

Qualpack TSC87251G2D

Qualification Package

TSC87251G2D / TSC83251G2D

0.5 µm SCMOS3 Technology



TSC87251G2D 0.5 µm SCMOS3 1999 October

TEMIC SEMICONDUCTORS IS AN ATMEL COMPANY



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1. General Information

1.1 Product Description

Product Name: TSC87251G2D / TSC83251G2D

Function: 8/16-bit Microcontrollers

32K EPROM / 32K ROM

Wafer process: Z94 (SCMOS 3 NV) / Z92 (SCMOS 3)

Available plastic package types: Wide range of packages including PLCC44,

PDIP40, PQFP44, TQFP44, VQFP44

Other forms Multiple Hermetic Packages, Die, Wafer

Locations:

Process, product development TEMIC Semiconductors Nantes, France

Wafer plant TEMIC Semiconductors Nantes, France QC responsibility TEMIC Semiconductors Nantes, France Assembly GATEWAY, Philippines - ASE, Taiwan

CHINTEIK, Thailand - ANAM, Korea and Philippines

CHIPPAC, China

Probe test TEMIC Semiconductors Nantes, France Final test GATEWAY, Philippines - ASE, Taiwan

ANAM, Korea and Philippines

Shipment control GLOBAL LOGISTICS CENTER, Philippines
Quality Assurance TEMIC Semiconductors Nantes, France
Reliability testing TEMIC Semiconductors Nantes, France
Failure analysis TEMIC Semiconductors Nantes, France

Product Quality Management Nantes

Signed:

Pascal LECUYER

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2. Technology Information

2.1 Wafer Process Technology

2.1.1 SCMOS3 0.5um ROM Process

Process type (Name): CMOS (SCMOS3 - Z92)

Base material: Bulk

Wafer Thickness (final) 475 µm Wafer diameter 150 mm

Number of masks 16

Gate oxide

Material Silicon dioxide

Thickness 110 A (optical - 120A electrical)

Polysilicon

Number of layers 1

Thickness 3000 A

Metal

Number of layers 3

Material Ti + TiN + AlCu

Layer 1 thickness 300A + 600A + 5000A + 250A TiN

Layer 2 thickness 300A + 600A + 5000A + 250A TiN

Layer 3 thickness 300A + 600A + 6500A + 250A TiN

Passivation

 $\begin{array}{ll} \text{Material} & \text{SiO}_2 \, / \, \text{Si}_3 \text{N}_4 \\ \text{Thickness} & 3000 \text{A} \, / \, 7000 \, \, \text{A} \end{array}$

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2.1.2 SCMOS3 NV 0.5um EPROM Process

Process type (Name): CMOS (SCMOS3 NV - Z94)

Base material: Bulk

Wafer Thickness (final) 475 µm Wafer diameter 150 mm

Number of masks 22

Gate oxide

Material Silicon dioxide

Thickness 110 A (optical - 120A electrical)

Polysilicon

Number of layers 2

Thickness Poly1 2000 A (amorphous) Thickness Poly2 3000 A (polysilicon)

Metal

Number of layers 3

Material Ti + TiN + AlCu + TiN

Layer 1 thickness 300A Ti + 600A TiN + 5000A AlCu+ 250A TiN
Layer 2 thickness 300A Ti + 600A TiN + 5000A AlCu+ 250A TiN
Layer 3 thickness 300A Ti + 600A TiN + 6500A AlCu+ 250A TiN

Passivation

Material SiO_2 / Nitride Oxide Thickness 3000A /15000 A

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2.2 Product Design

Die size For TSC87251G2D: 17.84 mm² (4250 μm * 4400 μm)

For TSC83251G2D: 17.84 mm^2 (4250 μ m * 4400 μ m)

Pad size 84 μm * 84 μm

Logic Effective channel length 0.42 µm

Gate poly width 0.5 μm
Gate poly spacing 0.6 μm

Contact size 0.6 µm

Via 1 size $0.6 \, \mu m$ Via 2 size $0.7 \, \mu m$

2.3 Package Technology

2.3.1 Package description

Depending on the customer's need. For information, the following data concern the PLCC 44.

Package weight 2.34g
Chip separation method Sawing

Lead frame

Material Cu Thickness 10 mils

Size 270*270 mils²

Lead plating Electroplated Sn/Pb 85/15

Die attach

Material Silver epoxy

Type Ablestick 84-1 LMIS

Wire bonding

Material Gold Diameter 33um

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Qualpack TSC87251G2D

Method Thermosonic

Molding

Material Sumitomo EME 6300HS

Flammability rating UL94V-0

Marking

Method Printed ink

Coding example T

optional special customer marking

TSC83C51RB2-MCA

© INTEL 80,82 Date-code Lot nbr

Dry packing No

Tube packed

Primary Tube

Material Antistatic PVC

Number per unit 27 Secondary Box

Material Cardboard

Number per unit 972

Labeling (minimum) Device type, Quantity, Date Code, Production code

Bar coding Code 39 to EIA-556-A

2.3.2 Other available packages

PQFP, PDIP, CQFP, CERDIP

No dry pack required

TQFP, VQFP

Dry pack required

2.4 Test

Probe equipment SCHLUMBERGER ITS9000 / S15

Probe temperature 85°C

Test equipment SENTRY 15

Test temperature

Commercial range 25°C

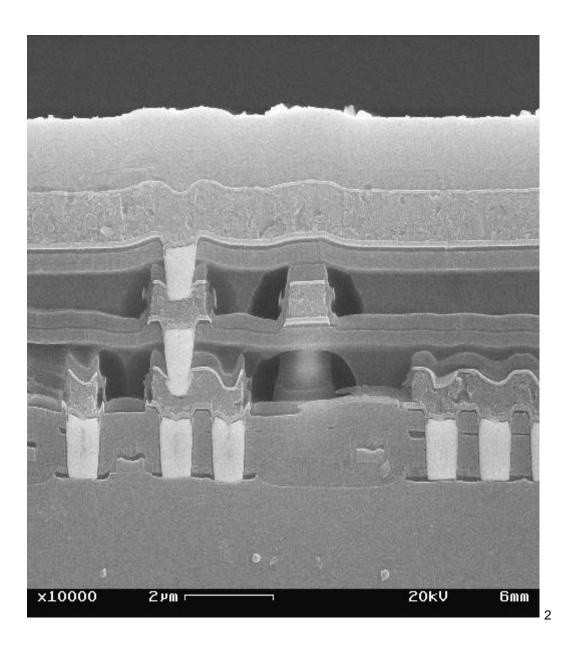
Industrial range 25°C and optional 85°C

Automotive range 25°C, 125°c and optional -40°c

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2.5 Device Cross Section



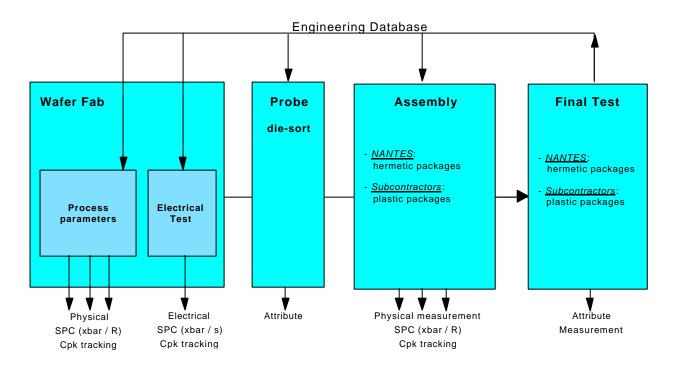
Final Z92 Cross Section

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2.6 Wafer Process Control

All the inspections and controls are defined as a process step in the production management software, and are led by using a centralized SPC software. PC system could be summarized as follows:

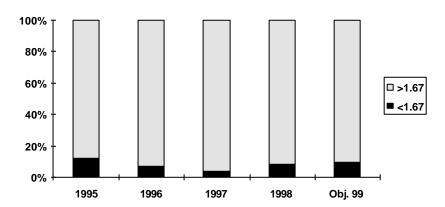


Critical process parameters are identified by using F.M.E.A. and other advanced tools.

Those parameters are followed in real time with the SPC methodology and their capability is measured and monthly reported in the Operation Review.

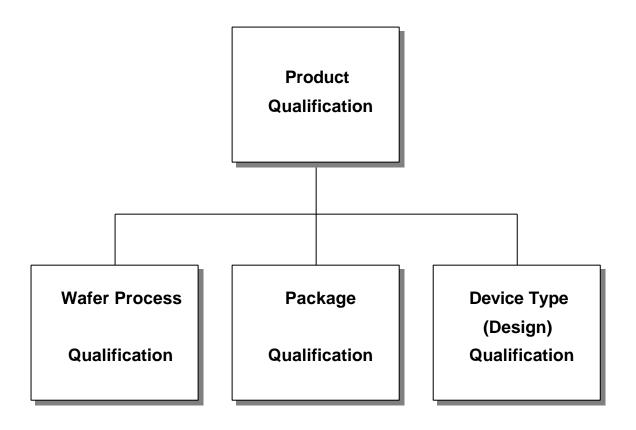
For end 1999, the Cpk target is the following:

% of all parameters per Cpk categories





3. Qualification



All product qualifications are split into three distinct steps as shown above. This same procedure is also used to qualify a change. Before a product is released for use, it must have been manufactured using a qualified wafer and package process. Before a device is released for production processing, it must also have successfully completed its required specific qualification.

The standard tests which are used for this procedure are shown in the section "Qualification Flow".

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3.1 Change Procedure

All changes are controlled by PCN (Product Change Notice). All major changes are notified to the customers affected by the change.

A major change is defined as a change that requires evidence of no electrical, mechanical impact on the product, or a change in the specification or marking of the product or packing. The list of changes usually considered as major is detailed hereafter:

1	General Major Changes
1-1	Manufacturing line
1-2	Sequence of fabrication process cycle
1-3	Material type
1-4	Electrical parameter
1-5	External physical dimension
1-6	Die size

2	Changes specific to wafer fabrication area
2-1	Doping method
2-2	Gate oxide formation method
2-3	Equipment change
2-4	Layer Thickness
2-5	Module dimensions

3	Changes specific to to assembly process area
	Sawing method
3-2 3-3	Die attach
3-3	Wire interconnect tools
	Molding process
3-5	Tinning method

4	Changes specific to test area
4-1	Specification limit
4-2	Test coverage reduction
4-2	Product identification
4-3	Final conditioning

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3.2 Qualification Flow

General Requirements for Plastic packaged CMOS IC

Standard	Test Description	Qualification type (acceptance)
MIL-STD 883D Method 1005	Electrical Life Test (Early Failure Rate) 12 hours 150°C (Tj) 5.75V	Device (1/2000 12h)
MIL-STD 883D Method 1005	Electrical Life Test (Latent Failure Rate) 1000 hours 150°C 5.75V Dynamic or Static	Device (0/100 500h)
MIL-STD 883D Method 3015.7	Electrostatic Discharge HBM +/-2000v 1.5kOhm/100pF/3 pulses	Device (0/3 per level)
JEDEC 78	Latch up 50mW power injection 125°C	Device (0/10)
MHS PAQA0046	NV Memory Dataretention High Temperature Storage 165°C	Device (0/50 500c)
MIL-STD 883D Method 1010	Temperature Cycling 1000 cycles -65°C/150°C air/air	Die and Package (0/50 500c)
MHS PAQA0184	Pressure Pot after Mounting Stress 168 hours 130°C/85%RH	Die and Package (0/50 168h)
EIA JESD22-A101	85/85 Humidity Test 1000 hours 85°C/85%RH	Die and Package (0/50 500h)
EIA JESD22-A110	HAST 336 hours 130°C/85%RH/5.5V	Die and Package (0/50 168h)
EIA JEDEC J-20-STD	Moisture Sensitivity Ranking Infra Red Stress 220°C/235°c/3 times	Package (0/10 per class)
MIL-STD 883D Method 2003	Solderability	Package (0/3)
MIL-STD 883D Method 2015	Marking Permanency	Package (0/5)

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3.3 Wafer Process Qualification

3.3.1 Process Module Reliability

This chapter contains all the information relative to the reliability of the SCMOS3 technology. Results presented in the following sections concern the reliability of the basic process steps that build up the technology.

3.3.1.1 Hot carrier qualification

STATIC NMOS DEGRADATION

Channel length in µm	0.5	0.55	0.6	0.65	0.7	0.5
Process corner	Fast	Fast	Fast	Fast	Fast	Typical
Substrate current in μA/μm VD=5.5v, VG=2.25v	17	15	13.4	12.1	11.1	14.7
Substrate current in μA/μm VD=3.6v, VG=1.6v	0.35	0.3	0.25	0.22	0.2	0.3
Lifetime in seconds for 10% shift of Gm at VD=5.5v	3.2e3	3.7e3	4.2e3	4.7e3	5.2e3	3.8e3
Lifetime in seconds for 10% shift of Gm at VD=3.6v	8e7	10e7	12e7	14e7	16e7	10e7

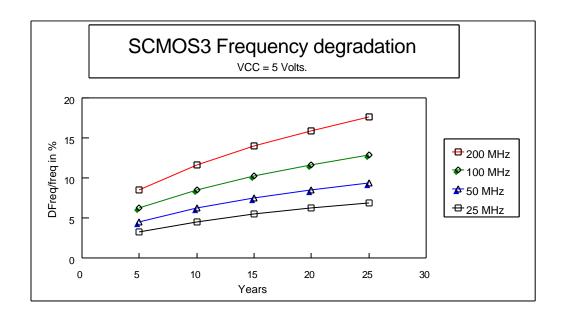
STATIC PMOS DEGRADATION

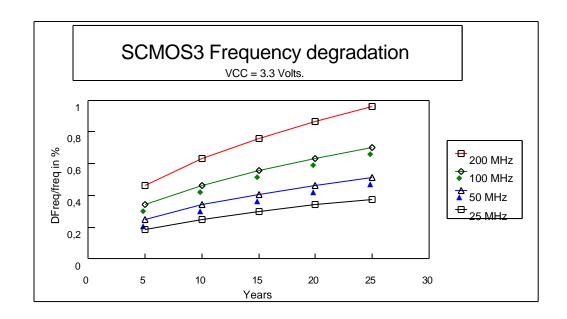
Channel length in µm	0.5	0.55	0.6	0.65	0.7	0.5
Process corner	Fast	Fast	Fast	Fast	Fast	Typical
Substrate current in μA/μm VD=5.5v, VG=2.25v	0.31	0.28	0.25	0.22	0.21	0.24
Substrate current in μA/μm VD=3.6v, VG=1.25v	2.3e-3	1.9e-3	1.6e-3	1.4e-3	1.1e-3	1.6e-3
Lifetime in seconds for 10% shift of Gm at VD=5.5v	2.7e4	3.1e4	3.5e4	3.9e4	4.3e4	3.5e4
Lifetime in seconds for 10% shift of Gm at VD=3.6v	2e7	2.5e7	3e7	3.8e7	4.6e7	3.2e7

EXPERIMENTAL RESULTS IN DYNAMIC MODE: hot carrier degradation effects on inverter propagation time have been measured on oscillators running at 75 MHz at 7v and 6.5v. Accelerator factor in voltage is then carried out and expected degradation laws at 5v and 3.3v derived. The following graphs show the frequency degradation of oscillators running at 5v and 3.3v.

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3.3.1.2 Electromigration

Characterization

Stresses of electromigration are achieved for 1000 hours on 32 packaged metal line running on flat with a current density of $2x10^6$ A/cm2 at a temperature of 200° C. Lines are declared to be failed for a shift of the initial resistance by 20%. Results are summarized in the table below.

Level	W/L/T(1)	Structure	Failures
Metal1	2/2000/0.50	Ti/TiN/AICu/TiN	No
Metal2	2/2000/0.50	Ti/TiN/AICu/TiN	No
Metal3	2/2000/0.70	Ti/TiN/AICu/TiN	No

(1)W/L/T=Width/Length/Thickness of the metal line in microns

Lifetime projection

The objective of reliability is to reach less than 10FIT on metal line within 10 years at a temperature of 150°C. As no failures have been found at 1000 hours in the above stress conditions a lifetime projection in FIT is meaningless.

However, assuming for AlCu metalization an activation energy in temperature Ea of 0.60eV and an activation in current with a power-law coefficient n of 2, the current density which guarantees no failures within 10 years at 150°C can be extrapolated.

With these assumptions the projected current density for no failures at 150°C within 10 years is calculated as 5x10⁵A/cm2 which is much higher than the current density of 2x10⁵A/cm2 specified in the design rules.

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3.3.1.3 Time Dependent Dielectric Breackdown

QBD MEASUREMENT:

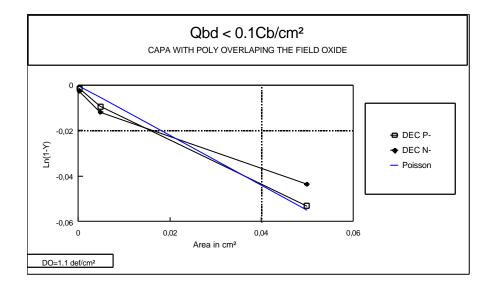
The critical charge, supported by the thin oxide and related to the extrinsic and intrinsic defects, is measured on TOX/P- and TOX/N- capacitors. The tested capacitor areas are varying from 4e-4 to 5e-2 cm2. Two types of capacitors with poly overlaping the field oxide (DEC) and poly non overlaping the field oxide (INC) are measured. The distributions have been obtained from 750 measurements for each area and type of capacitors on 10 different lots.

Extrinsic defects:

The two graphs here after represent the % of failures vs area for Qbd below or equal to 0.1 Cb/cm2. The law of Poisson is used to determine the D0 defect density of the extrinsic defects:

Poly overlaping the Field oxide on Tox/P- and Tox/N-:

The DO is found to be 1.1 def/cm2. This result is in agreement with the goal for D0 of 1 def/cm2.

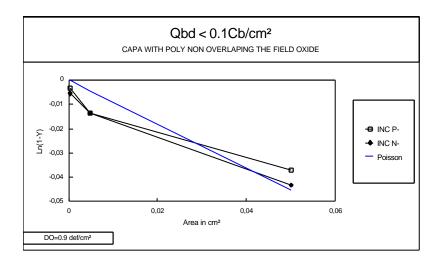


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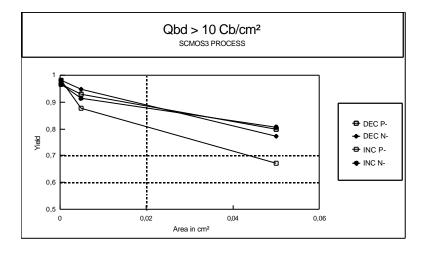
Poly non overlaping the Field oxide on Tox/P- and Tox/N-:

The DO is found to be 0.9def/cm2. This result is in agreement with the goal for D0 of 1 def/cm2.



Intrinsic defects:

The graph here after represents the percentage of failure for a Qbd > 10 Cb/cm² vs the area. The worst case given by the bigest capacitors shows that 67% of the total distribution has a Qbd > 10 Cb/cm². This result guarantees a good reliability behaviour. The critical charge, supported by thin oxide and related to the extrinsic defects, is measured on TOX/P- capacitors of 42570um2 and TOX/N- capacitors of 85140um2. Following are the average results obtained on recent lots from a distribution of about 60 sites per wafer. The minimum specification limit is 10C/cm2.



Conclusion:

The QBD results demonstrate high reliability level of SCMOS3 thin oxide.

D 0 0 1 1 1000



3.3.2 Z92 Wafer Process Qualification Results

This section summarizes the cumulated reliability data of 0.5um microcontrollers ROM technology.

Lots	Device Type	Test Description	Step	Result	Comment
Z27746A	TSC251G2D	EFR Dynamic Life Test	12h	3/2661	Poly particle Metal3 defect
		LFR Life Test	500h 1000h	0/100 0/100	
Z27735A Z29249	TS80C32X2	EFR Dynamic Life Test	12h	11/11712	Contacts alignment
Z29683C Z29936		LFR Life Test	500h 1000h	0/699 0/699	
Z27300A Z27880A	TS83C51RC2	EFR Dynamic Life Test	12h	5/7318	Passivation scratch Poly particle
Z28109A		LFR Life Test	500h 1000h	0/200 0/200	Silicon breakdown
Z26274A Z26407	TS83C51RX2	EFR Dynamic Life Test	12h	3/2238	
Z27291A		LFR Life Test	500h 1000h	0/173 0/173	
Global	All products	EFR Dynamic Life Test Commercial / Industrial	12h	22/23929	919 ppm (828 ppm / 10 mm2)
		Automotive (1)	24h 168h	0/3564 0/1172	Oppm
		LFR Life Test	500h 1000h	0/1172 0/1172	4.7 fit (3.0 fit / 10mm2)

Note (1): The additional operations included in the automotive backend flow allow to reduce significantly the Early Life Failure Rate. As long as needed to achieve the Automotive Quality Assurance requirements, these operations may be any of those described hereafter:

- Statistical wafer sort
- Accelerated Dynamic Burn-in at probe
- Probe critical parameters 3 sigma sort
- Part Average Testing
- Dynamic Burn-in of products
- Other equivalent methods

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3.3.3 Z94 Wafer Process Qualification Results

This section summarizes the cumulated reliability data of 0.5um microcontrollers EPROM technology.

Lots	Device Type	Test Description	Step	Result	Comment
Z27314A Z27748	TSC87251G2D	EFR Dynamic Life Test LFR Life Test	12h 24h 500h	4/3772 0/360 1/150	Poly bridging, Interlayer oxide defect, functional not identified, metal 2 photo etch bridging
Z28233C	TSC87C51RB2	EFR Dynamic Life Test LFR Life Test	12h 24h 500h 1000h	1/1663 0/323 0/100 0/97	Functional not identified
Z28090B Z28987 Z29142 Z29311D Z29568B	TSC87C51RC2	EFR Dynamic Life Test LFR Life Test	12h 24h 500h 1000h	8/11533 0/1284 0/500 0/500	Poly particle Contact misalignment Capacitor oxide defects
Z28303C	TSC87C51RD2	EFR Dynamic Life Test LFR Life Test	12h 24h 500h 1000h	2/953 0/324 0/100 0/100	Poly particle
Z28430A	TSC87C52X2	EFR Dynamic Life Test LFR Life Test	12h 24h 500h 1000h	2/2333 0/297 0/100 0/100	Functional not identified
Global	All products	EFR Dynamic Life Test Commercial / Industrial Automotive (1)	12h 24h 168h	17/20254 0/2588 0/950	839 ppm (705 ppm / 10mm2) 0ppm
		LFR Life Test	500h 1000h	1/950 0/797	14.2 fit (11.6 fit / 10mm2)

--- 0 Outstand 1000



3.4 Package Qualification

This section summarizes the initial package qualification data of TSC87251G2D and TSC87251G2D products in PLCC44.

Lots	Device Type	Test Description	Step	Result	Comment
Z27314A	TSC87251G2D	85/85 Humidity	500h	0/50	
	PLCC44		1000h	0/50	
		Moisture Sensitivity	L1	0/10	Pass level 1 of J-20-STD
		Ranking			
		HAST after Soldering	15c	0/50	
		Stress	168h	0/50	
Z27746A	TSC83251G2D	Thermal Cycles	500c	0/50	
	PLCC44		1000c	0/50	
		HAST after Soldering	15c	0/50	
		Stress	168h	0/50	

3.5 Device Qualification

This section presents the qualification results of TSC87251G2D/TSC83251G2D devices.

Lots	Device Type	Test Description	Step	Result	Comment
Z27314A	TSC87251G2D	EFR Dynamic Life Test	12h	2/1978	Interlayer oxide defect
	PLCC44		24h	0/360	Polysilicide particle
			168h	0/150	
		LFR Life Test	500h	1/150	Metal 2 photo etch bridging
			1000h		
		High Temp. Retention	500h	0/50	
			1000h	0/50	
Z27746A	TSC83251G2D	EFR Dynamic Life Test	12h	3/2661	Polysilicide particle
	PLCC44		24h	0/211	Metal 3 defect
			168h	0/100	
		LFR Life Test	500h	0/100	
			1000h	0/100	

Lots	Device Type	Test Description	Step	Result	Comment
Z26629	TSC87251G2D	ESD HBM	2000V	3/3	Class 1 of MIL883
		Latch up Overvoltage Power injection	10V 50mW	0/5 0/5	Latch-up free
Z27746	TSC83251G2D	ESD HBM	2000V 3000V	0/3 0/3	Class 2 of MIL883
		Latch up Overvoltage Power injection	10V 50mW	0/5 0/5	Latch-up free

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Comments:

No reject observed during package qualification tests.

One reject in LFR, but physical analysis demonstrated the failure was wafer process dependant and not related to the device itself. As a consequence it was not charged for device qualification.

3.5.1 Failure Mechanisms and Corrective Actions

As part of TEMIC continuous improvement policy, all defects are analysed. For all failure mechanisms identified, root causes ranked regards number of occurencies and criticity are investigated and addressed by corrective actions.

Failure Mechanism	Root Cause	Corrective Action	Date	Effect	Check of Efficiency
56% Contacts misalignment	RTA drift	Upgrade of RTA equipment	06/99	reduce alignment scattering	Visual inspection, yield - 07/99
26% Poly defects	Defect density at Poly level	# Hard mask : replacement of PR Titane mask by masking buffers during Ti deposition for # polysilicideBARC (Bottom Anti-Reflective	10/98	Reduction of defect density at Poly level Improve Poly dimension control	Yield EFR - 12/98 Yield EFR - 12/98
		Coating) # PR strip optimization	03/99	Defect density reduction	EFR - 05/99
6% Metal particles	PR strip process	# PR strip method optimized # Equipment upgrade (Semitool)	03/99 07/99	Reduction of the defect density	Yield – EFR 05/99
6% Passivation	Marginal	, ,			
6% Silicon breakdown	Marginal				

3.5.2 Qualification status

The 0.5um logic wafer process was qualified on 1997 September. The qualification was extended to OTP microcontrollers (SCMOS3 NV) process on 1999 April.

The TSC83251G2D was qualified on 1999 January, and OTP version TSC87251G2D was full qualified on 1999 April.

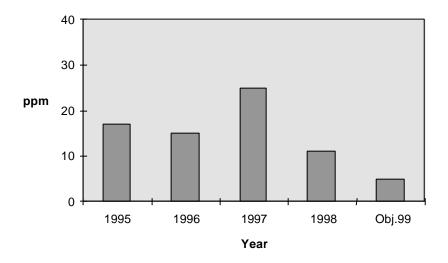
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3.6 Outgoing Quality and Reliability

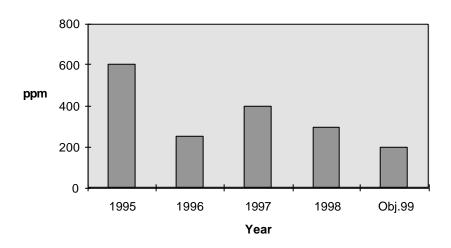
3.6.1 AOQ (Average Outgoing Quality)

The AOQ is measured following 100% test by sampling outgoing product. The results of this inspection are recorded in ppm (parts per million) using the method defined in JEDEC 16. The figures below cover the last years for both the subject and structurally similar products.



3.6.2 EFR (Early Failure Rate)

The EFR is measured on a sample of devices by operating them at an elevated temperature and measuring the number which fails to meet specification after 12 hours at 150°C. The figure is expressed in terms of ppm.

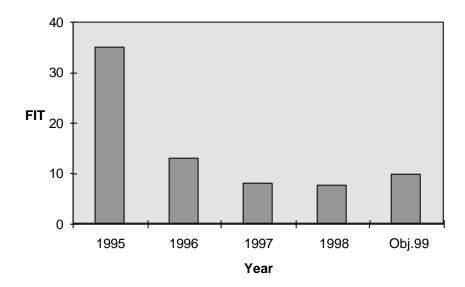


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3.6.3 LFR (Latent Failure Rate)

The LFR is measured by operating devices at elevated temperatures for 1000 hours and measuring the failure rate. Using the Arrhenius law, the expected failure rate at a operating temperature of 55°C is calculated using an activation Energy of 0.6 eV with a confidence level of 60%. This is expressed in units per billion hours (FIT). The figures given are for the subject and structurally similar products.



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4. User Information

4.1 Soldering Recommendations

For DRY PACKED products, TEMIC recommends to strictly follow the procedure described hereunder:

- Dry packed products must not be stored more than 1 year at 40°c 90%rh (worst storage conditions assumed)
- A longer storage period is allowed taking into account the following conditions: 5 years max at 25°c (+/-5°c) 50%rh
- From opening of the packs, the product must be assembled within 48 hours. (worst in-process storage condition assumed: 30°c 60%rh)
- If they cannot be soldered within this time period, then the pieces must be dryed at 125°c for 24 hours. Only one drying is allowed.
- Max relative humidity allowed in the bag is 20% (readable on the indicator inside the bag). If this value is reached, then the parts must be dryed at 125°C for 24 hours before mounting.
- For high sensitive products, the delay between pack openning and assembly is reduced to 6 hours (Level 6 of JEDEC 22-A112). In this case, a warning printed on each pack advises the user of this restriction.

4.2 DRY PACK Ordering rules

TEMIC qualification procedure allows to classify products according to JEDEC 22-A112 and to determine the convenient conditioning for safe customer use.

Nevertheless, even if the product is not classified as moisture sensitive, it is possible (for example if storage conditions are not properly controlled) to order product with a Dry Pack.

4.3 ESD caution

The user must protect components against EOS and ESD damages by grounding personal and workstations.

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5. Environmental Information

The TEMIC Environmental Policy aims are:

- Reducing the use of harmful chemicals in its processes
- Reducing the content of harmful materials in its products
- Using re-cyclable materials wherever possible
- Reducing the energy content of its products

As part of that plan, Ozone Depleting Chemicals are being replaced either by TEMIC MHS or its sub-contractors' process.

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6. Other Data

6.1 ISO9001 Approval Certificate



N° QUAL/1991/275

L'AFAQ certifie que le système qualité adopté par. AFAQ certifies that the quality system developed by :

MATRA MHS

pour les activités suivantes, for the following activities :

CONCEPTION ET PRODUCTION DE CIRCUITS INTEGRES ET ASICS.

DESIGN AND PRODUCTION OF INTEGRATED CIRCUITS AND ASICS.

exercées sur le(s) site(s) sulvent(s), carried out in the following (ocalion(s) :

La Chantrerie F-44087 NANTES

a été évalué et jugé conforme aux exigences de le norme, has been assessed and found to conform to the requirements of the standard :

ISO 9001 (1994)

Le présent certificat, délivré dans les conditions fixées par l'AFAQ, est valable jusqu'au.
This certificate, delivered under AFAQ rules, is valid until :

2000-07-17

(2000-000-000)

Segneux, k

1997-07-18

-

L4 PRESIDENT OF THE CASTIFICATION CONNECTED

The Manager Constant of Capacity

Le Representant de L'Entrepues

A. PIGEONNIES

0 55VBAT

F. FAES



6.2 Databook Reference

The datasheet is available upon request to sales representative, or on TEMIC Semiconductors web site: http://www.temic-semi.com

6.3 Address Reference

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Rev. 0 - October 1999



7. Revision History

Issue	Modification Notice	Application Date
0	Initial Product Qualification Report	1999 October

Remarks:

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