

# **Single Channel 12-Bit 500Msps Analog to Digital Converter**

**Check for Samples: [ADS5403](http://www.ti.com/product/ads5403#samples)**

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- **Spectral Performance at**  $f_{IN} = 230$  **MHz IF**  $85^{\circ}C$ ).
	- **SNR: 60.6 dBFS**
	- **SFDR: 80 dBc**
- **Spectral Performance at f<sub>IN</sub> = 700 MHz IF** 
	- **SNR: 59.5 dBFS**
	- **SFDR: 72 dBc**

# **APPLICATIONS**

- **Test and Measurement Instrumentation**
- **Ultra-Wide Band Software Defined Radio**
- 
- **Power Amplifier Linearization**
- **Signal Intelligence and Jamming**
- **Radar and Satellite Systems**
- **Microwave Receivers**

# **<sup>1</sup>FEATURES DESCRIPTION**

**Single Channel 12-bit, • The ADS5403 is a high linearity single channel 12-bit, <b>• Single Channel** 12-bit, **• S 12-Bit Resolution**<br>**• 12-Bit Resolution**<br>**• 12-Bit Resolution**<br>**•** 12-Bit Resolution front end filter design for wide bandwidth receivers.<br>The analog input buffer isolates the internal switching The analog input buffer isolates the internal switching **• Low Swing Fullscale Input: 1.0 Vpp** of the on-chip track-and-hold from disturbing the **on-chip track-and-hold from disturbing the**<br> **• Angles Input Buffer with High Impedance Input signal source as well as providing a h Analog Input Buffer with High Impedance Input** and a source as well as providing a high-impedance **input.** Optionally the output data can be decimated by **Input Bandwidth (3dB): >1.2GHz • • • • • • • • •** two. Designed for high SFDR, the ADC has low-noise **Data Output Interface: DDR LVDS** performance and outstanding spurious-free dynamic<br> **196-Pin BGA Package (12x12mm)** range over a large input-frequency range. The device **196-Pin BGA Package (12x12mm) • 196-Pin BGA Package (12x12mm)** is available in a 196pin BGA package and is specified<br> **• 196-Pin BGA package and is specified**<br>
• 196-Pin BGA package and is specified<br>
• 196-Pin BGA packa over the full industrial temperature range (-40°C to







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# **[ADS5403](http://www.ti.com/product/ads5403?qgpn=ads5403)**



#### SLAS944B –FEBRUARY 2013–REVISED JANUARY 2014 **[www.ti.com](http://www.ti.com)**

**Alland** 

This integrated circuit can be damaged by ESD. Texas Instruments recommends that all integrated circuits be handled with appropriate precautions. Failure to observe proper handling and installation procedures can cause damage.

ESD damage can range from subtle performance degradation to complete device failure. Precision integrated circuits may be more susceptible to damage because very small parametric changes could cause the device not to meet its published specifications.



# **DETAILED BLOCK DIAGRAM**

**Figure 1. Detailed Block Diagram**



## **PINOUT INFORMATION**

**Figure 2. Pinout in DDR output mode (top down view)**

## **PIN ASSIGNMENTS**



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#### **PIN ASSIGNMENTS (continued)**



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## **ABSOLUTE MAXIMUM RATINGS**

over operating free-air temperature range (unless otherwise noted)



### **THERMAL INFORMATION**

<span id="page-4-0"></span>

(1) For more information about traditional and new thermal metrics, see the *IC Package Thermal Metrics* application report, [SPRA953](http://www.ti.com/lit/pdf/spra953).

The junction-to-ambient thermal resistance under natural convection is obtained in a simulation on a JEDEC-standard, high-K board, as specified in JESD51-7, in an environment described in JESD51-2a.

(3) The junction-to-case (top) thermal resistance is obtained by simulating a cold plate test on the package top. No specific JEDECstandard test exists, but a close description can be found in the ANSI SEMI standard G30-88.

(4) The junction-to-board thermal resistance is obtained by simulating in an environment with a ring cold plate fixture to control the PCB temperature, as described in JESD51-8.

(5) The junction-to-top characterization parameter,  $\psi_{JT}$ , estimates the junction temperature of a device in a real system and is extracted from the simulation data for obtaining  $\theta_{JA}$ , using a procedure described in JESD51-2a (sections 6 and 7).

(6) The junction-to-board characterization parameter,  $\psi_{JB}$ , estimates the junction temperature of a device in a real system and is extracted from the simulation data for obtaining  $\theta_{JA}$ , using a procedure described in JESD51-2a (sections 6 and 7).

# **RECOMMENDED OPERATING CONDITIONS**

over operating free-air temperature range (unless otherwise noted)



(1) Prolonged use at this junction temperature may increase the device failure-in-time (FIT) rate.

# **ELECTRICAL CHARACTERISTICS**





# **ELECTRICAL CHARACTERISTICS**





# **ELECTRICAL CHARACTERISTICS**

Typical values at T<sub>A</sub> = 25°C, full temperature range is T<sub>MIN</sub> = –40°C to T<sub>MAX</sub> = 85°C, ADC sampling rate = 500Msps, 50% clock duty cycle, AVDD33 = 3.3V, AVDDC/AVDD18/DVDD/DVDDLVDS/IOVDD = 1.8V, –1dBFS differential input (unless otherwise noted).



(1) SFDR and SNR calculations do not include the DC or Fs/2 bins when Auto Correction is disabled.



# **ELECTRICAL CHARACTERISTICS**

Typical values at T<sub>A</sub> = 25°C, full temperature range is T<sub>MIN</sub> = –40°C to T<sub>MAX</sub> = 85°C, ADC sampling rate = 500Msps, 50% clock duty cycle, AVDD33 = 3.3V, AVDDC/AVDD18/DVDD/DVDDLVDS/IOVDD = 1.8V, –1dBFS differential input (unless otherwise noted).



# **ELECTRICAL CHARACTERISTICS**

The DC specifications refer to the condition where the digital outputs are not switching, but are permanently at a valid logic level 0 or 1. AVDD33 = 3.3V, AVDDC/AVDD18/DVDD/DVDDLVDS/IOVDD = 1.8V







**Figure 3. Timing Diagram for 12-bit DDR Output**



### **TYPICAL CHARACTERISTICS**



**EXAS NSTRUMENTS** 

# **TYPICAL CHARACTERISTICS (continued)**





## **TYPICAL CHARACTERISTICS (continued)**



**EXAS ISTRUMENTS** 







### **TYPICAL CHARACTERISTICS (continued)**



EXAS **STRUMENTS** 

### **TYPICAL CHARACTERISTICS (continued)**

Typical values at TA = +25°C, full temperature range is T<sub>MIN</sub> = -40°C to T<sub>MAX</sub> = +85°C, ADC sampling rate = 500Msps, 50% clock duty cycle, AVDD33 = 3.3V, AVDDC/AVDD18/DVDD/DVDDLVDS/IOVDD = 1.8V, -1dBFS differential input, unless otherwise noted.

**SFDR Across Input and Sampling Frequencies (auto on)**



**Figure 31.**



### **TYPICAL CHARACTERISTICS (continued)**

Typical values at TA = +25°C, full temperature range is T<sub>MIN</sub> = -40°C to T<sub>MAX</sub> = +85°C, ADC sampling rate = 500Msps, 50% clock duty cycle, AVDD33 = 3.3V, AVDDC/AVDD18/DVDD/DVDDLVDS/IOVDD = 1.8V, -1dBFS differential input, unless otherwise noted.



**SFDR Across Input and Sampling Frequencies (auto off)**

**Figure 32.**

**ISTRUMENTS** 

**EXAS** 

## **TYPICAL CHARACTERISTICS (continued)**

Typical values at TA = +25°C, full temperature range is T<sub>MIN</sub> = -40°C to T<sub>MAX</sub> = +85°C, ADC sampling rate = 500Msps, 50% clock duty cycle, AVDD33 = 3.3V, AVDDC/AVDD18/DVDD/DVDDLVDS/IOVDD = 1.8V, -1dBFS differential input, unless otherwise noted.



**SNR Across Input and Sampling Frequencies (auto on)**

**Figure 33.**



### **TYPICAL CHARACTERISTICS (continued)**

Typical values at TA = +25°C, full temperature range is T<sub>MIN</sub> = -40°C to T<sub>MAX</sub> = +85°C, ADC sampling rate = 500Msps, 50% clock duty cycle, AVDD33 = 3.3V, AVDDC/AVDD18/DVDD/DVDDLVDS/IOVDD = 1.8V, -1dBFS differential input, unless otherwise noted.



**SNR Across Input and Sampling Frequencies (auto on)**

**Figure 34.**



# **FEATURES**

## **POWER DOWN MODES**

The ADS5403 can be configured via SPI write (address x37) to a stand-by, light or deep sleep power mode which is controlled by the ENABLE pin. The sleep modes are active when the ENABLE pin goes low. Different internal functions stay powered up which results in different power consumption and wake up time between the two sleep modes.



## **TEST PATTERN OUTPUT**

The ADS5403 can be configured to output different test patterns that can be used to verify the digital interface is connected and working properly. To enable the test pattern mode, the high performance mode 1 has to be disabled first via SPI register write. Then different test patterns can be selected by configuring registers x3C, x3D and x3E. All three registers must be configured for the test pattern to work properly.

First set  $HP1 = 0$  (Addr 0x01, D01)





For normal operation, set HP1 = 1 (Addr 0x01, D01) and 0x3C, 0x3D, 0x3E all to 0.

## **CLOCK INPUT**

The ADS5403 clock input can be driven differentially with a sine wave, LVPECL or LVDS source with little or no difference in performance. The common mode voltage of the clock input is set to 0.9V using internal 2kΩ resistors. This allows for AC coupling of the clock inputs. The termination resistors should be placed as close as possible to the clock inputs in order to minimize signal reflections and jitter degradation.





### **Figure 35. Recommended Differential Clock Driving Circuit**



**[ADS5403](http://www.ti.com/product/ads5403?qgpn=ads5403)**

(2)

### **SNR AND CLOCK JITTER**

The signal to noise ratio of the ADC is limited by three different factors: the quantization noise is typically not noticeable in pipeline converters and is 74dB for a 12bit ADC. The thermal noise limits the SNR at low input frequencies while the clock jitter sets the SNR for higher input frequencies.

$$
SNR_{ADC}[dBc] = -20 \times log \sqrt{10 - \frac{SNR_{Quantization\_Noise}}{20}}^2 + \left(10 - \frac{SNR_{ThermalNoise}}{20}\right)^2 + \left(10 - \frac{SNR_{Jitter}}{20}\right)^2 \tag{1}
$$

The SNR limitation due to sample clock jitter can be calculated as following:

$$
SNR_{\text{Jitter}} \text{ [dBc]} = -20 \times \log(2\pi \times f_{\text{IN}} \times t_{\text{Jitter}})
$$

The total clock jitter (TJitter) has three components – the internal aperture jitter (100fs for ADS5403) which is set by the noise of the clock input buffer, the external clock jitter and the jitter from the analog input signal. It can be calculated as following:

$$
T_{\text{Jitter}} = \sqrt{\left(T_{\text{Jitter,Ext.Clock\_Input}}\right)^2 + \left(T_{\text{Aperture}\_\text{ADC}}\right)^2}
$$
\n(3)

External clock jitter can be minimized by using high quality clock sources and jitter cleaners as well as bandpass filters at the clock input while a faster clock slew rate improves the ADC aperture jitter.

The ADS5403 has a thermal noise of 60.8 dBFS and internal aperture jitter of 100fs. The SNR depending on amount of external jitter for different input frequencies is shown in the following figure.



#### **SNR vs Input Frequency and External Clock Jitter**



# **ANALOG INPUTS**

The ADS5403 analog signal input is designed to be driven differentially. The analog input pins have internal analog buffers that drive the sampling circuit. As a result of the analog buffer, the input pins present a high impedance input across a very wide frequency range to the external driving source which enables great flexibility in the external analog filter design as well as excellent  $50\Omega$  matching for RF applications. The buffer also helps to isolate the external driving circuit from the internal switching currents of the sampling circuit which results in a more constant SFDR performance across input frequencies.

The common-mode voltage of the signal input is internally biased to 1.9V using 500Ω resistors which allows for AC coupling of the input drive network. Each input pin (INP, INM) must swing symmetrically between (VCM + 0.25V) and (VCM – 0.25V), resulting in a 1.0Vpp (default) differential input swing. The input sampling circuit has a 3dB bandwidth that extends up to 1.2GHz.



# **OVER-RANGE INDICATION**

The ADS5403 provides a fast over-range indication on the OVRA/B pins. The fast OVR is triggered if the input voltage exceeds the programmable overrange threshold and it gets presented after just 12 clock cycles enabling a quicker reaction to an overrange event. The OVR threshold can be configured using SPI register writes.

The input voltage level at which the overload is detected is referred to as the threshold and is programmable using the Over-range threshold bits. The threshold at which fast OVR is triggered is (full-scale  $\times$  [the decimal value of the FAST OVR THRESH bits] /16). After reset, the default value of the over-range threshold is set to 15 (decimal) which corresponds to a threshold of  $0.56dB$  below full scale  $(20<sup>*</sup>log(15/16))$ .





### **INTERLEAVING CORRECTION**

The data converter channel consists of two interleaved ADCs each operating at half of the ADC sampling rate but 180º out of phase from each other. The front end track and hold circuitry is operating at the full ADC sampling rate which minimizes the timing mismatch between the two interleaved ADCs. In addition the ADS5403 is equipped with internal interleaving correction logic that can be enabled via SPI register write.



The interleaving operation creates 2 distinct and interleaving products:

- Fs/2 Fin: this spur is created by gain timing mismatch between the ADCs. Since internally the front end track and hold is operated at the full sampling rate, this component is greatly improved and mostly dependent on gain mismatch.
- Fs/2 Spur: due to offset mismatch between ADCs



The auto correction loop can be enabled via SPI register write in address 0x01 and resetting the correction circuit in address 0x03 and 0x1A. By default it is disabled for lowest possible power consumption. The default settings for the auto correction function should work for most applications. However please contact Texas Instruments if further fine tuning of the algorithm is required.

<span id="page-22-0"></span>The auto correction function yields best performance for input frequencies below 250MHz..

**EXAS NSTRUMENTS** 

## **RECEIVE MODE: DECIMATION FILTER**

There is an optional digital decimation filter in the data path as shown in [Figure 36](#page-23-0). The filter can be programmed as a low-pass or a high-pass filter and the normalized frequency response of both filters is shown in [Figure 37.](#page-23-1)





<span id="page-23-0"></span>The decimation filter response has a 0.1dB pass band ripple with approximately 41% pass-band bandwidth. The stop-band attenuation is approximately 40dB.

<span id="page-23-1"></span>





#### **MULTI DEVICE SYNCHRONIZATION**

The ADS5403 simplifies the synchronization of data from multiple ADCs in one common receiver. Upon receiving the initial SYNC input signal, the ADS5403 resets all the internal clocks and digital logic while also starting a SYNCOUT signal which operates on a 5bit counter (32 clock cycles). Therefore by providing a common SYNC signal to multiple ADCs their output data can be synchronized as the SYNCOUT signal marks a specific sample with the same latency in all ADCs. The SYNCOUT signal then can be used in the receiving device to synchronize the FIFO pointers across the different input data streams. Thus the output data of multiple ADCs can be aligned properly even if there are different trace lengths between the different ADCs.



The SYNC input signal should be a one time pulse to trigger the periodic 5-bit counter for SYNCOUT or a periodic signal repeating every 32 CLKIN clock cycles. It gets registered on the rising edge of the ADC input clock (CLKIN). Upon registering the initial rising edge of the SYNC signal, the internal clocks and logic get reset which results in invalid output data for 36 samples (1 complete sync cycle and 4 additional samples). The SYNCOUT signal starts with the next output clock (DACLK) rising edge and operates on a 5-bit counter. If a SYNCIN rising edge gets registered at a new position, the counter gets reset and SYNCOUT starts from the new position.

<span id="page-24-0"></span>Since the ADS5403 output interface operates with a DDR clock, the synchronization can happen on the rising edge or falling edge sample. Synchronization on the falling edge sample will result in a half cycle clock stretch of DACLK. For convenience the SYNCOUT signal is available on the ChA output LVDS bus. When using decimation the SYNCOUT signal still operates on 32 clock cycles of CLKIN but since the output data is decimated by 2, only the first 18 samples should be discarded.





## **PROGRAMMING INTERFACE**

The serial interface (SIF) included in the ADS5403 is a simple 3 or 4 pin interface. In normal mode, 3 pins are used to communicate with the device. There is an enable (SDENB), a clock (SCLK) and a bi-directional IO port (SDIO). If the user would like to use the 4 pin interface one write must be implemented in the 3 pin mode to enable 4 pin communications. In this mode, the SDO pin becomes the dedicated output. The serial interface has an 8-bit address word and a 16-bit data word. The first rising edge of SCLK after SDENB goes low will latch the read/write bit. If a high is registered then a read is requested, if it is low then a write is requested. SDENB must be brought high again before another transfer can be requested. The signal diagram is shown below:

### <span id="page-25-1"></span>**Device Initialization**

After power up, it is recommended to initialize the device through a hardware reset by applying a logic low pulse on the SRESETb pin (of width greater than 20ns), as shown in [Figure 38.](#page-25-0) This resets all internal digital blocks (including SPI registers) to their default condition.



**Figure 38. Device Initialization Timing Diagram**



<span id="page-25-0"></span>

Recommended Device Initialization Sequence:

- 1. Power up
- 2. Reset ADS5403 using hardware reset.
- 3. Apply clock and input signal.
- 4. Set register 0x01 bit D15 to "1" (ChA Corr EN) to enable gain/offset correction circuit and other desired registers.
- 5. Set register 0x03 D14 to "1" (Start Auto Corr ChA). This clears and resets the accumulator values in the DC and gain correction loop.
- 6. Set register 0x03 D14 to "0" (Start Auto Corr ChA). This starts the DC and gain auto-correction loop.

### **Serial Register Write**

The internal register of the ADS5403 can be programmed following these steps:

- 1. Drive SDENB pin low
- 2. Set the R/W bit to '0' (bit A7 of the 8 bit address)



- 3. Initiate a serial interface cycle specifying the address of the register (A6 to A0) whose content has to be written
- 4. Write 16bit data which is latched on the rising edge of SCLK



#### **Figure 39. Serial Register Write Timing Diagram**



(1) Typical values at +25°C; minimum and maximum values across the full temperature range: TMIN = –40°C to TMAX = +85°C, AVDD3V  $= 3.3V$ , AVDD, DRVDD  $= 1.9V$ , unless otherwise noted.



#### **Serial Register Readout**

The device includes a mode where the contents of the internal registers can be read back using the SDO/SDIO pins. This read-back mode may be useful as a diagnostic check to verify the serial interface communication between the external controller and the ADC.

- 1. Drive SDENB pin low
- 2. Set the RW bit (A7) to '1'. This setting disables any further writes to the registers
- 3. Initiate a serial interface cycle specifying the address of the register (A6 to A0) whose content has to be read.
- 4. The device outputs the contents (D15 to D0) of the selected register on the SDO/SDIO pin
- 5. The external controller can latch the contents at the SCLK rising edge.
- 6. To enable register writes, reset the RW register bit to '0'.



**Figure 40. Serial Register Read Timing Diagram**



### **SERIAL REGISTER MAP(2)**

<span id="page-28-0"></span>

(2) Multiple functions in a register can be programmed in a single write operation.

# **DESCRIPTION OF SERIAL INTERFACE REGISTERS**



- D15 **3/4 Wire SPI** Enables 4-bit serial interface when set Default 0
- 0 3 wire SPI is used with SDIO pin operating as bi-directional I/O port
- 1 4 wire SPI is used with SDIO pin operating as data input and SDO pin as data output port.
- D14 **Decimation** 2x decimation filter is enabled when bit is set **Filter EN** Default 0
- 0 Normal operation with data output at full sampling rate
- 1 2x decimation filter enabled
- D12 **ChA High/Low** (Decimation filter must be enabled first: set bit D14) **Pass** Default 0
- 0 Low Pass
- 1 High Pass



## D15 **ChA Corr EN (should be enabled for maximum performance)**

Default 0

- 0 auto correction disabled
- 1 auto correction enabled
- D3 **Data Format**

Default 0

- 0 Two's complement
- 1 Offset Binary

# D1 **HP Mode 1**

Default 0

### 1 Must be set to 1 for optimum performance



D10-D7 **Over-range threshold** The over-range detection is triggered 12 output clock cycles after the overload condition occurs. The threshold at which the OVR is triggered = 1.0V x [decimal value of <Over-range threshold>]/16. After power up or reset, the default value is 15 (decimal) which corresponds to a OVR threshold of 0.56dB below fullscale (20\*log(15/16)). This OVR threshold is applicable to both channels.

#### Default 1111







#### D14 **Start Auto Corr ChA** Starts DC offset and Gain correction loop for ChA Default 1

0 Starts offset and Gain correction loop for ChA

1 Clears DC offset correction value to 0 and Gain correction value to 1

D11, 9, 8, 4, 3 Must be set to 1 for maximum performance Default 1









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D8-D0 **Temp Sensor** Internal temperature sensor value – read only



D15-D0 **Reset** This is a software reset to reset all SPI registers to their default value. Self clears to 0.

0000

1101001011110000 Perform software reset





Sleep mode selection which is controlled by the ENABLE pin. Sleep modes are active when ENABLE pin goes low. Wake up time 2.5 ms



<span id="page-31-0"></span>





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<span id="page-34-0"></span>

<span id="page-34-1"></span>

<span id="page-34-4"></span><span id="page-34-3"></span><span id="page-34-2"></span>D11-D0 corresponds to DA11-DA0

# **REVISION HISTORY**



### Changes from Original (February 2013) to Revision A **Page Page**





www.ti.com 10-Dec-2020

# **PACKAGING INFORMATION**



**(1)** The marketing status values are defined as follows:

**ACTIVE:** Product device recommended for new designs.

**LIFEBUY:** TI has announced that the device will be discontinued, and a lifetime-buy period is in effect.

**NRND:** Not recommended for new designs. Device is in production to support existing customers, but TI does not recommend using this part in a new design.

**PREVIEW:** Device has been announced but is not in production. Samples may or may not be available.

**OBSOLETE:** TI has discontinued the production of the device.

<sup>(2)</sup> RoHS: TI defines "RoHS" to mean semiconductor products that are compliant with the current EU RoHS requirements for all 10 RoHS substances, including the requirement that RoHS substance do not exceed 0.1% by weight in homogeneous materials. Where designed to be soldered at high temperatures. "RoHS" products are suitable for use in specified lead-free processes. TI may reference these types of products as "Pb-Free".

**RoHS Exempt:** TI defines "RoHS Exempt" to mean products that contain lead but are compliant with EU RoHS pursuant to a specific EU RoHS exemption.

Green: TI defines "Green" to mean the content of Chlorine (CI) and Bromine (Br) based flame retardants meet JS709B low halogen requirements of <=1000ppm threshold. Antimony trioxide based flame retardants must also meet the <=1000ppm threshold requirement.

**(3)** MSL, Peak Temp. - The Moisture Sensitivity Level rating according to the JEDEC industry standard classifications, and peak solder temperature.

**(4)** There may be additional marking, which relates to the logo, the lot trace code information, or the environmental category on the device.

**(5)** Multiple Device Markings will be inside parentheses. Only one Device Marking contained in parentheses and separated by a "~" will appear on a device. If a line is indented then it is a continuation of the previous line and the two combined represent the entire Device Marking for that device.

**(6)** Lead finish/Ball material - Orderable Devices may have multiple material finish options. Finish options are separated by a vertical ruled line. Lead finish/Ball material values may wrap to two lines if the finish value exceeds the maximum column width.

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# **PACKAGE OPTION ADDENDUM**

# **TEXAS INSTRUMENTS**

www.ti.com 5-Jan-2022

# **PACKAGE MATERIALS INFORMATION**

# **TRAY**



Chamfer on Tray corner indicates Pin 1 orientation of packed units.

\*All dimensions are nominal





# **PACKAGE OUTLINE**

# **ZAY0196A NFBGA - 1.4 mm max height**

PLASTIC BALL GRID ARRAY



NOTES:

- 1. All linear dimensions are in millimeters. Any dimensions in parenthesis are for reference only. Dimensioning and tolerancing per ASME Y14.5M.
- 2. This drawing is subject to change without notice.



# **EXAMPLE BOARD LAYOUT**

# **ZAY0196A NFBGA - 1.4 mm max height**

PLASTIC BALL GRID ARRAY



NOTES: (continued)

3. Final dimensions may vary due to manufacturing tolerance considerations and also routing constraints. For information, see Texas Instruments literature number SPRAA99 (www.ti.com/lit/spraa99).



# **EXAMPLE STENCIL DESIGN**

# **ZAY0196A NFBGA - 1.4 mm max height**

PLASTIC BALL GRID ARRAY



NOTES: (continued)

4. Laser cutting apertures with trapezoidal walls and rounded corners may offer better paste release.



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