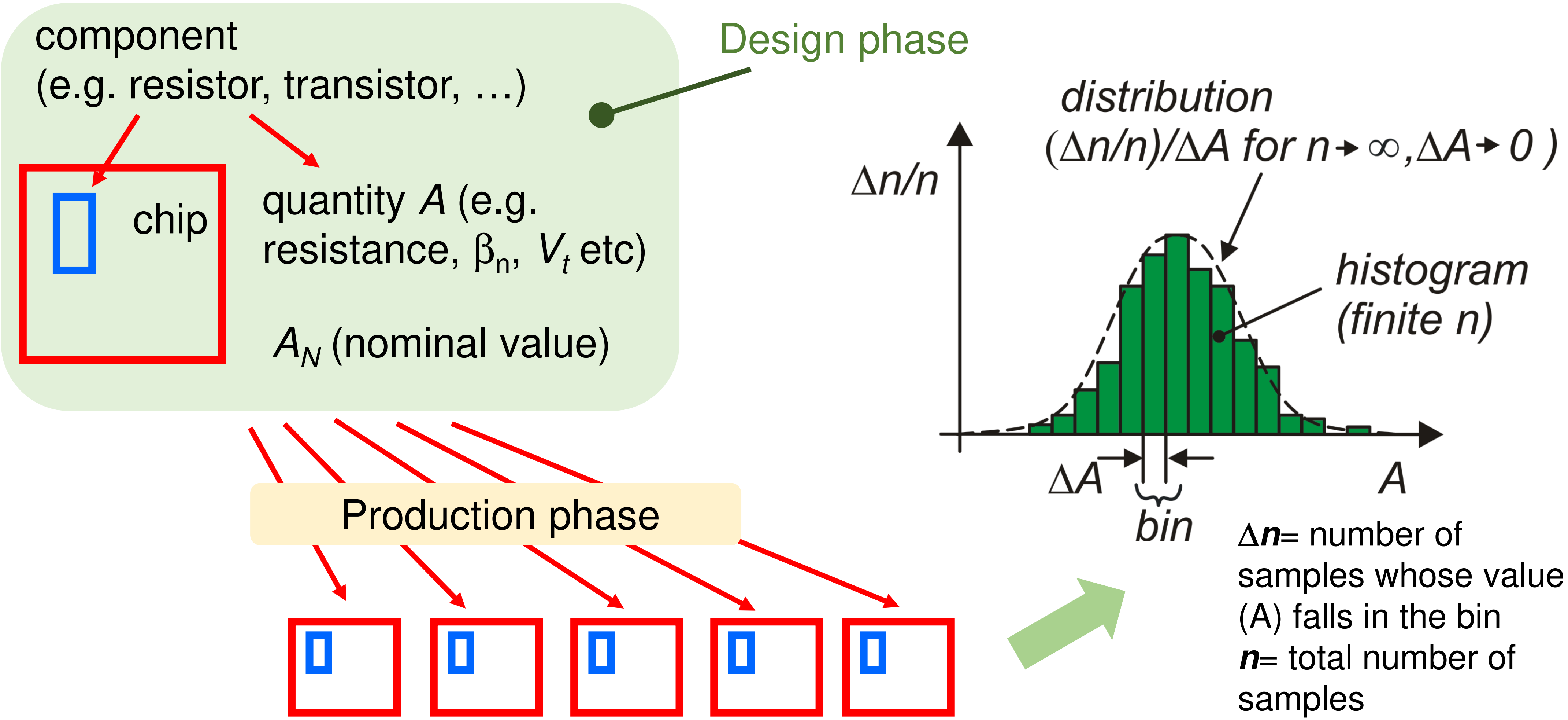
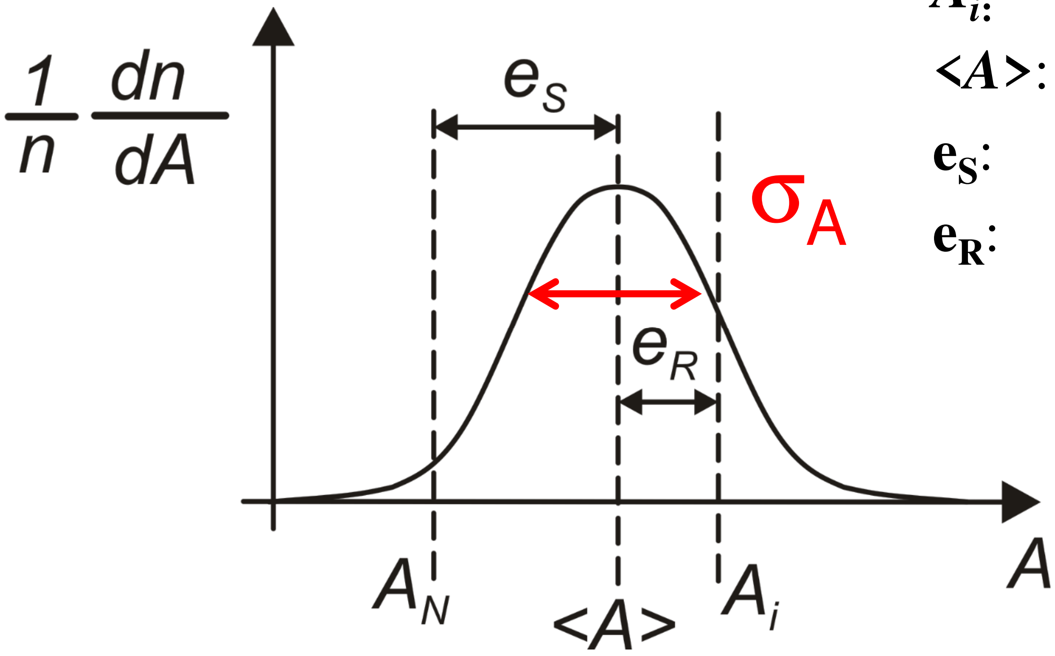
Process Errors in Integrated Circuits



Components of the error and statistical representation



A_N: nominal value

A_i: A for a generic i-th component.

$<A>$: the mean of the distribution.

$\mathbf{e_S}$: Systematic error = $<A>-A_N$

$\mathbf{e_R}$: Random error for the i-th component $\mathbf{e_R} = A_i - <A>$.

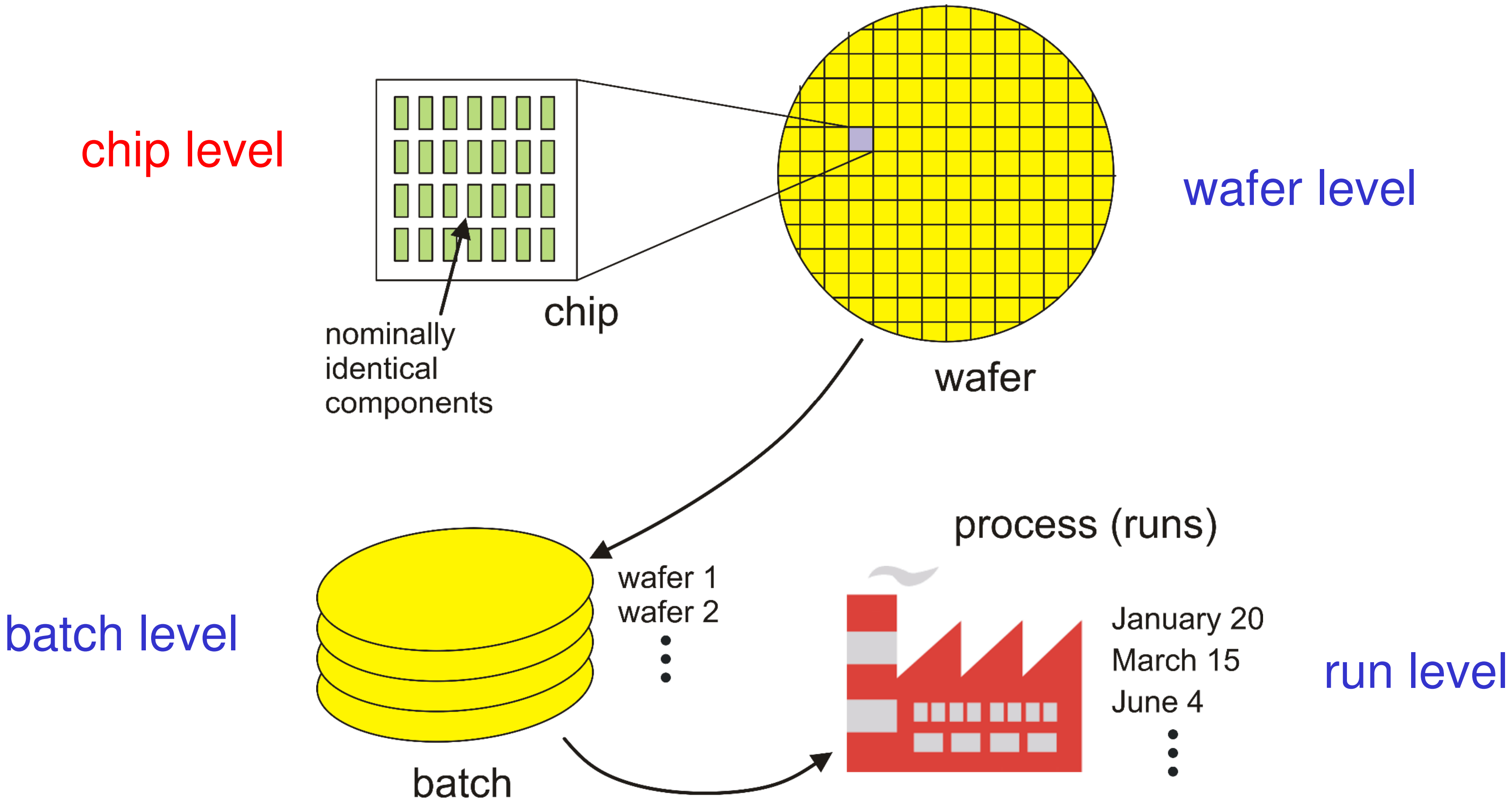
Random error: standard deviation

$$\sigma_A = \sqrt{\left\langle \left(A - <A>\right)^2 \right\rangle}$$

Confidence intervals

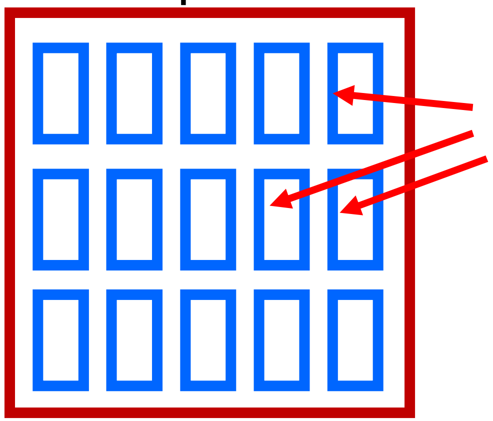
Max deviation from the mean	$\pm\sigma$	$\pm 2\sigma$	$\pm 3\sigma$	$\pm 4\sigma$
Fraction of data within the interval	68.3 %	95.4 %	99.7 %	99.994 %
Fraction of data outside the interval	31.7 %	4.6 %	0.3 %	0.006 %

Errors in Integrated Circuits: Levels



Local and global errors: means

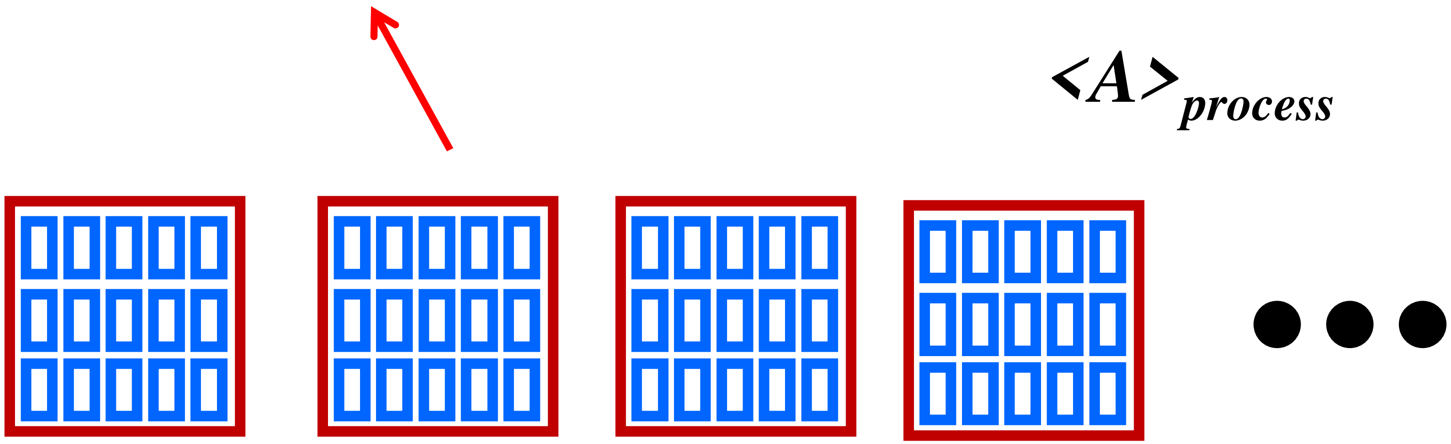
i-th chip



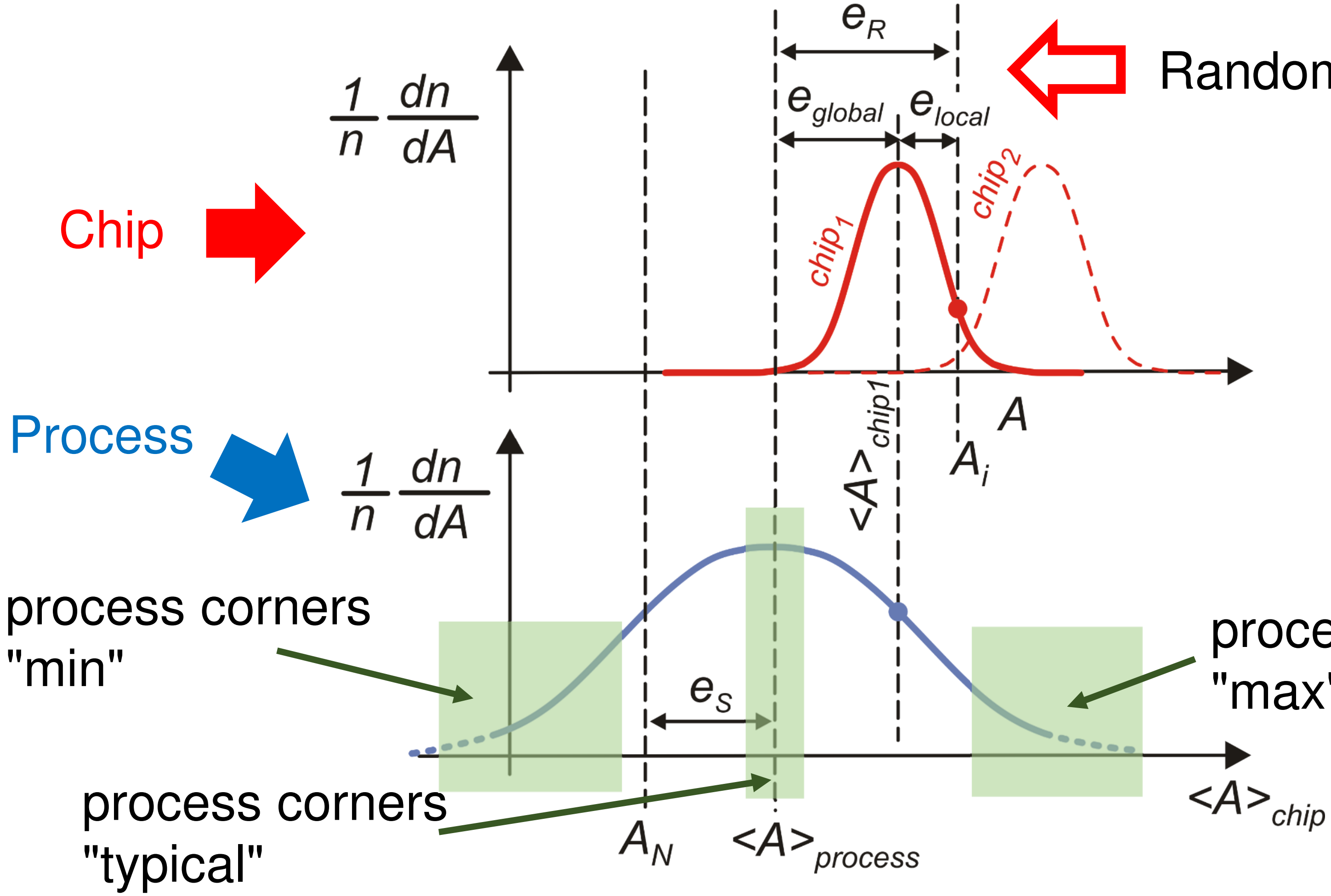
nominally identical components

$\langle A \rangle_{chip}$ varies from chip to chip (local mean)

$\langle A \rangle_{process}$ property of the whole process (global mean)



Local and global errors

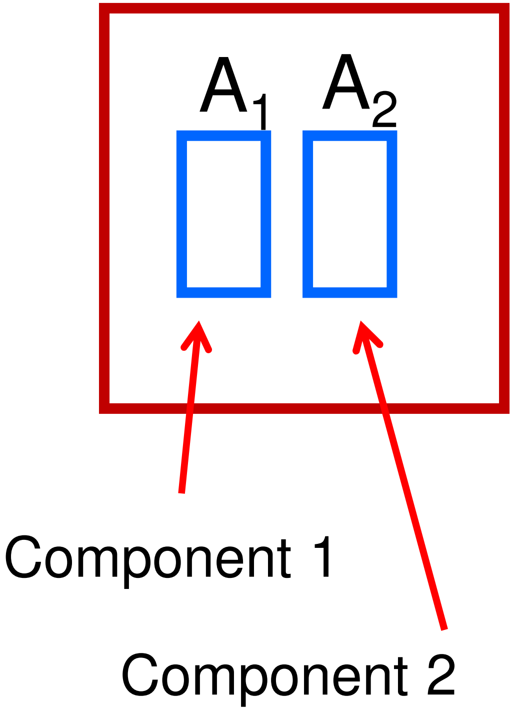


Random errors **local** and **global**

In practice, the distribution of local errors is much narrower than shown here

$$\sigma_{global} >> \sigma_{local}$$

Matching errors: definition



Matching error (or mismatch)

$$\begin{cases} \Delta A = A_1 - A_2 \\ \bar{A} = \dfrac{A_1 + A_2}{2} \end{cases} \Leftrightarrow \begin{cases} A_1 = \bar{A} + \dfrac{\Delta A}{2} \\ A_2 = \bar{A} - \dfrac{\Delta A}{2} \end{cases}$$

Nominally identical and placed on the same chip

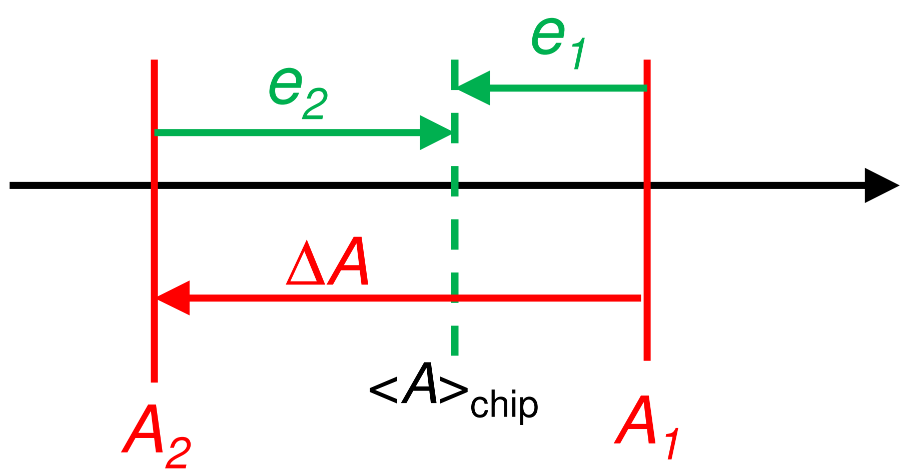
Random Matching errors: Main causes

- Microscopic irregularities (local granularity)
- Parameter gradients

Relationship between matching error and local error

$$A_1 = \langle A \rangle_{chip} + e_1$$

$$A_2 = \langle A \rangle_{chip} + e_2 \qquad \Delta A = A_1 - A_2 = e_1 - e_2$$



Matching errors: Microscopic irregularities

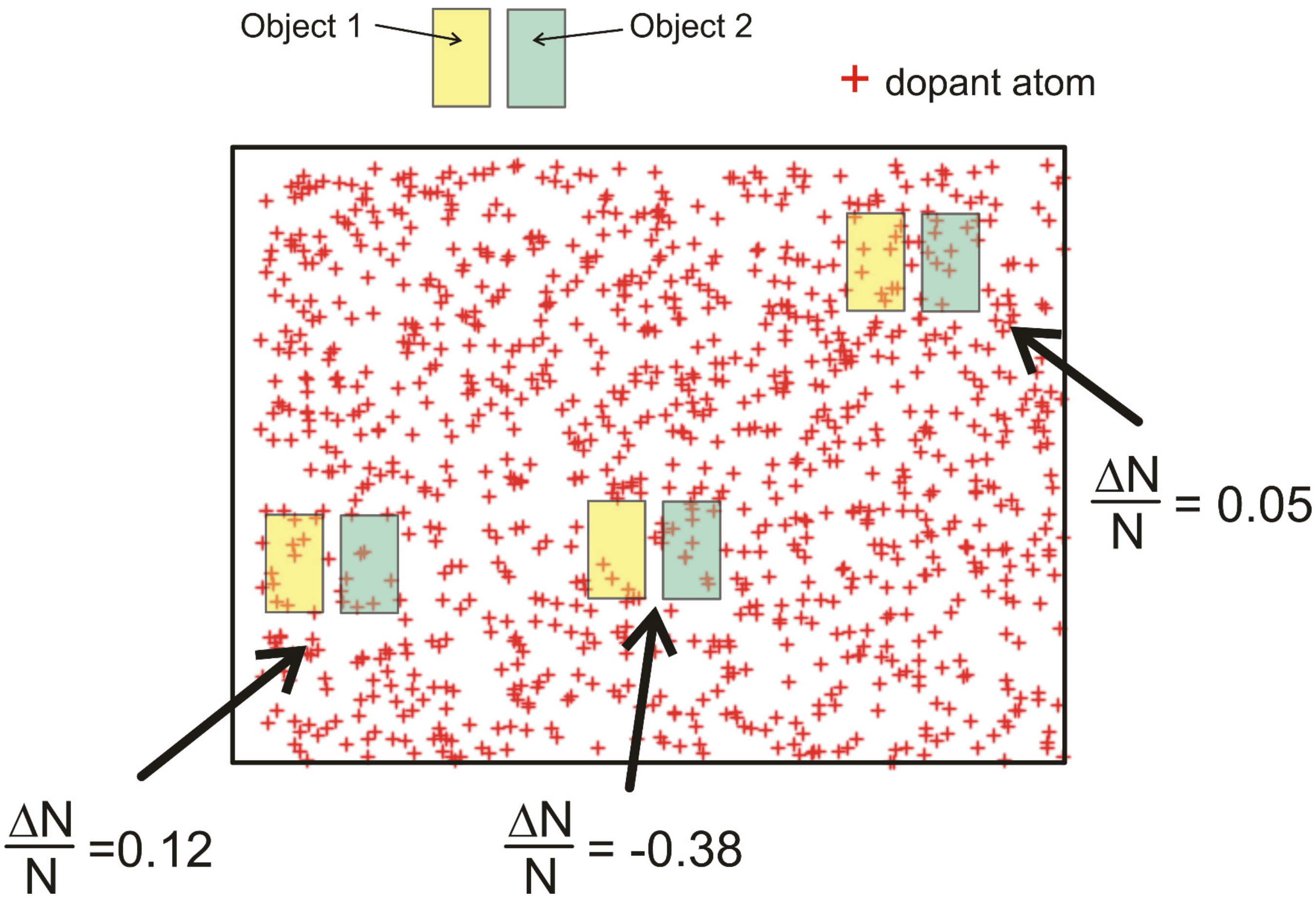
N= number of dopants atoms within the component area

$\Delta N = N_1 - N_2$ matching error

Depending on the position ΔN is subjected to large variations.

The important parameter is:
Relative matching error:

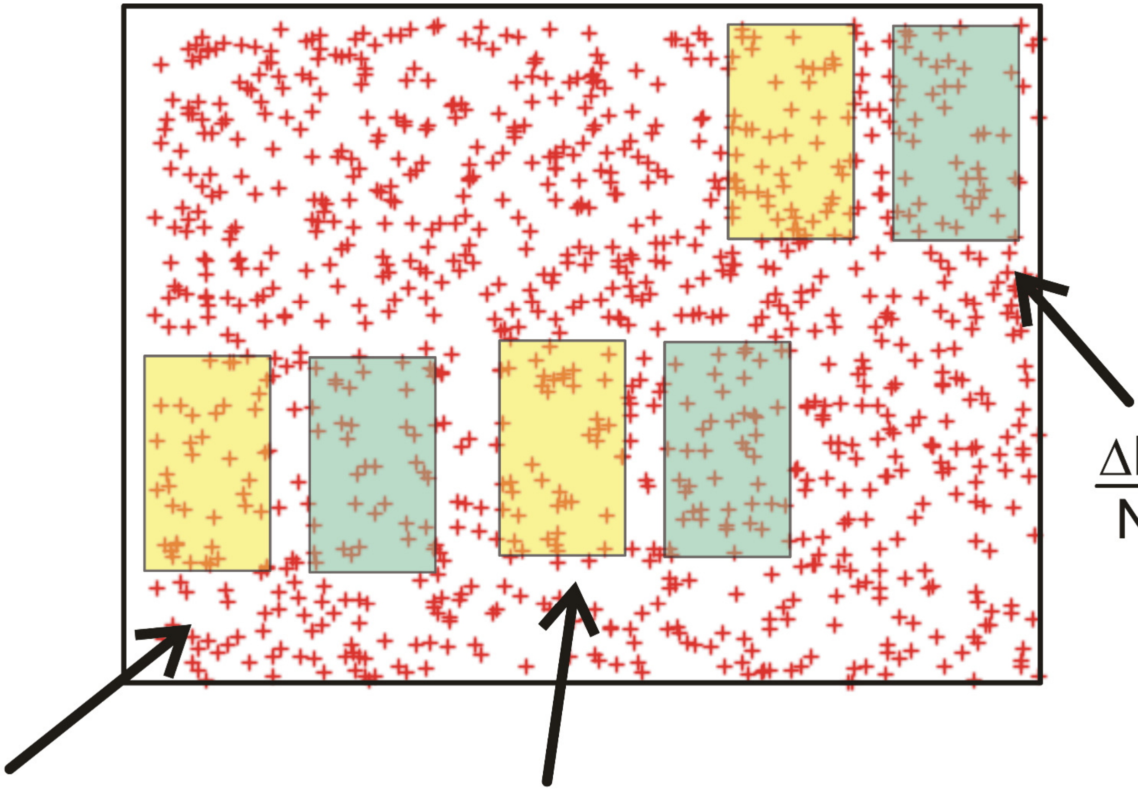
$$\frac{\Delta N}{N} \leftarrow \frac{N_1 + N_2}{2}$$



Matching errors: Microscopic irregularities

- The number of dopants atoms affects several properties such as effective sheet resistance and MOSFET threshold voltage
- The example can be replicated for other quantities, such as oxide thickness, where the crosses in the figure may represent local maxima or minima
- The large fluctuation of $\Delta N/N$ can be ascribed to the small area of the devices shown in the example. For even smaller devices its is likely that one of the two devices does not include any dopant atom : $\Delta N/N$ may exceed unity (100 % error).

Microscopic irregularities: effect of device area



Larger device areas result in smaller **relative** matching errors

$$\frac{\Delta N}{N} = 0.01$$

$$\frac{\Delta N}{N} = 0.04$$

$$\frac{\Delta N}{N} = -0.05$$

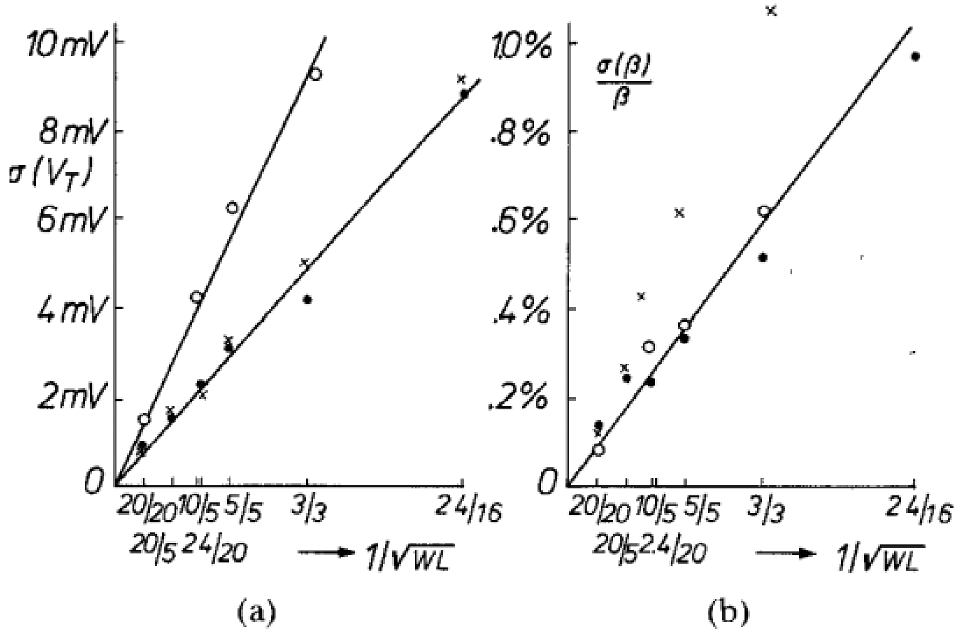
Microscopic irregularities: the Pelgrom model

$$\begin{cases} \sigma_{\Delta V_t} = \dfrac{C_{Vt}}{\sqrt{WL}} \\ \sigma_{\frac{\Delta\beta}{\beta}} = \dfrac{C_{\beta}}{\sqrt{WL}} \end{cases}$$

Mosfet

$$\sigma_{\frac{\Delta R}{R}} = \frac{C_R}{\sqrt{WL}}$$

Resistor



From: Pelgrom et a IEEE J. of Solid State Circuits, 1989l

C_{vt}, C_{β} and C_R are constant parameters of the process Their values are given in the Design Rule Manual, with names that depend on the foundry (there is no general convention).

C_{vt} units are generally V·μm, while C_{β} and C_R ones are μm.

Matching Errors: Gradients

- Gradients indicate that important quantities that affect the device properties are not uniformly distributed on a macroscopic scale. This means that these quantities gradually varies across the chip area.

- Quantities of interest can be, for example:

  -) Dopant density

  -) Oxide thickness

- -) Geometrical process biases (e.g. etching undercut)

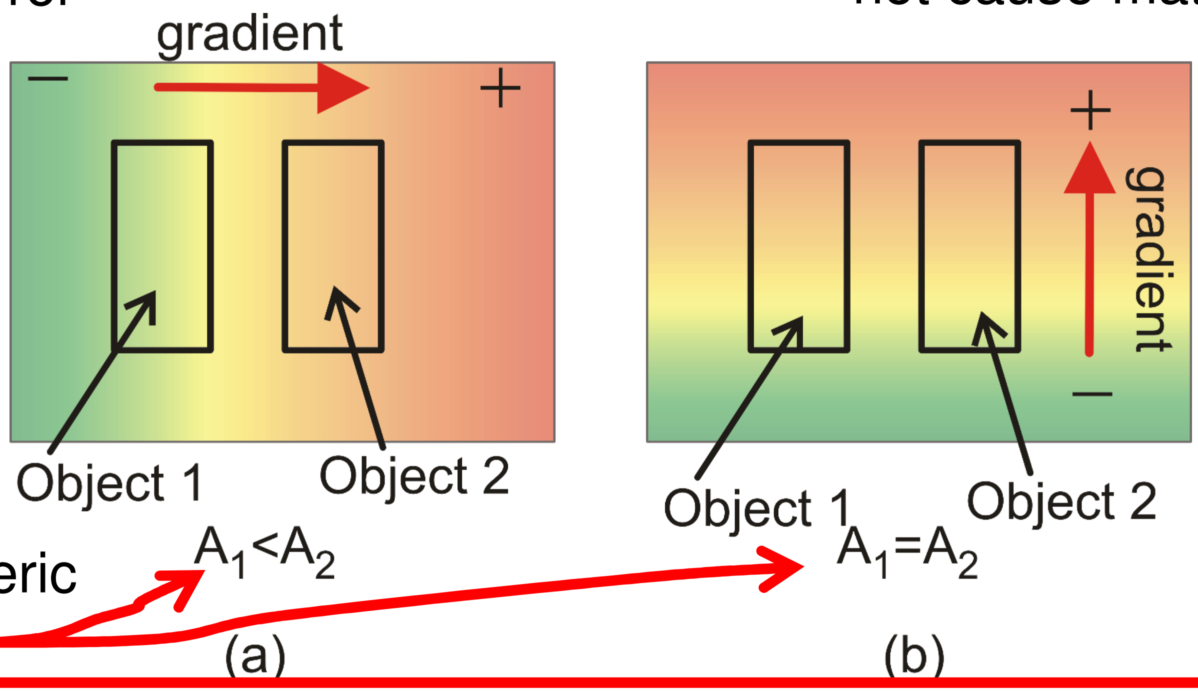
  -) Temperature (e.g. due to power devices present on the chip)

- -) Mechanical stress (mainly due to the packaging process)

Effect of gradients on device matching

In this example radient causes matching error

For this case, gradient does not cause matching error

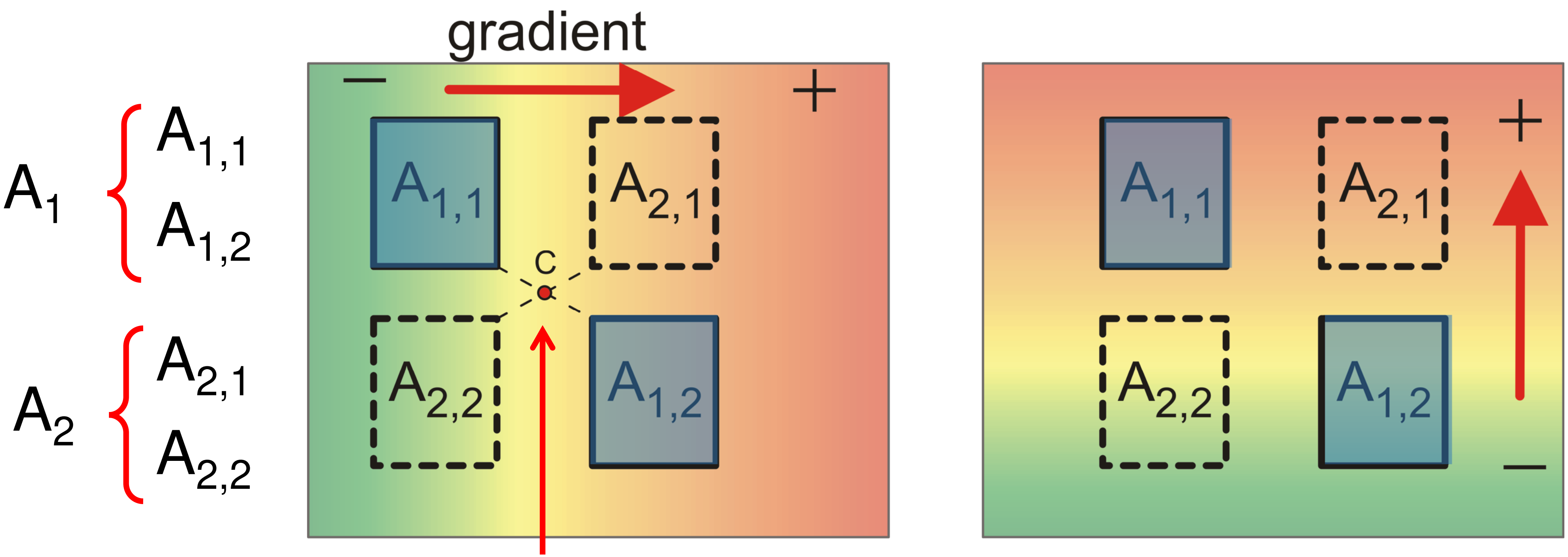


We consider a generic quantity "A"

Unfortunately, in most cases, the direction of gradients is not predictable!

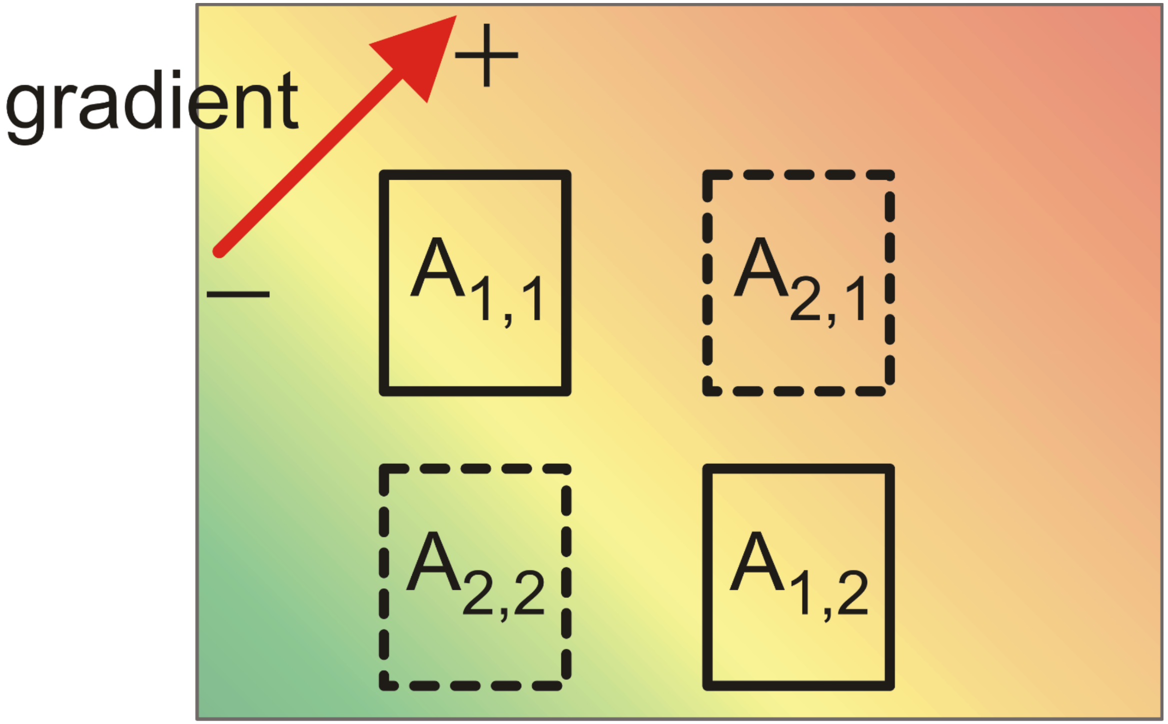
Layout rules that prevent device mismatch caused by gradients

- Rule 1 (obvious): Take the distance between objects as close as possible. (This rule is less effective for large devices)
- Rule 2: Use <u>common centroid</u> configurations.



Centroid of both A_1 and A_2 objects

Common centroid configuration: Oblique gradients



component	part	level
A_1	$A_{1,1}$	average
	$A_{1,2}$	average
A_2	$A_{2,1}$	high
	$A_{2,2}$	low

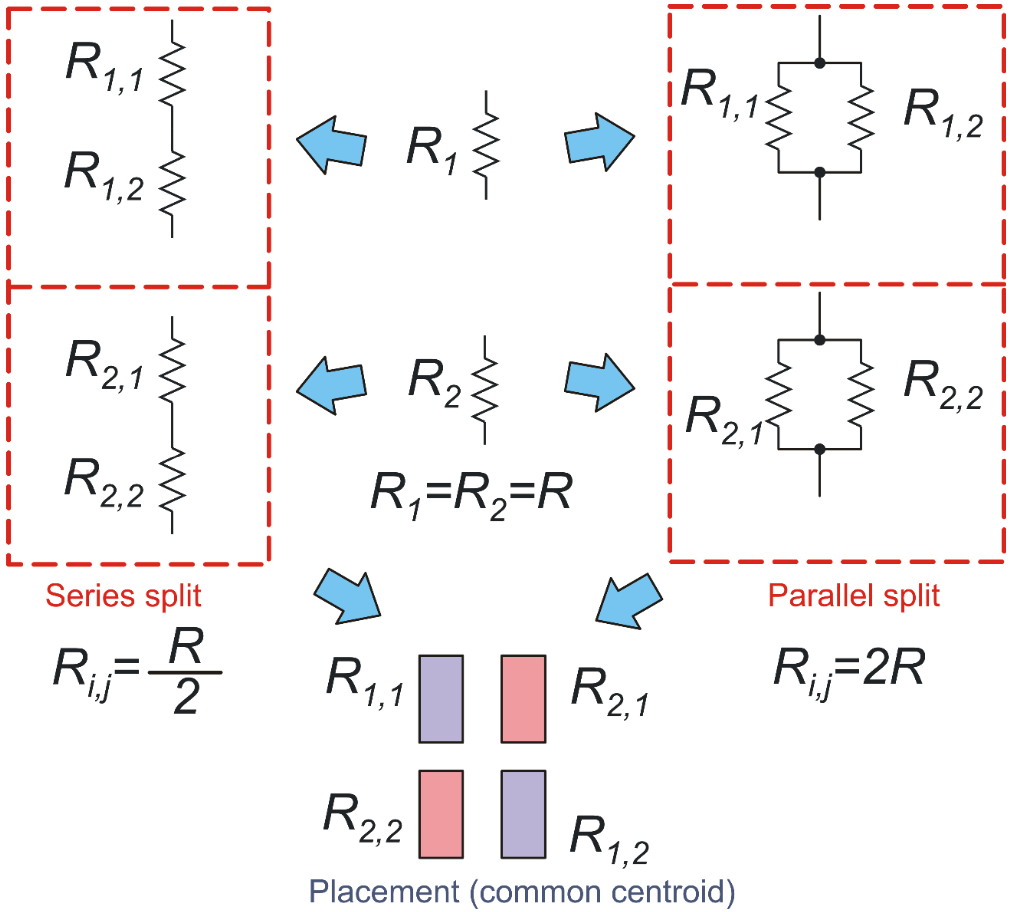
The common centroid configuration is effective also against oblique gradients..

Split and connect components in common centroid configurations

Case 1::Resistors

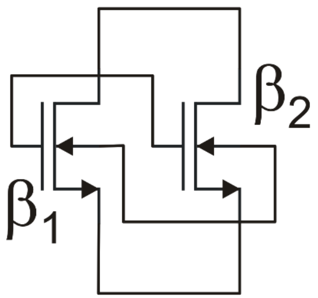
Series are preferred when resistors R_1 and R_2 are large

Parallels have to be preferred for small resistances

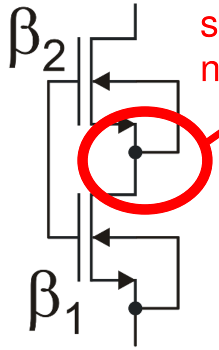


Split and connect components in common centroid configurations

Other devices -Properties of series and parallels



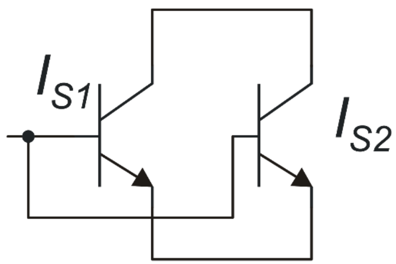
$$\beta_{eq}=\beta_1+\beta_2$$



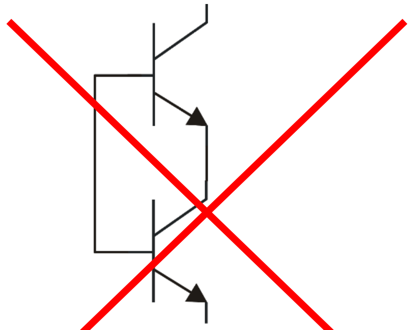
not allowed in standard n-well CMOS

$$\frac{1}{\beta_{eq}}\cong\frac{1}{\beta_1}+\frac{1}{\beta_2}$$

Not accurate



$$I_{Seq}=I_{S1}+I_{S2}$$



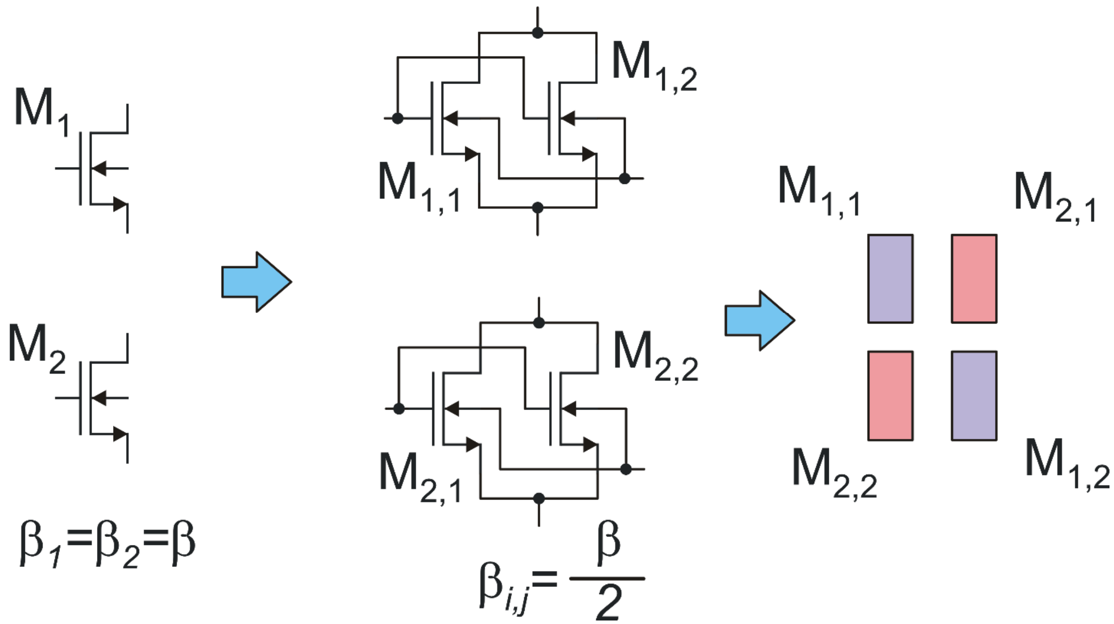
$$V_{CE1}=V_{BE1}-V_{BE2}\cong 0$$

Don't use!

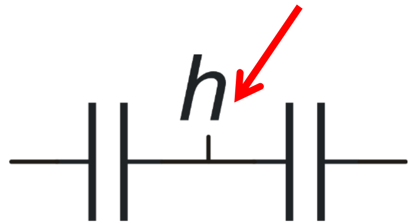
Accurate: Can be used in common centroid configurations

Split and connect components in common centroid configurations

Case 2: MOSFETS



Floating node (no dc path)



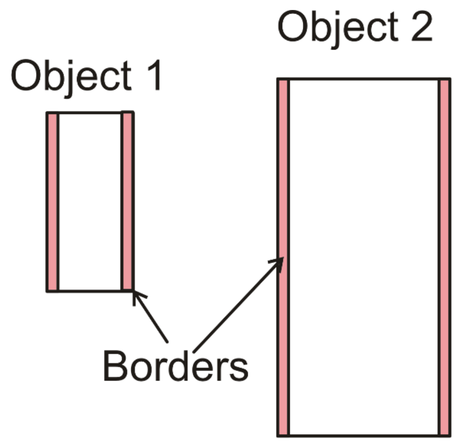
Series connections of capacitors have to be avoided as much as possible unless dc paths are provided for the floating node

BJTs: Same as Mosfets (parallels only)

Capacitors: Parallel connections are preferred (no floating nodes)

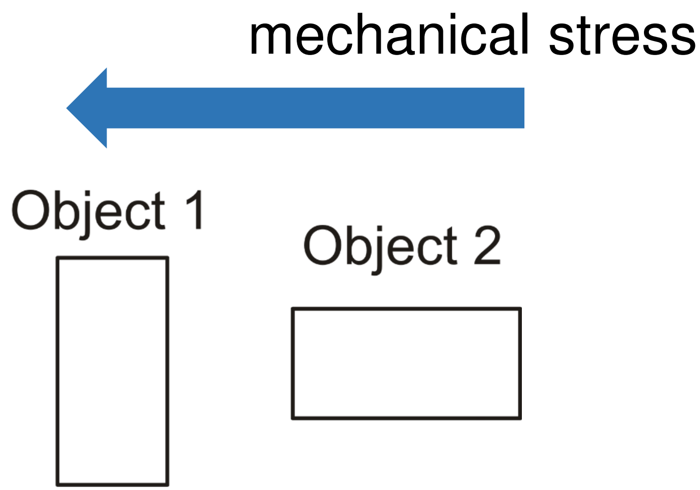
Other Layout rules for improving device matching

Wrong solutions



$$\frac{W_1}{L_1}=\frac{W_2}{L_2} \;\not\Rightarrow\; \begin{array}{ll} R_1=R_2 & \text{resistors} \\ \beta_1=\beta_2 & \text{mosfets} \end{array}$$

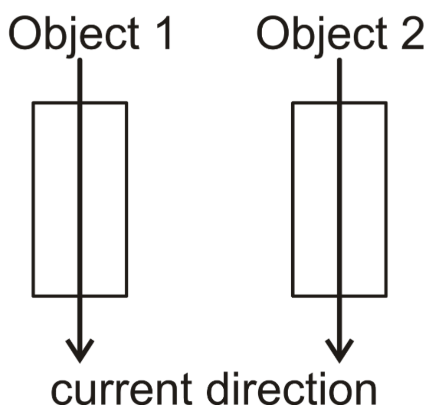
Different size: poor matching



Different orientation: poor matching

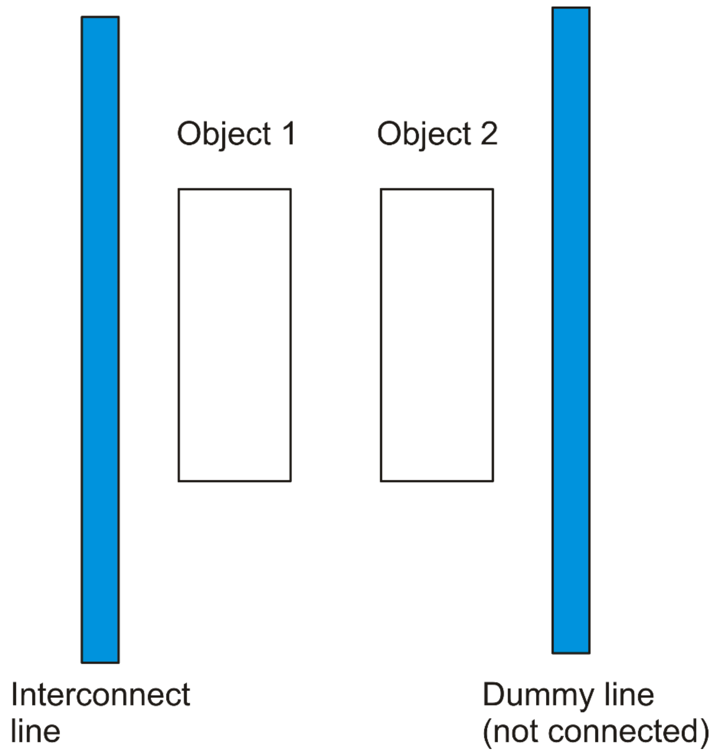
Other Layout rules for improving device matching

Same direction
(to match thermoelectric effects)



Temperature gradients develop extra voltage differences that depend on the current direction
(up to several hundred μVs

Same surroundings

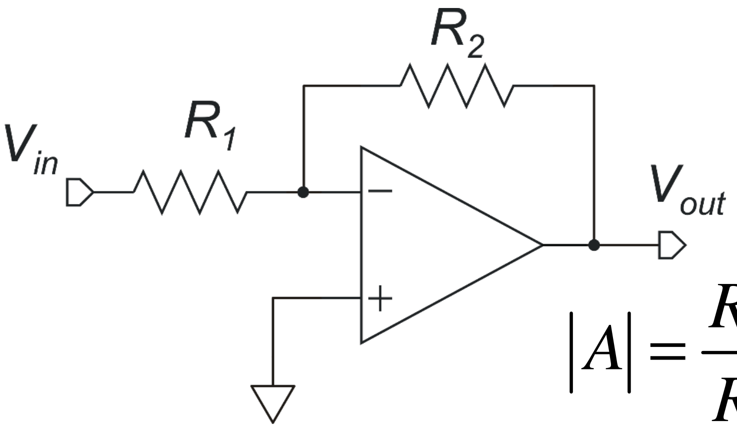


Summary of rules for a good device matching

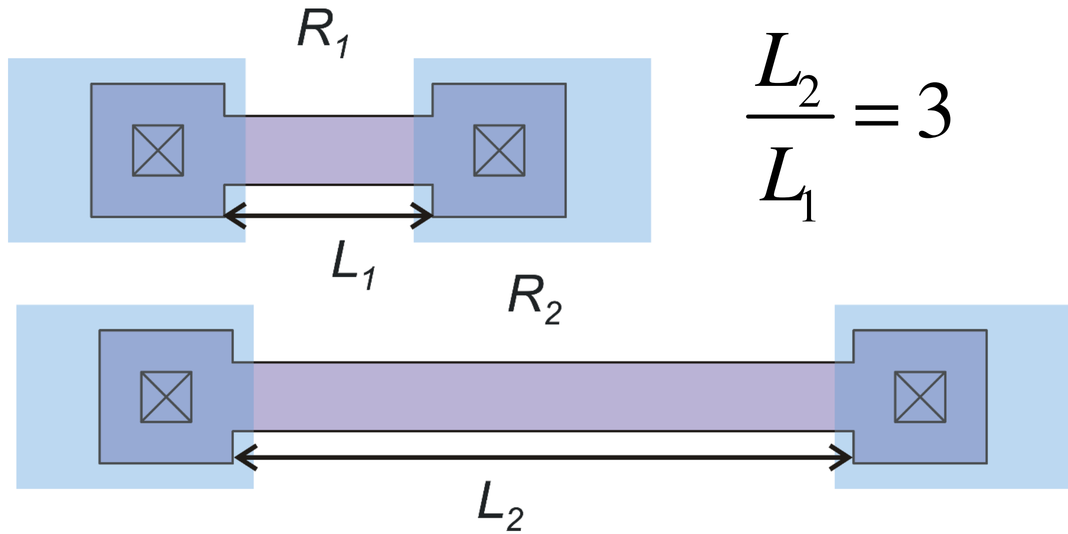
- Devices must be nominally identical (same dimensions, same orientation)
- Device areas should be as large as possible (Pelgrom model)
- Place devices as close as possible
- Use common centroid configurations
- Same current direction for the two devices
- The devices should "see" the same surroundings

Rules to obtain accurate ratios

Example: accurate inverting amplifier with gain magnitude =**3**

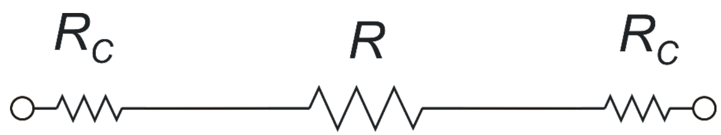


$$|A| = \frac{R_2}{R_1} = 3$$



$$\frac{L_2}{L_1} = 3$$

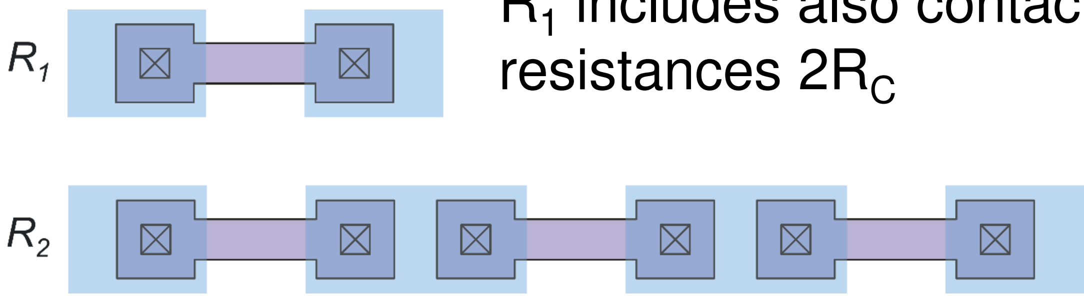
$$|A| = \frac{3R + 2R_C}{R + 2R_C} = 3\left[\frac{1 + (2/3)x}{1 + 2x}\right] < 3$$



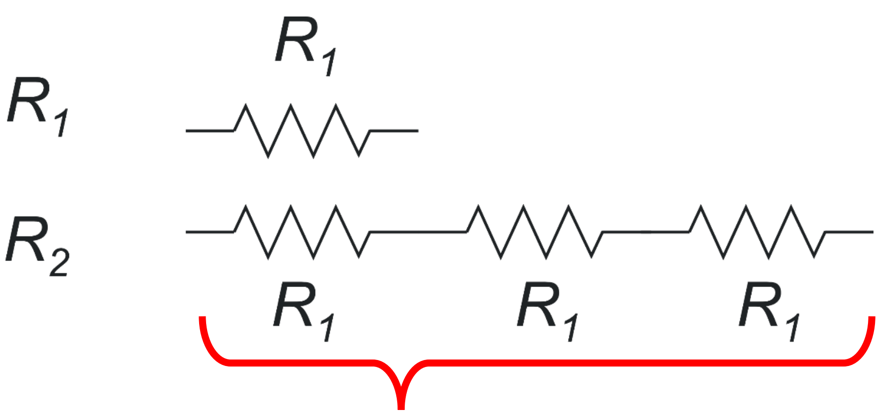
$$x = \frac{R_C}{R}$$ (e.g. with x=0.1, er=**11%**)

(systematic error)

Accurate ratios: modular components

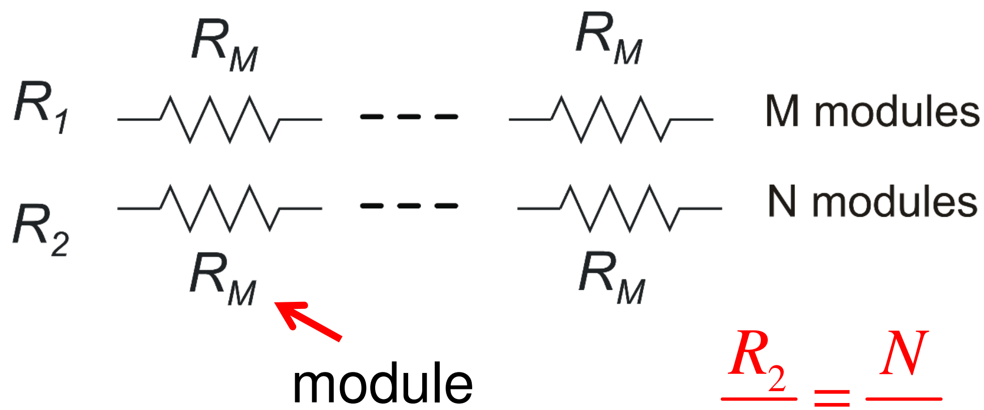


R_1 includes also contact resistances $2R_C$



R_2 is now exactly 3 R_1, independently from contact resistances and other non idealities of R_1

Generalization to Fractional ratios

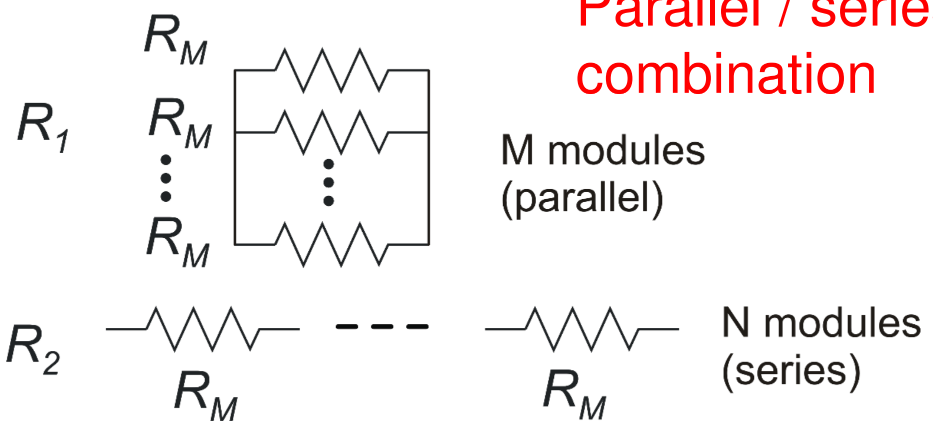


$$\frac{R_2}{R_1} = \frac{N}{M}$$

Both R_1 and R_2 are obtained by adding different numbers of a single module R_N.

Accurate ratios: modular components

Parallel / series combination

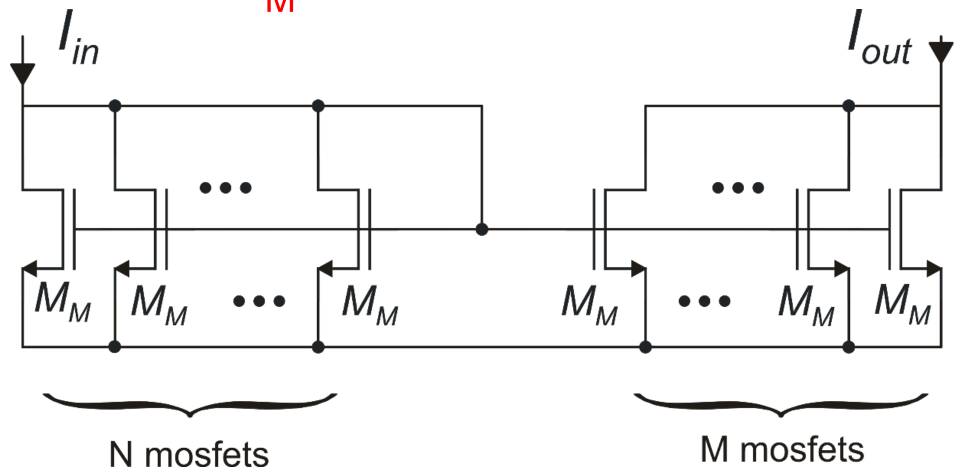


$$\frac{R_2}{R_1} = \frac{NR_M}{\frac{1}{M}R_M} = N \cdot M$$

Large ratios with less components

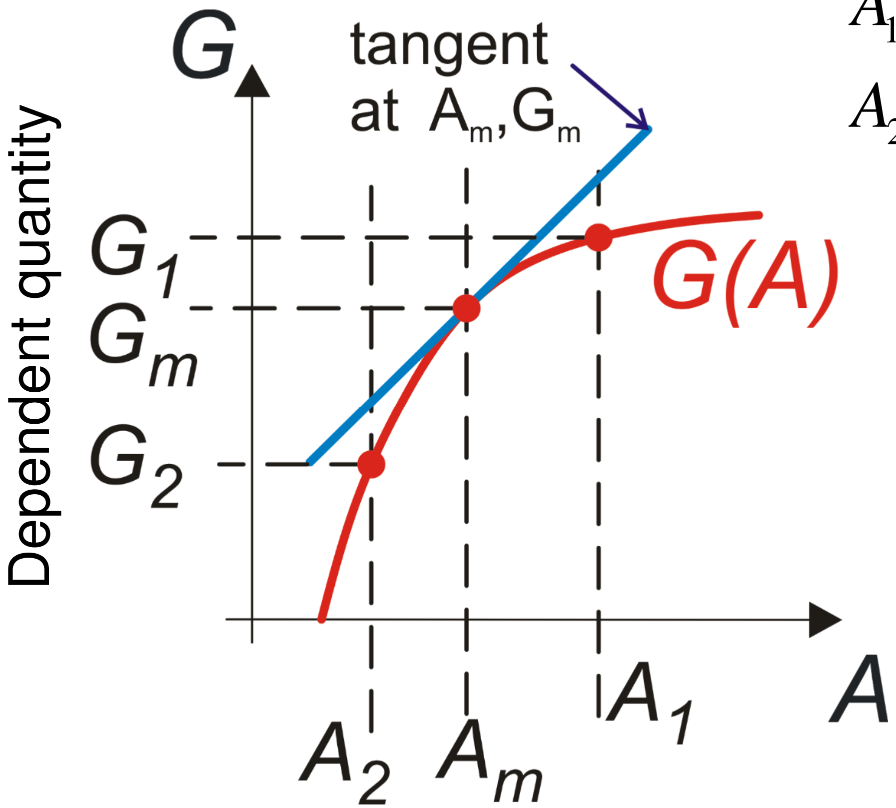
Current mirror with accurate gain

M_M = Module



$$\frac{I_{out}}{I_{in}} = \frac{\beta_2}{\beta_1} = \frac{M\,\beta_M}{N\,\beta_M} = \frac{M}{N}$$

Elements of error propagation theory



$$A_1 = A_m + \Delta A_1$$

$$A_2 = A_m + \Delta A_2$$

$$\Delta A = A_1 - A_2 = \Delta A_1 - \Delta A_2$$

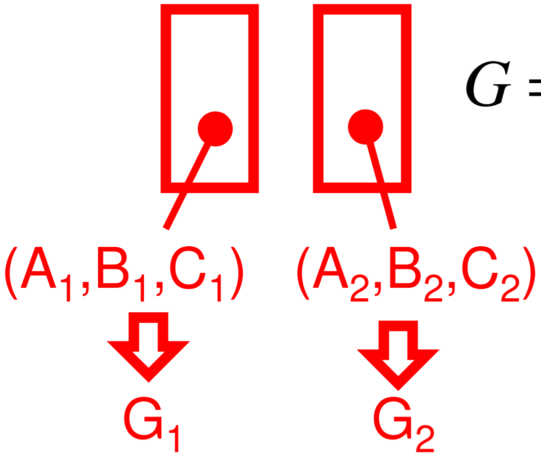
A_m is an arbitrary value between A_1 and A_2

$$G_1 = G\left(A_m + \Delta A_1\right) \cong G\left(A_m\right) + \Delta A_1 \left.\frac{dG}{dA}\right|_{A=A_m}$$

$$G_2 = G\left(A_m + \Delta A_2\right) \cong G\left(A_m\right) + \Delta A_2 \left.\frac{dG}{dA}\right|_{A=A_m}$$

$$G_1 - G_2 \cong \left(\Delta A_1 - \Delta A_2\right) \left.\frac{dG}{dA}\right|_{A=A_m} = \Delta A \left.\frac{dG}{dA}\right|_{A=A_m}$$

For multiple independent variables - general case



$$G = f(A, B, C) \qquad \Delta G = G_1 - G_2 = G(A_1, B_1, C_1) - G(A_2, B_2, C_2)$$

$$P_m = (A_m, B_m, C_m) \quad \begin{cases} G_1 = G(A_m + \Delta A_1, B_m + \Delta B_1, C_m + \Delta C_1) \\ G_2 = G(A_m + \Delta A_2, B_m + \Delta B_2, C_m + \Delta C_2) \end{cases}$$

$$\begin{cases} G_1 = G(A_m, B_m, C_m) + \Delta A_1 \left.\dfrac{\partial G}{\partial A}\right|_{P_m} + \Delta B_1 \left.\dfrac{\partial G}{\partial B}\right|_{P_m} + \Delta C_1 \left.\dfrac{\partial G}{\partial C}\right|_{P_m} \\ G_2 = G(A_m, B_m, C_m) + \Delta A_2 \left.\dfrac{\partial G}{\partial A}\right|_{P_m} + \Delta B_2 \left.\dfrac{\partial G}{\partial B}\right|_{P_m} + \Delta C_2 \left.\dfrac{\partial G}{\partial C}\right|_{P_m} \end{cases}$$

$$\Delta G = G_1 - G_2 = \Delta A \left.\frac{\partial G}{\partial A}\right|_{P_m} + \Delta B \left.\frac{\partial G}{\partial B}\right|_{P_m} + \Delta C \left.\frac{\partial G}{\partial C}\right|_{P_m}$$

Error propagation: particular case 1

case 1:
posynomial expression

$$\boxed{G(A,B,C) = A^{\alpha}B^{\beta}C^{\gamma}}$$

α,β,γ : real exponents
A,B,C real positive variables

$$\left.\frac{\partial G}{\partial A}\right|_{P_m} = \alpha A_m^{\alpha-1}B_m^{\beta}C_m^{\gamma}$$

Using: $\Delta G = \Delta A \left.\frac{\partial G}{\partial A}\right|_{P_m} + \Delta B \left.\frac{\partial G}{\partial B}\right|_{P_m} + \Delta C \left.\frac{\partial G}{\partial C}\right|_{P_m}$

$$\left.\frac{\partial G}{\partial B}\right|_{P_m} = \beta A_m^{\alpha}B_m^{\beta-1}C_m^{\gamma}$$

$$\Delta G = \alpha A_m^{\alpha-1}B_m^{\beta}C_m^{\gamma}\Delta A + \beta A_m^{\alpha}B_m^{\beta-1}C_m^{\gamma}\Delta B + \gamma A_m^{\alpha}B_m^{\beta}C_m^{\gamma-1}\Delta C$$

$$\left.\frac{\partial G}{\partial C}\right|_{P_m} = \gamma A_m^{\alpha}B_m^{\beta}C_m^{\gamma-1}$$

Error propagation: particular case 1

case 1

$$\boxed{G(A,B,C) = A^{\alpha} B^{\beta} C^{\gamma}}$$

Relative variation (or relative error)

$$\frac{\Delta G}{G_m} = \frac{\Delta G}{G(P_m)} = \frac{\Delta G}{A_m^{\alpha} B_m^{\beta} C_m^{\gamma}}$$

$$\frac{\Delta G}{G_m} = \frac{\alpha A_m^{\alpha-1} B_m^{\beta} C_m^{\gamma} \Delta A + \beta A_m^{\alpha} B_m^{\beta-1} C_m^{\gamma} \Delta B + \gamma A_m^{\alpha} B_m^{\beta} C_m^{\gamma-1} \Delta C}{A_m^{\alpha} B_m^{\beta} C_m^{\gamma}}$$

$$\boxed{\frac{\Delta G}{G_m} = \alpha \frac{\Delta A}{A_m} + \beta \frac{\Delta B}{B_m} + \gamma \frac{\Delta C}{C_m}}$$

Sum of the single relative errors, weighted by the respective exponents

$$P = \frac{V^2}{R}$$

$V \to 10\%$

$$\frac{\Delta P}{P} = 2\left(\frac{\Delta V}{V}\right) - \frac{\Delta R}{R}$$

0.1

Error propagation: particular case 2

$$\boxed{G(A,B,C) = \ln\left(A^{\alpha}B^{\beta}C^{\gamma}\right)}$$

case 2: logarithm of a posinomial

$$Z = \left(A^{\alpha}B^{\beta}C^{\gamma}\right)$$

$$Z_m = \left(A_m^{\alpha}B_m^{\beta}C_m^{\gamma}\right)$$

$$\Delta G = \Delta Z \left.\frac{dG}{dZ}\right|_{Z=Z_m} = \Delta Z \left.\frac{d\left[\ln(Z)\right]}{dZ}\right|_{Z=Z_m} = \frac{\Delta Z}{Z_m}$$

$$\Delta G = \frac{\Delta Z}{Z} = \alpha\frac{\Delta A}{A_m} + \beta\frac{\Delta B}{B_m} + \gamma\frac{\Delta C}{C_m}$$

Here we have the absolute error of G, not the relative one.

Application to matching errors

- Generally, when dealing with matching errors: $A_m = \bar{A}$ (mean value)

- Matching errors has also the following basic property:

Linearity: G=A+B ΔG=ΔA+ΔB

G=kA, where k is a constant : ΔG=kΔA

- In the case of relative error, if G=kA: $\frac{\Delta G}{G} = \frac{\Delta A}{A}$

• Matching errors: statistical independence

- Matching errors of <u>different quantities</u> (e.g., quantities A,B,C) can be often considered independent from each other since they are mostly affected by microscopic irregularities, that do not show significant correlations when pairs of quantities are considered.
- In addition matching errors of <u>different device pairs</u> can be also considered independent, or, at least, uncorrelated.

$$\boxed{G = k_1 A + k_2 B + k_3 C \Rightarrow \sigma_{\Delta G} = \sqrt{k_1^2 \sigma_{\Delta A}^2 + k_2^2 \sigma_{\Delta B}^2 + k_3^2 \sigma_{\Delta C}^2}}$$

ΔA ΔB ΔC