	JEDEC	JEITA			
SOT1039-1	- - -		- - -			07-11-14 07-12-01

Fig 18. SOT1039-1 (HXQFN16U) package outline

Fig 19.   SOT1039-1 (HXQFN16U) solder footprint

XQFN10U: plastic extremely thin quad flat package; no leads; 10 terminals;
**UTLP based; body 2 x 1.55 x 0.5 mm**

SOT1049-1

DIMENSIONS (mm are the original dimensions)

UNIT		A	A₁	b	D	E	e	e₁	e₂	e₃	L	L₁	v	w	y	y₁
mm	max nom min	0.50	0.05 0.03 0.00	0.30 0.23 0.15	1.65 1.55 1.45	2.1 2.0 1.9	0.58	0.5	1.16	1.5	0.4 0.3 0.2	0.15 0.08 0.00	0.1	0.05	0.1	0.05

OUTLINE VERSION	REFERENCES				EUROPEAN PROJECTION	ISSUE DATE
	IEC	JEDEC	JEITA			
SOT1049-1	- - -	MO-255	- - -			08-02-28 10-02-05

Fig 20. SOT1049-1 (XQFN10U) package outline

Fig 21. SOT1049-1 (XQFN10U) solder footprint

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**XSON10U: plastic extremely thin small outline package; no leads;
10 terminals; UTLP based; body 1 x 1.7 x 0.5 mm**

SOT1081-1

DIMENSIONS (mm are the original dimensions)

UNIT		A	A₁	b	D	E	e	e₁	e₂	L	L₁	L₂	v	w	y	y₁
mm	max	0.50	0.05	0.20	1.8	1.1				0.4	0.10	0.45				
	nom	0.48	0.03	0.15	1.7	1.0	0.35	1.4	0.6	0.3	0.05	0.35	0.1	0.05	0.05	0.1
	min	0.46	0.00	0.10	1.6	0.9				0.2	0.00	0.25				

OUTLINE VERSION	REFERENCES				EUROPEAN PROJECTION	ISSUE DATE
	IEC	JEDEC	JEITA			
SOT1081-1	- - -		- - -			~~08-03-28~~ 08-04-18

Fig 22. SOT1081-1 (XSON10U) package outline

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Footprint information for reflow soldering of XSON10U package   **SOT1081-1**

Generic footprint pattern
Refer to the package outline drawing for actual layout

▨ solder land

▨ solder paste deposit

▨ solder land plus solder paste

- - - - - occupied area

— · — solder resist

Dimensions in mm

P	Ay	By	C	D	Hx	Hy
0.35	1.26	0.26	0.5	0.15	1.75	1.4

Remark:
Stencil of 75 μm is recommended.
A stencil of 75 μm gives an aspect ratio of 0.77
With a stencil of 100 μm one will obtain an aspect ratio of 0.58

Fig 23.   SOT1081-1 (XSON10U) solder footprint

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XSON8: extremely thin small outline package; no leads;
8 terminals; body 1.35 x 1 x 0.5 mm

SOT1089

detail X

terminal 1
index area

(4×)(2)

(8×)(2)

terminal 1
index area

0   0.5   1 mm
scale

Dimensions

Unit		A[1]	A₁	b	D	E	e	e₁	L	L₁
mm	max	0.5	0.04	0.20	1.40	1.05			0.35	0.40
	nom			0.15	1.35	1.00	0.55	0.35	0.30	0.35
	min			0.12	1.30	0.95			0.27	0.32

Note
1. Including plating thickness.
2. Visible depending upon used manufacturing technology.

sot1089_po

Outline version	References				European projection	Issue date
	IEC	JEDEC	JEITA			
SOT1089		MO-252				~~10-04-09~~ 10-04-12

Fig 24. SOT1089 (XSON8) package outline

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Footprint information for reflow soldering of XSON8 package   **SOT1089**

Dimensions in mm

solder paste = solder land

solder resist

occupied area

sot1089_fr

Fig 25. SOT1089 (XSON8) solder footprint

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