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**[DRV8833C](http://www.ti.com/product/drv8833c?qgpn=drv8833c)** SLVSCP9 –AUGUST 2014

# **DRV8833C Dual H-Bridge Motor Driver**

**Technical** [Documents](http://www.ti.com/product/DRV8833C?dcmp=dsproject&hqs=td&#doctype2)

- Dual H-Bridge Motor Driver With Current Control Point-of-Sale Printers
	- 1 or 2 DC Motors or 1 Stepper Motor Video Security Cameras
	- Low On-Resistance: HS + LS = 1735 mΩ Office Automation Machines (Typical, 25°C) • Gaming Machines
- <span id="page-0-2"></span>Output Current Capability (at  $V_M = 5 V$ , 25°C) • Robotics
	- PWP (HTSSOP) Package  **Battery-Powered Toys** 
		- 0.7-A RMS, 1-A Peak per H-Bridge
		-
	- - 0.6-A RMS, 1-A Peak per H-Bridge applications.
		-
- -
- 
- 
- 
- -
	-
- -
	-
	-
	- Fault Indication Pin (nFAULT)

### <span id="page-0-1"></span>**1 Features 2 Applications**

Tools & **[Software](http://www.ti.com/product/DRV8833C?dcmp=dsproject&hqs=sw&#desKit)** 

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– 1.4-A RMS in Parallel Mode **3 Description** The DRV8833C provides a dual-bridge motor driver<br>solution for toys, printers, and other mechatronic

Support & **[Community](http://www.ti.com/product/DRV8833C?dcmp=dsproject&hqs=support&#community)** 

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– 1.2-A RMS in Parallel Mode<br>The device has two H-bridges and can drive two DC<br>brushed motors, a bipolar stepper motor, solenoids. brushed motors, a bipolar stepper motor, solenoids, – 2.7 to 10.8 V or other inductive loads.

Integrated Current Regulation **Each H-bridge output consists of a pair of N-channel** Easy Pulse-Width-Modulation (PWM) Interface and P-channel MOSFETs, with circuitry that regulates<br>1.6 u.0 Low Current Sleep Mode (at 5 V) the winding current. With proper PCB design, each Hthe winding current. With proper PCB design, each H-<br>bridge of the DRV8833C can drive up to 700-mA<br>RMS (or DC) continuously at 25°C with a V<sub>ri</sub>sumply  $\epsilon$  Small Package and Footprint Foother RMS (or DC) continuously, at 25°C with a V<sub>M</sub> supply<br>- 16 HTSSOP (PowerPAD<sup>TM</sup>) 5.00 x 6.40 mm of 5 V. The device can support peak currents of up to of 5 V. The device can support peak currents of up to - 16 QFN (PowerPAD) 3.00  $\times$  3.00 mm  $\qquad$  1 A per bridge. Current capability is reduced slightly

<span id="page-0-0"></span>at lower V<sup>M</sup> voltages. • Protection Features  $V_M$  Undervoltage Lockout (UVLO)<br>  $V_M$  Undervoltage Lockout (UVLO) provided for overcurrent protection, short-circuit<br>
protection  $UVLO$  and overtemperature A low-power – Overcurrent Protection (OCP) protection, UVLO, and overtemperature. A low-power<br>
– Thermal Shutdown (TSD) subsetioned is also provided. sleep mode is also provided.

#### **Device Information[\(1\)](#page-0-0)**



(1) For all available packages, see the orderable addendum at the end of the data sheet.



Texas<br>Instruments

# **Table of Contents**





# <span id="page-1-0"></span>**4 Revision History**





### <span id="page-2-0"></span>**5 Pin Configuration and Functions**





#### **Pin Functions**



**STRUMENTS** 

**EXAS** 

#### **External Components**



(1) Proper bulk capacitance sizing depends on the motor power.

(2) nFAULT may be pulled up to an external supply rated < 5.5 V.

### <span id="page-3-0"></span>**6 Specifications**

#### <span id="page-3-1"></span>**6.1 Absolute Maximum Ratings**

over operating free-air temperature (unless otherwise noted)<sup>(1)</sup>



(1) Stresses beyond those listed under *Absolute Maximum Ratings* may cause permanent damage to the device. These are stress ratings only, which do not imply functional operation of the device at these or any other conditions beyond those indicated under *Recommended Operating Conditions*. Exposure to absolute-maximum-rated conditions for extended periods may affect device reliability.

#### <span id="page-3-2"></span>**6.2 Handling Ratings**



(1) JEDEC document JEP155 states that 500-V HBM allows safe manufacturing with a standard ESD control process.

(2) JEDEC document JEP157 states that 250-V CDM allows safe manufacturing with a standard ESD control process.

#### <span id="page-3-3"></span>**6.3 Recommended Operating Conditions**

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



(1) Note that when V<sub>M</sub> is below 5 V, R<sub>DS(ON)</sub> increases and maximum output current is reduced.<br>(2) Power dissipation and thermal limits must be observed.

#### <span id="page-4-0"></span>**6.4 Thermal Information**



(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).

#### <span id="page-4-1"></span>**6.5 Electrical Characteristics**

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



(1) Not tested in production; based on design and characterization data

### **Electrical Characteristics (continued)**

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



(2) Not tested in production; based on design and characterization data



#### **6.6 Typical Characteristics**

<span id="page-6-0"></span>

#### <span id="page-7-1"></span><span id="page-7-0"></span>**7.1 Overview**

The DRV8833C device is an integrated motor driver solution for brushed DC or bipolar stepper motors. The device integrates two PMOS + NMOS H-bridges and current regulation circuitry. The DRV8833C can be powered with a supply voltage from 2.7 to 10.8 V and can provide an output current up to 700 mA RMS.

A simple PWM interface allows easy interfacing to the controller circuit.

The current regulation is a 20-µs fixed off-time slow decay.

The device includes a low-power sleep mode, which lets the system save power when not driving the motor.

#### <span id="page-7-2"></span>**7.2 Functional Block Diagram**





#### <span id="page-8-0"></span>**7.3 Feature Description**

#### <span id="page-8-1"></span>**7.3.1 PWM Motor Drivers**

The DRV8833C contains drivers for two full H-bridges. [Figure 6](#page-8-2) shows a block diagram of the circuitry.



**Figure 6. H-Bridge and Current-Chopping Circuitry**

#### <span id="page-8-2"></span>**7.3.2 Bridge Control and Decay Modes**

<span id="page-8-3"></span>The AIN1 and AIN2 input pins control the state of the AOUT1 and AOUT2 outputs; similarly, the BIN1 and BIN2 input pins control the state of the BOUT1 and BOUT2 outputs (see [Table 1\)](#page-8-3).



#### **Table 1. H-Bridge Logic**

The inputs can also be used for PWM control of the motor speed. When controlling a winding with PWM and the drive current is interrupted, the inductive nature of the motor requires that the current must continue to flow (called recirculation current). To handle this recirculation current, the H-bridge can operate in two different states, fast decay or slow decay. In fast-decay mode, the H-bridge is disabled and recirculation current flows through the body diodes. In slow-decay mode, the motor winding is shorted by enabling both low-side FETs.

To externally pulse-width modulate the bridge in fast-decay mode, the PWM signal is applied to one xIN pin while the other is held low; to use slow-decay mode, one xIN pin is held high. See [Table 2](#page-9-0) for more information.

**ISTRUMENTS** 



#### **Table 2. PWM Control of Motor Speed**

<span id="page-9-0"></span>The internal current control is still enabled when applying external PWM to xIN. To disable the current control when applying external PWM, the xISEN pins should be connected directly to ground. [Figure 7](#page-9-1) show the current paths in different drive and decay modes.



#### <span id="page-9-1"></span>**7.3.3 Current Control**

The current through the motor windings may be limited, or controlled, by a 20-µs constant off-time PWM current regulation, or current chopping. For DC motors, current control is used to limit the start-up and stall current of the motor. For stepper motors, current control is often used at all times.

When an H-bridge is enabled, current rises through the winding at a rate dependent on the DC voltage and inductance of the winding. If the current reaches the current chopping threshold, the bridge disables the current until the beginning of the next PWM cycle. Note that immediately after the output is enabled, the voltage on the xISEN pin is ignored for a fixed period of time before enabling the current sense circuitry. This blanking time is fixed at 3.75 μs.

The PWM chopping current is set by a comparator that compares the voltage across a current sense resistor connected to the xISEN pins with a reference voltage. The reference voltage,  $V_{TRIP}$ , is is fixed at 200 mV nominally.

<span id="page-9-2"></span>The chopping current is calculated as in [Equation 1](#page-9-2).

$$
I_{CHOP} = \frac{200 \text{ mV}}{R_{XISEN}}
$$

(1)

Example: If a 1-Ω sense resistor is used, the chopping current will be 200 mV / 1 Ω = 200 mA.



#### **NOTE**

If current control is not needed, the xISEN pins should be connected directly to ground.

#### **7.3.4 Decay Mode**

After the chopping current threshold is reached, the H-bridge switches to slow-decay mode. This state is held for  $t_{off}$  (20 µs) until the next cycle to turn on the high-side MOSFETs.

#### **7.3.5 Slow Decay**

In slow-decay mode, the high-side MOSFETs are turned off and both of the low-side MOSFETs are turned on. The motor current decreases while flowing in the two low-side MOSFETs until reaching its fixed off time (typically 20 µs). After that, the high-side MOSFETs are enabled to increase the winding current again.





#### **7.3.6 Sleep Mode**

Driving nSLEEP low puts the device into a low-power sleep state. In this state, the H-bridges are disabled, all internal logic is reset, and all internal clocks are stopped. All inputs are ignored until nSLEEP returns inactive high. When returning from sleep mode, some time, t<sub>WAKE</sub>, needs to pass before the motor driver becomes fully operational. To make the board design simple, the nSLEEP can be pulled up to the supply  $(V_M)$ . TI recommends to use a pullup resistor when this is done. This resistor limits the current to the input in case  $V_M$  is higher than 6.5 V. Internally, the nSLEEP pin has a 500-kΩ resistor to GND. It also has a clamping Zener diode that clamps the voltage at the pin at 6.5 V. Currents greater than 250 µA can cause damage to the input structure. Therefore, TI recommends a pullup resistor between 20 to 75 kΩ.



#### **7.3.7 Parallel Mode**

The two H-bridges in the DRV8833C can be connected in parallel for double the current of a single H-bridge. The internal dead time in the DRV8833C prevents any risk of cross-conduction (shoot-through) between the two bridges due to timing differences between the two bridges. [Figure 9](#page-11-0) shows the connections.



**Figure 9. Parallel Mode Schematic**

#### <span id="page-11-0"></span>**7.3.8 Protection Circuits**

The DRV8833C is fully protected against overcurrent, overtemperature, and undervoltage events.

#### *7.3.8.1 Overcurrent Protection (OCP)*

An analog current limit ( $I_{OCP}$ ) circuit on each FET limits the current through the FET by limiting the gate drive. If this analog current limit persists for longer than the OCP deglitch time  $(t_{DEG})$ , all FETs in the H-bridge are disabled and the nFAULT pin is driven low. The driver is re-enabled after the OCP retry period ( $t_{OCP}$ ) has passed. nFAULT becomes high again after the retry time. If the fault condition is still present, the cycle repeats. If the fault is no longer present, normal operation resumes and nFAULT remains deasserted. Note that only the Hbridge in which the OCP is detected will be disabled while the other bridge functions normally.

Overcurrent conditions are detected independently on both high-side and low-side devices; a short to ground, supply, or across the motor winding all result in an overcurrent shutdown. Note that overcurrent protection does not use the current sense circuitry used for PWM current control, so it functions even without presence of the xISEN resistors.

#### *7.3.8.2 Thermal Shutdown (TSD)*

If the die temperature exceeds safe limits, all FETs in the H-bridge are disabled and the nFAULT pin is driven low. After the die temperature has fallen below the specified hysteresis  $(T_{HYS})$ , operation automatically resumes. The nFAULT pin is released after operation has resumed.

#### *7.3.8.3 UVLO*

If at any time the voltage on the  $V_M$  pin falls below the UVLO threshold voltage,  $V_{UVLO}$ , all circuitry in the device is disabled, and all internal logic is reset. Operation resumes when  $V_M$  rises above the UVLO threshold. The nFAULT pin is not driven low during an undervoltage condition.



<span id="page-12-1"></span>

#### **Table 3. Device Protection**

### <span id="page-12-0"></span>**7.4 Device Functional Modes**

The DRV8833C is active unless the nSLEEP pin is brought logic low. In sleep mode, the H-bridge FETs are disabled (Hi-Z). Note that  $t_{SLEEP}$  must elapse after a falling edge on the nSLEEP pin before the device is in sleep mode. The DRV8833C is brought out of sleep mode automatically if nSLEEP is brought logic high. Note that  $t_{\text{WAKE}}$  must elapse before the outputs change state after wake-up.

#### **Table 4. Modes of Operation**



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## <span id="page-13-0"></span>**8 Application and Implementation**

### <span id="page-13-1"></span>**8.1 Application Information**

The DRV8833C is used in stepper or brushed DC motor control. The following design procedure can be used to configure the DRV8833C in a bipolar stepper motor application.

### <span id="page-13-2"></span>**8.2 Typical Application**



#### **8.2.1 Design Requirements**

<span id="page-13-3"></span>[Table 5](#page-13-3) gives design input parameters for system design.

<b>Design Parameter</b>	Reference	<b>Example Value</b>
Supply voltage	Vм	9 V
Motor winding resistance	$\mathsf{R}_{\mathsf{L}}$	12 $\Omega$ /phase
Motor winding inductance	ч	10 mH/phase
Motor full step angle	$\Theta_{\text{step}}$	1.8 $\degree$ /step
Target stepping level	$n_{m}$	2 (half-stepping)
Target motor speed	v	$120$ rpm
Target chopping current	<b>I</b> CHOP	200 mA
Sense resistor	$R_{\mathsf{ISEN}}$	1 O

**Table 5. Design Parameters**

#### **8.2.2 Detailed Design Procedure**

#### *8.2.2.1 Stepper Motor Speed*

The first step in configuring the DRV8833C requires the desired motor speed and stepping level. The DRV8833C can support full- and half-stepping modes using the PWM interface.

If the target motor speed is too high, the motor does not spin. Ensure that the motor can support the target speed.

For a desired motor speed (v), microstepping level (n<sub>m</sub>), and motor full step angle ( $\theta_{\text{step}}$ ),

$$
f_{\text{step}}\left(\text{steps}/\text{s}\right) = \frac{\text{v(rpm)} \times \text{n}_{\text{m}}\left(\text{steps}\right) \times 360^{\circ}/\text{rot}}{\theta_{\text{step}}\left(\text{°}/\text{step}\right) \times 60 \text{ s}/\text{min}}
$$

(2)



AIN1 AIN2 BIN1 BIN2 **I**AOUT Forward Reverse AIN1 AIN2 BIN1 BIN2 IAOUT IBOUT Forward Reverse Forward **Forward** Forward **Forward** Reverse **Figure 10. Full-Step Mode**



Forward **Forward** Forward

#### <span id="page-14-0"></span>*8.2.2.2 Current Regulation*

**I**BOUT

The chopping current ( $I_{CHOP}$ ) is the maximum current driven through either winding. This quantity depends on the sense resistor value  $(R_{XISEN})$ .

$$
I_{CHOP} = \frac{200 \text{ mV}}{R_{XISEN}}
$$

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(3)

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**STRUMENTS** 

XAS

<span id="page-15-0"></span> $I_{CHOP}$  is set by a comparator which compares the voltage across  $R_{XISEN}$  to a reference voltage. Note that  $I_{CHOP}$ must follow [Equation 4](#page-15-0) to avoid saturating the motor.

$$
I_{FS}(A) < \frac{VM(V)}{R_{L}(\Omega) + R_{DS(ON)}HS(\Omega) + R_{DS(ON)}LS(\Omega)}
$$

where

- $V_M$  is the motor supply voltage.
- $R_L$  is the motor winding resistance.  $(4)$

#### **8.2.3 Application Curve**



A. Channel 1 is the AIN1 input PWM signal, and channel 2 is the AIN2 input PWM signal. BIN1 and BIN2 follow the same pattern, but are shifted by 90° from AIN1 and AIN2 as shown in [Figure 11](#page-14-0). Channel 4 is the output current in the direction AOUT1  $\rightarrow$  AOUT2. In forward and reverse drive, the current rises until it hits the current chopping limit of 200 mA, and is regulated at that level with fixed-off time current chopping.





#### <span id="page-16-0"></span>**9 Power Supply Recommendations**

The DRV8833C is designed to operate from an input voltage supply  $(V_M)$  range between 2.7 to 10.8 V. A 10- $\mu$ F ceramic capacitor rated for  $V_M$  must be placed as close to the DRV8833C as possible.

#### <span id="page-16-1"></span>**9.1 Sizing Bulk Capacitance for Motor Drive Systems**

Bulk capacitance sizing is an important factor in motor drive system design. It depends on a variety of factors including:

- Type of power supply
- Acceptable supply voltage ripple
- Parasitic inductance in the power supply wiring
- Type of motor (brushed DC, brushless DC, stepper)
- Motor startup current
- Motor braking method

The inductance between the power supply and motor drive system limits the rate current can change from the power supply. If the local bulk capacitance is too small, the system responds to excessive current demands or dumps from the motor with a change in voltage. Size the bulk capacitance to meet acceptable voltage ripple levels.

The data sheet generally provides a recommended value, but system-level testing is required to determine the appropriate-sized bulk capacitor.



**Figure 13. Setup of Motor Drive System With External Power Supply**

### <span id="page-17-0"></span>**10 Layout**

#### <span id="page-17-1"></span>**10.1 Layout Guidelines**

Bypass the V<sub>M</sub> terminal to GND using a low-ESR ceramic bypass capacitor with a recommended value of 10  $\mu$ F rated for V<sub>M</sub>. This capacitor should be placed as close to the V<sub>M</sub> pin as possible with a thick trace or ground plane connection to the device GND pin and PowerPAD.

Bypass VINT to ground with a ceramic capacitor rated 6.3 V. Place this bypassing capacitor as close to the pin as possible.

#### <span id="page-17-2"></span>**10.2 Layout Example**



**NSTRUMENTS** 

**FXAS** 



### <span id="page-18-0"></span>**11 Device and Documentation Support**

#### <span id="page-18-1"></span>**11.1 Trademarks**

PowerPAD is a trademark of Texas Instruments.

#### <span id="page-18-2"></span>**11.2 Electrostatic Discharge Caution**



These devices have limited built-in ESD protection. The leads should be shorted together or the device placed in conductive foam during storage or handling to prevent electrostatic damage to the MOS gates.

### <span id="page-18-3"></span>**11.3 Glossary**

[SLYZ022](http://www.ti.com/lit/pdf/SLYZ022) — *TI Glossary*.

This glossary lists and explains terms, acronyms, and definitions.

### <span id="page-18-4"></span>**12 Mechanical, Packaging, and Orderable Information**

The following pages include mechanical, packaging, and orderable information. This information is the most current data available for the designated devices. This data is subject to change without notice and revision of this document. For browser-based versions of this data sheet, refer to the left-hand navigation.



### **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".

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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  $\leq 1000$ ppm 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.

<sup>(6)</sup> 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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#### **TAPE AND REEL INFORMATION**

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#### **QUADRANT ASSIGNMENTS FOR PIN 1 ORIENTATION IN TAPE**







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# **PACKAGE MATERIALS INFORMATION**

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\*All dimensions are nominal



### **TEXAS INSTRUMENTS**

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### **TUBE**



### **B - Alignment groove width**

\*All dimensions are nominal



# **GENERIC PACKAGE VIEW**

# **RTE 16 WQFN - 0.8 mm max height**

**3 x 3, 0.5 mm pitch** PLASTIC QUAD FLATPACK - NO LEAD

This image is a representation of the package family, actual package may vary. Refer to the product data sheet for package details.







# **PACKAGE OUTLINE**

# **RTE0016C** WQFN - 0.8 mm max height

PLASTIC QUAD FLATPACK - NO LEAD



#### 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.
- 3. The package thermal pad must be soldered to the printed circuit board for thermal and mechanical performance.



# **EXAMPLE BOARD LAYOUT**

# **RTE0016C WQFN - 0.8 mm max height**

PLASTIC QUAD FLATPACK - NO LEAD



4. This package is designed to be soldered to a thermal pad on the board. For more information, see Texas Instruments literature number SLUA271 (www.ti.com/lit/slua271).

5. Vias are optional depending on application, refer to device data sheet. If any vias are implemented, refer to their locations shown on this view. It is recommended that vias under paste be filled, plugged or tented.



# **EXAMPLE STENCIL DESIGN**

# **RTE0016C WQFN - 0.8 mm max height**

PLASTIC QUAD FLATPACK - NO LEAD



6. Laser cutting apertures with trapezoidal walls and rounded corners may offer better paste release. IPC-7525 may have alternate design recommendations.



# **GENERIC PACKAGE VIEW**

# **PWP 16**

# **PowerPAD<sup>™</sup> TSSOP - 1.2 mm max height**<br>PLASTIC SMALL OUTLINE



Images above are just a representation of the package family, actual package may vary. Refer to the product data sheet for package details.





# **PACKAGE OUTLINE**

# **PWP0016C**  $\bullet$  <sup>53</sup><sup>5</sup> PowerPAD<sup>™</sup> TSSOP - 1.2 mm max height

SMALL OUTLINE PACKAGE



NOTES:

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- 2. This drawing is subject to change without notice.
- 3. This dimension does not include mold flash, protrusions, or gate burrs. Mold flash, protrusions, or gate burrs shall not exceed 0.15 mm per side.
- 4. Reference JEDEC registration MO-153.
- 5. Features may differ or may not be present.



# **EXAMPLE BOARD LAYOUT**

# **PWP0016C PowerPAD TSSOP - 1.2 mm max height** TM

SMALL OUTLINE PACKAGE



NOTES: (continued)

- 6. Publication IPC-7351 may have alternate designs.
- 7. Solder mask tolerances between and around signal pads can vary based on board fabrication site.
- 8. This package is designed to be soldered to a thermal pad on the board. For more information, see Texas Instruments literature numbers SLMA002 (www.ti.com/lit/slma002) and SLMA004 (www.ti.com/lit/slma004).
- 9. Size of metal pad may vary due to creepage requirement.
- 10. Vias are optional depending on application, refer to device data sheet. It is recommended that vias under paste be filled, plugged or tented.



# **EXAMPLE STENCIL DESIGN**

# **PWP0016C PowerPAD TSSOP - 1.2 mm max height** TM

SMALL OUTLINE PACKAGE



11. Laser cutting apertures with trapezoidal walls and rounded corners may offer better paste release. IPC-7525 may have alternate design recommendations.

12. Board assembly site may have different recommendations for stencil design.



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