

Guidelines for Chip
Design For Test (DFT)
Based on Boundary Scan or JTAG

Prepared by

Ben Bennetts, DFT Consultant

for ASSET InterTech, Inc.

April 2006

ABSTRACT:

This document is DFT Guidelines for devices to be tested primarily through the use of boundary scan/JTAG, based on the IEEE 1149.1-2001 Standard.


Any comments, corrections, suggested additions should be sent to the author, Ben Bennetts, at ben@dft.co.uk.

About The Author/Presenter

Easy, Affordable, Powerful



Dr R G "Ben" Bennetts is an independent consultant in Design-For-Test (DFT), consulting in product life-cycle DFT strategies, and delivering on-site and open educational courses in DFT technologies.

Previously, he has worked for **LogicVision**, **Synopsys**, **GenRad** and **Cirrus Computers**. Between 1986 and 1993, he was a free-lance consultant and lecturer on Design-for-Test (DFT) topics. During this time, he was a member of **JTAG**, the organization that created the IEEE 1149.1 Boundary-Scan Standard.



He is currently an Advisor to the Board of Directors of **ASSET InterTech**, advising the company on future directions of boundary-scan technology. He is also a core-group member of **IJTAG** and **SJTAG** (and currently the SJTAG Chairman), a co-founder and past Program Chair of the IEEE **Board Test Workshop**, founder of the IEEE **European Board Test Workshop**, and the founder and current Chairman of the IEEE's **BTAC** organisation.

Ben has published over 100 papers plus three books on test and DFT subjects.


© 2006, Bennetts Associates
ASSET InterTech, Inc.
Slide 3
Last revised: March 2006


DFT Guidelines

Easy, Affordable, Powerful

**Boundary-Scan Testability:
Device-Level Guidelines**

**Ben Bennetts, DFT Consultant
Bennetts Associates, UK**

Tel: +44 1489 581276 E-mail: ben@dft.co.uk
<http://www.dft.co.uk/>


© 2006, Bennetts Associates
ASSET InterTech, Inc.
Slide 4
Last revised: March 2006


In this document, we will look at DFT guidelines specific to the design of devices to be tested through the boundary-scan (JTAG) registers of IEEE 1149.1-compliant devices. Since the 1149.1 structures are incorporated inside the compliant devices, many of the guidelines relate to the specification of optional features inside the devices i.e. are device-level DFT guidelines. Accordingly, the first part of the document considers the device-level guidelines.

Easy, Affordable, Powerful

Device-Level DFT Guidelines

At the Device level:

Board Test Engineers

Device Designers


Device Procurement

System Engineers


Board Designers

Field Service Engineers

Discuss the requirements with board designers and test engineers, system engineers, field-service engineers and procurement people. They drive the specification.

 © 2006, Bennetts Associates
ASSET InterTech, Inc.

Slide 5
Last revised: March 2006

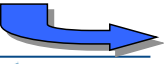



First and foremost, we should ask “who drives the specification for JTAG/boundary-scan features inside new ASICs and SoC devices?”. The answer is “all those who will benefit from the use of boundary scan” – that is, prototype board debug engineers, board test programmers, system integrators, and field service repair engineers. It’s also worth adding device procurement people to the group. This makes such people conscious of the need to buy 1149.1-compliant devices. Consequently, the correct way to specify the 1149.1 features in a new ASIC or SoC is for all these people to sit down and decide the product life-time strategy for testing the boards. Each engineer will have a different view of the requirements specification and, collectively, the group can try to come up with a consensus view of the overall requirement, but note: obtaining a consensus view can be difficult!!

Once specified, the requirement can be presented to the chip designer in the form of a BSDL file. But note that some 1149.1 chip-level boundary-scan (JTAG) synthesis programs cannot accept BSDL as an input specification. Check with your vendor.

Specify 1149.1 Compliance


Easy, Affordable, Powerful

- ❑ For all ASICs/SoCs, produce an internal default specification for 100%-compliant 1149.1 requirements including:
 - **CLAMP** and/or **HIGHZ**, to support PLD and FLASH programming and reduce problems of back-driving,
 - **INTEST** to support limited parallel test access to the device
 - **INSCAN** (Scan-thru-TAP) and **RUNBIST** to support board-level re-use of internal DFT structures for diagnostics
 - **IDCODE** to allow part number and version number identification
 - **USERCODE** in PLDs (mandatory in 1532-compliant devices)
 - Scan cells on all digital IO pins except Compliance-Enable, Power and Ground pins
 - 1149.4, for mixed-signal devices
 - 1149.6, for AC-coupled LVDS devices e.g. SERDES devices
- ❑ For all 1149.1 devices, check device and BSDL compliance 



© 2006, Bennetts Associates
ASSET InterTech, Inc.

Slide 6
Last revised: March 2006



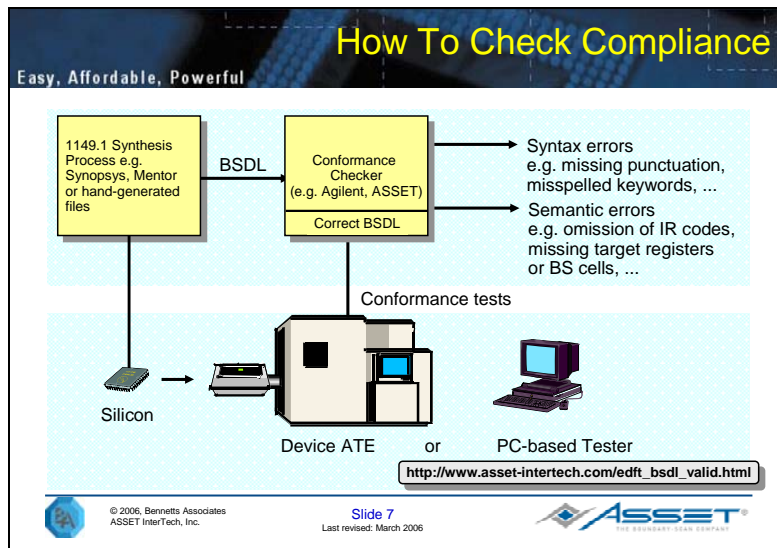
All devices should be 100% compliant with the 1149.1 Standard.

It is a good habit to specify all the optional public instructions (e.g. IDCODE, CLAMP, HIGHZ, etc) by default and only remove them if it can be shown that they will never be used or that they cause violation of another design requirement. IDCODE allows identification of the device manufacturer plus the part number and version number. It also supports a higher-quality board-level scan-chain integrity test.

IC vendors should have checked all 1149.1 features before shipping the parts to system companies. Make sure they have done this. You do not want to find a faulty 1149.1 part once it has been bonded to the board.

Strictly speaking, there should not be any non-compliant 1149.1 devices!! But, if the vendor has done something that does not comply (tying TRST* low inside the device is a common non-compliant feature), make sure the non-compliance is documented. Non-compliance can be documented in the Design Warnings section of a BSDL file.

Last, but not least, validate the BSDL files – next slide.



As you will appreciate, the BSDL files must be 100% accurate. Any slight error in the data can completely disrupt the board-level pattern generation processes and cause anomalous behavior which can become very difficult to diagnose correctly. It is strongly recommended that BSDL files are checked both syntactically and semantically before they are used by the board-level pattern-generation and pattern-application processes. There are commercial checkers available, from companies such as ASSET InterTech (www.asset-intertech.com).

The final proof of correctness is to compute 1149.1 conformance tests from the apparently correct BSDL, and then apply these tests to a device on either a chip tester or even a PC-based tester. You are strongly urged to carry out both the syntax and semantic tests, and then to generate and apply conformance tests on real silicon before using BSDL files “in anger”.

Assigning IO and OZ Control Cells

Easy, Affordable, Powerful

Assign internally-generated IO and OZ BS control cells to match the normal use of groups of IO or OZ pins to avoid problems at board level.

© 2006, Bennetts Associates
 ASSET InterTech, Inc. Slide 8 Last revised: March 2006

Bidirectional (IO) and three-state (OZ) pins require status-control JTAG or boundary-scan cells so that their status can be controlled whilst the device is in its test mode. Often the status control is based on an input pin, such as an *Output_Enable* pin. If the control is internal, extra boundary-scan (JTAG) cells are inserted in the JTAG register. Such scan cells should control the IO and OZ pins in a way that conforms to the natural use of the IO or OZ pins. This prevents unnatural test configurations at board level that might place other on-board devices into a potentially dangerous state.

TRST* Signal

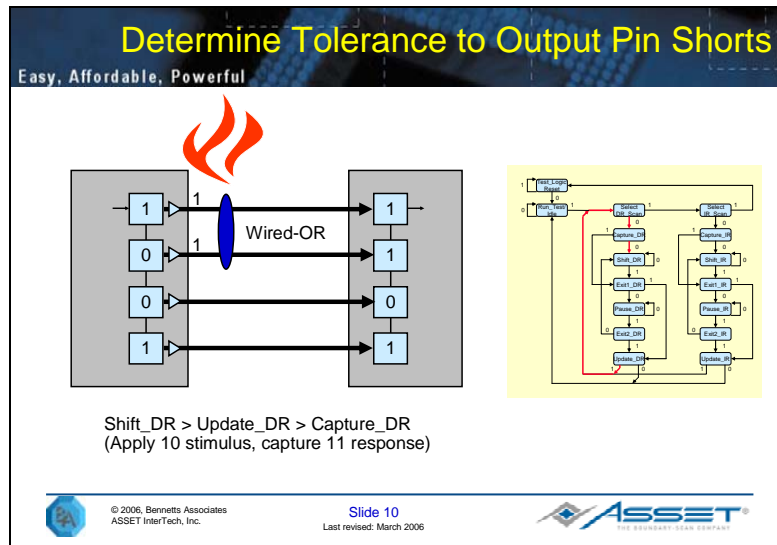
Easy, Affordable, Powerful

- TRST* signal is optional
- Make the default to insert TRST*. It solves a board test problem.
- If TRST* is not inserted, the TAP controller must power up in the Test-Logic/Reset state: check with your boundary-scan synthesis tool supplier
- If TRST* is inserted, there is no requirement for the POR circuit but add it in anyway – see board DFT guidelines

© 2006, Bennetts Associates
 ASSET InterTech, Inc. Slide 9 Last revised: March 2006

TRST* is an optional active-low asynchronous reset signal for the 1149.1 logic. There always exists a synchronous reset, initiated by holding the TMS signal at logic 1 and applying five consecutive TCK clocks (the so-called "TMS = 1, 5 x TCK" cycle) but, as we will see later when we reach the board guidelines section, there

are very good reasons to also incorporate the optional TRST* feature. There are also very good reasons to insert a Power-On-Reset (POR) circuit to the TAP controller even if the optional TRST* is inserted. Note: POR is not mandated if the TRST* signal is inserted.



It is ironic that the only way to find pin-to-pin shorts at the board level is by deliberately creating contention on two driver scan cells i.e. causing one driver to drive a logic 1 and the other to drive a logic 0. If the short is present, then we assume that it is either a strong-1 weak-0 (Wired-OR) short or weak-1 strong-0 (Wired-AND) short. Such a test places a stress on the output drivers since one output will dominate, forcing the other to its opposite logic value and possibly damaging the output drive amplifier of the weaker signal. In the world of in-circuit test, this problem is known as *node forcing* or *back driving* and steps can be taken to reduce the amount of time the outputs are under stress. In the JTAG or boundary scan world, the time it takes to apply all the interconnect tests is a function of the complete length of the boundary-scan/JTAG chain, the number of interconnect patterns, and the frequency of TCK. This time may become too long and irreversible damage can occur to one of the output drivers. You will need to determine the vulnerability of the outputs to such damage.

In the example above, the assumption is that the short behaves like a strong 1 weak 0 (Wired-OR) short, and the initial 10 stimulus values in the driver scan cells are received as 11 response values in the sensor scan cells. Once the received values are off-loaded from the board, the presence of the short will be known.

Increasing Short-Circuit Coverage

Easy, Affordable, Powerful

- ❑ If the output scan cells are BC_1s, a pin-to-pin short between Net 1 and Net 2 is not detectable at the receiving non-BS device.
- ❑ Replacing the BC_1s with, for example, bi-directional BC_7s will allow detection of the pin-to-pin short at the transmit end.

© 2006, Bennetts Associates
 ASSET InterTech, Inc.

Slide 11
Last revised: March 2006

The figure shows a JTAG/boundary-scan device connected to a non-boundary-scan device. The existence of the short is not detectable by the boundary-scan/JTAG structure if the output boundary-scan cells are drive-only cells e.g. BC_1s. The pattern can be set up and applied but there is no JTAG/boundary-scan visibility of the response values. Consequently, there will be a loss of defect coverage unless the driver scan cell can also become a sensor. This can be achieved by replacing the drive-only boundary-scan cells with drive-and-sense boundary-scan cells, such as a BC_7: next slide

Using BC_7 Boundary-Scan Cells

Easy, Affordable, Powerful

© 2006, Bennetts Associates
 ASSET InterTech, Inc.

Slide 12
Last revised: March 2006

The BC_7 scan cell is especially designed for bidirectional signal pins and when in Drive mode, it is able to Sense the value of the driven signal i.e. the BC_7 is a self-sensing boundary-scan cell. Using BC_7s instead of BC_1s will allow detection of shorts between boundary-scan (JTAG) and non-boundary-scan devices, thereby increasing the defect coverage on the board.

Avoiding Ground Bounce

Easy, Affordable, Powerful

Figure 1. (left) Swinging out of phase demonstrates how out-of-phase outputs cancel, and there is no ground bounce. (right) Swinging in the same direction demonstrates in-phase outputs, adding up to ground bounce.

© 2003 IEEE
 Bob Colwell, "Ground Bounce", IEEE Computer, March 2003, pp. 11 - 13

© 2006, Bennetts Associates
 ASSET InterTech, Inc. Slide 13
 Last revised: March 2006

An interesting way of illustrating the phenomenon of ground bounce.

Reproduced with permission of the IEEE Computer Society.

Internal Ground Bounce

Easy, Affordable, Powerful

- ❑ Ensure no ground bounce in worst-case **EXTEST** mode i.e. all BS cells changing simultaneously. Note: this is a requirement of the Standard
- ❑ OK to skew TCK (UpdateDR) or Mode controls inside the device to reduce ground-bounce possibility.

© 2006, Bennetts Associates
 ASSET InterTech, Inc. Slide 14
 Last revised: March 2006

Ground bounce is a dip in the DC supply voltage caused by a sudden power surge and, if it occurs it can disrupt the operation of the TAP controller. The 1149.1 Standard states that there should be no ground bounce inside a compliant device under worst-case switching conditions in the JTAG (boundary-scan) cells – for example, if all output scan cells were updated from, say, all-1s to all-0s. It's interesting to ask whether an 1149.1 synthesis tool actually checks this requirement!!

Access to Internal DFT for Re-Use

Easy, Affordable, Powerful

- ❑ Allow access to internal scan and BIST through the TAP for re-use at board, system and field-service test
- ❑ Supports a board debug situation

The more you know about what is working, the more you know about what is not working.

© 2006, Bennetts Associates
ASSET InterTech, Inc. Slide 15
Last revised: March 2006

Allowing access to other internal chip DFT features, such as internal scan (known as *Scan Thru TAP*) and internal memory BIST or logic BIST (using RUNBIST-like instructions) allows re-use of these features once the chip is assembled to the board. Such re-use supports improved board-level diagnostics.

Re-Using Device Internal DFT Structures

Easy, Affordable, Powerful

- ❑ Be aware that **RUNBIST**, **INTEST** or "**INSCAN**" (Scan thru TAP) modes causes unnatural behaviour inside the device
 - For **RUNBIST** and **INTEST**: devices are in test mode, not functional mode. Device outputs are controlled by boundary-scan cells (**PRELOADED** with safe values) or placed in a disabled non-drive mode.
 - For **INSCAN** application of tests through the internal scan chains, it is better if the device is in test mode, similar to **RUNBIST** or **INTEST** above
 - Provide simple master device RESETs to re-establish operational functional modes

© 2006, Bennetts Associates
ASSET InterTech, Inc. Slide 16
Last revised: March 2006

Using the optional RUNBIST or INTEST public instructions places the device in test mode. The outputs of the device are under the control of the boundary scan/JTAG register cells and can either be preloaded with safe values (using the PRELOAD instruction) or placed in a disabled non-drive (high impedance) state.

Using private instructions such as “INSCAN” to access internal scan paths (sometimes called “Scan Thru TAP”), the values driven out of the device output pins should also be under the control of the JTAG/boundary scan register cells and can either be preloaded with safe values (using the PRELOAD instruction) or placed in a disabled non-drive (high impedance) state.

Safe States: Power-Up

Easy, Affordable, Powerful

□ Power-Up: Auto power-up into safe states i.e three-state (OZ pins) in Z mode, bidirectional outputs (IO pins) in I mode

Input High-Z

Slide 17
Last revised: March 2006

ASSET
THE BOUNDARY-SCAN COMPANY

In general, it is desirable that boundary-scan (and non-boundary-scan) devices power up in safe states. That is, three-state outputs power up with their outputs in the high-Z state, and bidirectional outputs power up in the input mode rather than their output drive mode. In this way, the risk of powering up into a state of contention (bus fight) is reduced. Safe-state power up can be achieved by internal power-on circuitry (preferred) or by controlling *Output_Enable* control cells via their boundary-scan/JTAG cells and using the PRELOAD instruction during board initialisation (not so good as the board may power up in an unsafe state to start with).

Safe States: EXTEST

Easy, Affordable, Powerful

□ EXTEST: During the use of the EXTEST test-mode instruction, ensure that values updated into devices from, e.g. BC-1s, are safe values for the functional logic

New Stimulus update Update of residual values from previous test

Slide 18
Last revised: March 2006


ASSET
THE BOUNDARY-SCAN COMPANY

During the update operation of test-mode instructions, such as EXTEST, values on BC_1 or BC_2 input scan cells are updated into the functional logic. Ensure that the board-level interconnect pattern-generation algorithm will generate safe values into the functional logic (difficult) or, alternatively, ensure that the functional logic can accept any input from the boundary-scan (JTAG) cells without the risk of damage (easier).

TAP Pin Layout
Easy, Affordable, Powerful

□ Keep TAP pins away from each other and physically adjacent to:

- Pins that are directly connected to Power and Ground (shorts to power-supply lines are deterministic "well-behaved", or
- Pins that are "strong" 0s and 1s e.g. pins that are pulled low or high, or
- Pins that are Not-Connected (NC) pins i.e. floating



© 2006, Bennetts Associates
ASSET InterTech, Inc.

Slide 19
Last revised: March 2006

ASSET
THE BOUNDARY-SCAN COMPANY

Placing TDI, TDO, TMS, TRST* and TCK pins close to Power and Ground pins means that shorts will behave very deterministically as strong stuck-at-1 or stuck-at-0 faults appropriately. It also reduces the risk of crosstalk thereby creating higher signal integrity, especially on TCK.

The next slide illustrates how a short between an adjacent TDI and TDO pin, although detectable, can create an incorrect diagnosis.

More on TDI and TDO Pin Allocation

Easy, Affordable, Powerful

☐ Separate adjacent TDI/TDO pins, preferably with power or ground pins

Expected	01	01	01	01
Actual	00	01	01	01

Diagnosis suggests chip 1, not chip 2

One solution: add nails to resolve diagnostic ambiguity

© 2006, Bennetts Associates
ASSET InterTech, Inc.

Slide 20
Last revised: March 2006

ASSET
THE PROBE-TEST COMPANY

In this example, the TDI and TDO pins of Chip 2 are assumed to be shorted together during the integrity test based on placing the Instruction Register in the active path and capturing and shifting out the captured hardwired 01. If each instruction register is just 2 bits long (the minimum length) and the short behaves like a Wired-AND short, then the actual values will differ from the expected values but the diagnosis suggests that the problem is associated with Chip 1, not Chip 2.

Note: if the short behaves like a Wired-OR short, the detection will occur on the second sentinel bit. The reader is invited to “check out the 1s and 0s”. The reader is also invited to see what would happen if the alternative integrity test, based on selecting the default Identification or Bypass register, is applied.

Note: if there is an open between a TDO-to-TDI connect, this will result in all downstream values becoming logic-1s because of the requirement for an open-circuit TDI to rise to logic 1. Detection of the open is not difficult but diagnosing the source of the open is ambiguous – is it at the exit TDO pin or the entry TDI pin? Diagnosis to the source of the open-circuit is assisted if the TDO-to-TDI interconnect can be probed, either with a bed-of-nails probe (in-circuit test or flying probe) or more simply with an oscilloscope probe. Adding a test point to the TDO-to-TDI interconnect facilitates the use of a ‘scope probe.

Easy, Affordable, Powerful

Reduced Pin-Count Test

Not another untestable design?

2000 IO Pins

1024 D/S Channels

The diagram shows a person with a speech bubble asking 'Not another untestable design?' looking at a test system. The system consists of a large cabinet with a monitor and a smaller unit with a test head. A purple arrow points from a 2000-pin chip to the test head. The text '1024 D/S Channels' is positioned below the test head.

© 2006, Bennetts Associates
ASSET InterTech, Inc.

Slide 21
Last revised: March 2006

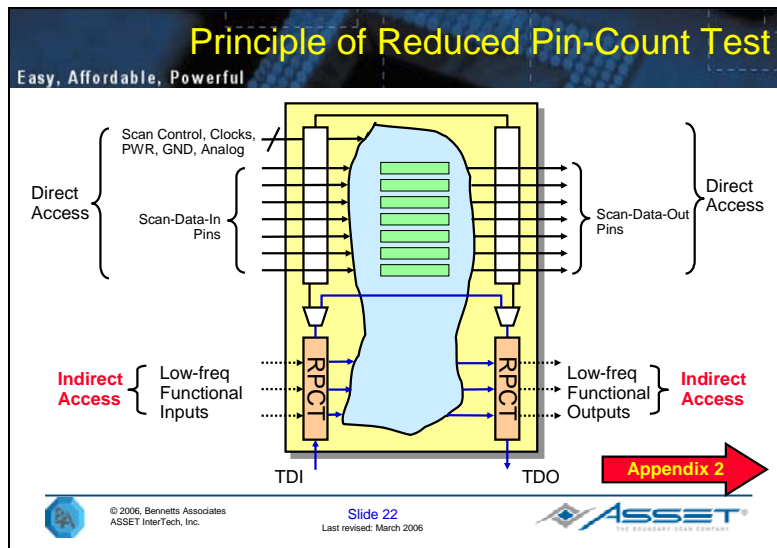
ASSET
THE BOUNDARY-SCAN EXPERT

Problem:

How to test a 2000-pin chip on a 1024-Driver/Sensor channel tester?

Solution 1: Buy another 876 DS channels at \$2K each (= \$1.752M extra capital investment)

Solution 2: Use 876 bits of the JTAG (boundary-scan) register to indirectly access the low-frequency pins, at zero extra cost. Called Reduced Pin Count Test (RPCT)



Reduced pin count test (RPCT) is becoming popular as a way of keeping down the cost of test for devices that are “fully loaded” with internal scan, BIST and 1149.1 boundary scan or JTAG. Companies such as IBM, Motorola and now Philips are using part of the boundary-scan/JTAG register to access the low data-rate functional pins of a device in lieu of engaging these pins through a dedicated driver/sensor pin channel. High data-rate pins, such as *Scan-In*, *Scan-Out* and *Clock* pins are contacted directly. The boundary-scan or JTAG register is designed to allow segments to be addressed through the TAP using private instructions, such as INTEST-RPCT. The addressed segment is used for serial-to-parallel access on the input side, and parallel-to-serial access on the output side. The remainder of the boundary-scan register is left in transparent mode.

Why RPCT?

Easy, Affordable, Powerful

- ❑ Reduces cost of test: re-use older testers; no need to buy more D/S channels
- ❑ Reduces number of probe points during wafer probe
 - Lower cost
 - Lower contact problems
- ❑ Enables multi-site testing at both wafer probe and packaged die test
- ❑ High data-rate D/S channels (scan-in, scan-out) can share memory
- ❑ Only a few high-speed, high resolution pins needed e.g. for clocks
- ❑ Enables DC and AC parametric testing (ITC2002, P16.2):
 - DC: Output VOL, IOL, VOH, IOH: Input VIL, VIH: Pin leakage currents IIL, IIH, IOZ
 - AC (path delay defects): HF clock rate, power rail quality (ground bounce problems)

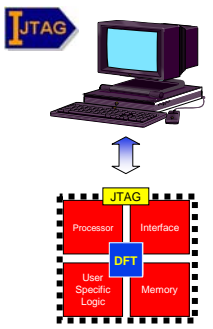
© 2006, Bennetts Associates
ASSET InterTech, Inc.
Slide 23
Last revised: March 2006
ASSET
THE BOUNDARY-SCAN EXPERT

The slide summarises some of the advantages of RPCT.

Chip-Level use of JTAG "In a Nutshell"

Easy, Affordable, Powerful


1149.1 Port Used:



- For reduced pin count test
- Re-use of internal scan chains for "peek and poke" design validation
- Reconfigure internal scan chains to support improved defect diagnostics
- Functional test via control of processor core emulation
- Core access and isolation for core-internal and core-to-core interconnect test
- Memory BIST/logic BIST controller
- Control of decompress/compress operations for test data compression scan test.
- Control of detect/locate modes using the Instruction Register or private instructions
- In-system configuration of internal flash
- Control of embedded test instrumentation
- Controlling programmable PLLs
- Controlling reconfigurable IO pins
- Power management
- Clock control
- Etc.

© 2006, Bennetts Associates
ASSET InterTech, Inc.

Slide 24
Last revised: March 2006



Chip designers are using the IEEE Std 1149.1 (JTAG) Test Access Port not just for its intended purpose of providing access to boundary scan test functions, but increasingly as a way of gaining access to a variety of internal test features for prototype chip design validation and structural test purposes. This trend is of great interest across the industry, from IP providers to EDA and ATE companies to system integrators. Providing for and gaining access to on-chip test features helps address a wide range of test challenges. While IEEE Std 1149.1 provides very generic support for internal test access, these new applications have begun to stretch the architectural requirements of IEEE Std 1149.1 and have clearly pointed out the need for better methods of describing and accessing internal test features. In response, an *ad hoc* group has decided to take a closer look at what chip designers are implementing, what problems they are encountering with TAP-based access, and what extensions would be useful to them. Once the problems are understood, it may be possible to develop standard solutions.

Jeff Rearick (Agilent Technologies) kicked off the IJTAG initiative at ITC 2004. The objectives of the group are to understand the full range of "new" device-level applications of IEEE Std 1149.1 i.e. the "what" and "why", and then to understand the current limitations of 1149.1 that either prevent or make it difficult to use 1149.1 in a specific way. Currently, it is not the intention of the group to determine whether the 1149.1 Standard should be upgraded one more time. Essentially, the objectives of the group are to standardize the protocols and associated tools without compromising compliance to the 2001 version of the Standard.



The unofficial name for the initiative is IJTAG, where "I" stands for Internal i.e. the use of JTAG for device-internal applications. (You may also hear the initiative referred to as I-JTAG, iJTAG, 1149.i or 1149.x. IJTAG is preferred.) At the moment, the activity is focused on the needs of the designers and the test engineers of prototype High End-ASICs and SoCs.

The next public IJTAG meeting will take place at the 2005 VLSI Test Symposium, <http://www.tttc-vts.org/> If you are planning to attend VTS, this will be an opportunity for you to find out more. In the meantime, please register your interest in IJTAG by sending e-mail to Jeff Rearick at jeff_rearick@agilent.com.

To Probe Further Chip

Easy, Affordable, Powerful

- ❑ Ken Parker, "The boundary-scan handbook: analog and digital", Kluwer, 2003 (3rd Edition)
- ❑ Ken Parker, "Sorting out boundary-scan compliance problems" EDN, Dec 7, 1999
- ❑ Ken Posse, "The use of 1149.1 in DFT based IC testing", Proc. IEEE Test Resource Partitioning Workshop, 2001
- ❑ Stang and Dandapani (Astek Corp) "An implementation of 1149.1 ...", ITC02, P. 27.1
- ❑ Harald Vranken et al., "Enhanced RPCT for full-scan design", ITC01, P27.3. See also D&TC, July/Sept 1998 (IBM S/390 RPCT solution)
- ❑ Boundary-scan cells on Power and Ground? See ITC96, Tegethoff, Parker and Lee, Paper 12.2 See also, de Jong et al., ITC2000, P22.1, Schuttert et al. VTS 2002
- ❑ "Reducing time-to-market using BSDArchitect New edition", available from www.mentor.com/dft/


© 2006, Bennetts Associates
ASSET InterTech, Inc.
Slide 25
Last revised: March 2006




DFT Guidelines

Easy, Affordable, Powerful

**Appendix 1:
Guidelines for Device Buyers**

**Ben Bennetts, DFT Consultant
Bennetts Associates, UK**

Tel: +44 1489 581276 E-mail: ben@dft.co.uk
<http://www.dft.co.uk/>


© 2006, Bennetts Associates
ASSET InterTech, Inc.
Slide 26
Last revised: March 2006


This appendix contains a summary of guidelines for people who are not deep into the technicalities of boundary scan/JTAG but whom; nevertheless, influence the purchase decision to buy boundary-scan devices e.g. corporate buyers.

This Buyer's Checklist is designed to sensitise Buyers as to the importance of making sure that they purchase devices containing JTAG/boundary scan.

Boundary Scan: Buyers Checklist (1)

Easy, Affordable, Powerful

- Does the device contain boundary scan?
- If no, why not?
- If yes:
 - Check what level of the Standard was used: 1990, 1993, 1994, 2001?
 - Check the experience level of the vendor: how many years building 1149.1-compliant devices, how many different devices?
 - Has the vendor pre-tested the 1149.1 logic for compliance to the Standard and for structural defects?
 - How are these tests generated? Are they available for inspection?
 - Are these test carried out on production devices or just pre-production samples?
 - Has the vendor identified and documented all non-compliant features. (There should be none!!) Note: this is a big issue with prime source/second source RAMs, also with IP cores.
 - Find out how the vendor reacts when non-compliant features are discovered? Document or fix?
 - Ask: what 1149.1 synthesis program was used (robustness, maturity, etc.)?



© 2006, Bennetts Associates
ASSET InterTech, Inc.

Slide 27
Last revised: March 2006



Boundary Scan: Buyers Checklist (2)

Easy, Affordable, Powerful

- Has the vendor supplied and validated the BSDL file?
 - Is the BSDL file available with the device? If so, at what level of BSDL: 1990, 1994, 2001?
 - Check what software compliance tests were made on the BSDL file (syntax, semantics) and how the compliance tests were generated? Is there any notion of compliance certification?
 - Check: are all compliance-enable pins described in the BSDL file?
 - Check: if there are known non-compliant features in the design, are these all documented in the Design Warnings section of the BSDL file?
 - Was the silicon implementation checked against the BSDL content?
 - Ask: is there an audit trail for software and hardware compliance checking?
 - Ask: whether device re-spins automatically cause an update to BSDL files and how users are notified of any BSDL changes.



© 2006, Bennetts Associates
ASSET InterTech, Inc.

Slide 28
Last revised: March 2006



DFT Guidelines

Easy, Affordable, Powerful

Appendix 2: Reduced Pin Count Test

Ben Bennetts, DFT Consultant
Bennetts Associates, UK

Tel: +44 1489 581276 E-mail: ben@dft.co.uk
<http://www.dft.co.uk/>



© 2006, Bennetts Associates
ASSET InterTech, Inc.

Slide 29
Last revised: March 2006



Easy, Affordable, Powerful

Reduced Pin-Count Test

Not another untestable design?

2000 IO Pins

1024 D/S Channels

© 2006, Bennetts Associates
ASSET InterTech, Inc.

Slide 30
Last revised: March 2006

ASSET
THE BOUNDARY-SCAN COMPANY

Problem:

How to test a 2000-pin chip on a 1024-Driver/Sensor channel tester?

Solution 1: Buy another 876 DS channels at \$2K each (= \$1.75M extra capital investment)

Solution 2: Use 876 bits of the JTAG/boundary-scan register to indirectly access the low-frequency pins, at zero extra cost. Called Reduced Pin Count Test (RPCT)

Easy, Affordable, Powerful

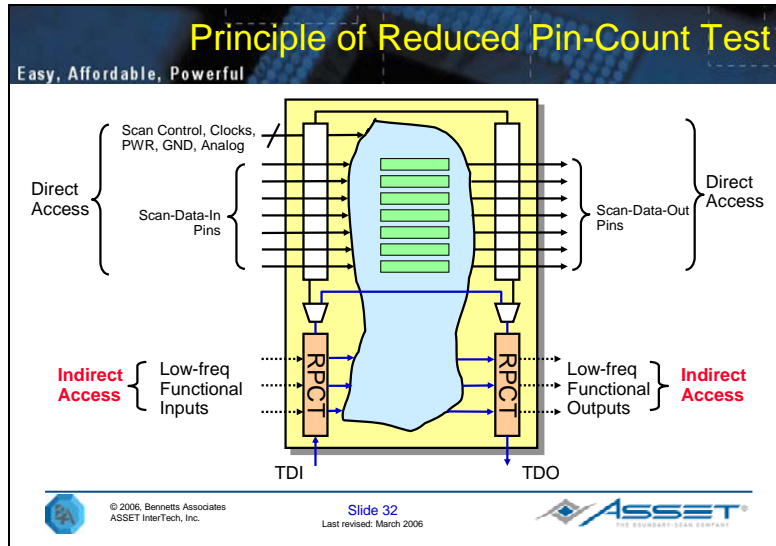
Solutions?

- How to test a 2000-pin chip on a 1024-Driver/Sensor channel tester?
- Solution1: buy another 876 DS channels at \$2K each (= \$1.75M extra capital investment)
- Solution 2: Use 876 bits of the boundary-scan register to indirectly access the low-frequency pins, at zero extra cost. Called Reduced Pin Count Test (RPCT)

© 2006, Bennetts Associates
ASSET InterTech, Inc.

Slide 31
Last revised: March 2006

ASSET
THE BOUNDARY-SCAN COMPANY



Reduced pin count test (RPCT) is becoming popular as a way of keeping down the cost of test for devices that are “fully loaded” with internal scan, BIST and 1149.1 boundary scan or JTAG. Companies such as IBM, Motorola and now Philips are using part of the boundary-scan register to access the low data-rate functional pins of a device in lieu of engaging these pins through a dedicated driver/sensor pin channel. High data-rate pins, such as Scan-In, Scan-Out and Clock pins are contacted directly. The boundary-scan register is designed to allow segments to be addressed through the TAP using private instructions, such as INTEST-RPCT. The addressed segment is used for serial-to-parallel access on the input side, and parallel-to-serial access on the output side. The remainder of the boundary-scan register is left in transparent mode.

- ## Why RPCT?
- Easy, Affordable, Powerful
- Reduces cost of external tester:
 - enables re-use of older testers;
 - no need to buy more D/S channels;
 - enables use of low-cost DFT testers.
 - Reduces number of probe points during wafer probe:
 - Lowers the cost of the probe card
 - Lower contact problems, thereby potentially reducing yield loss
 - Enables multi-site testing at both wafer probe and packaged die test to increase throughput.
 - Only a few high-speed, high resolution pins needed e.g. for clocks.
- At the bottom of the slide, there is a copyright notice: © 2006, Bennetts Associates ASSET InterTech, Inc. and the ASSET logo.

The slide summarises some of the advantages of RPCT.

Impact on 1149.1 Implementation

Easy, Affordable, Powerful

- ❑ Will need special boundary-scan cells on the RPCT segment – see later.



- ❑ It would seem that RPCT requires the optional *INTEST* instruction to be implemented in the instruction set but ...
- ❑ ... BScan cells not used during the RPCT mode e.g. on SDI/SDO, Scan-Enable pins, must be transparent. This means that any special RPCT instructions should leave the device in its functional mode, not test mode.



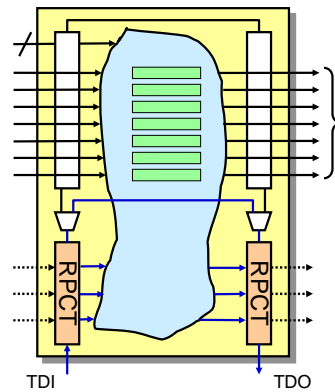
© 2006, Bennetts Associates
ASSET InterTech, Inc.

Slide 34
Last revised: March 2006



Internal/External Surround Register

Easy, Affordable, Powerful



- ❑ RPCT could be implemented with a simple internal or external Surround Register around the lower-frequency Functional Inputs but then all the other advantages of 1149.1 at the chip (and board) level would be lost.



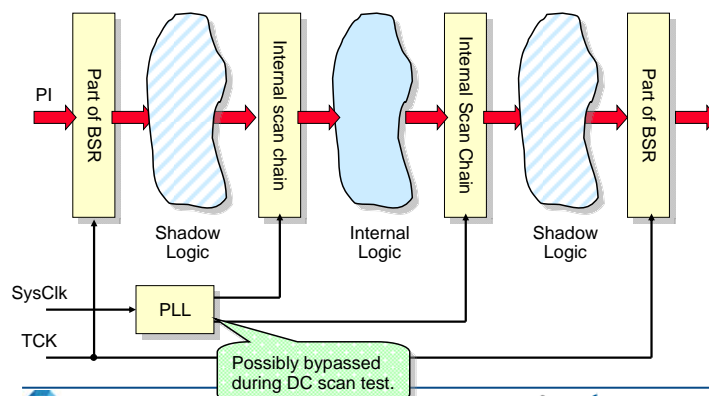
© 2006, Bennetts Associates
ASSET InterTech, Inc.

Slide 35
Last revised: March 2006



Testing the Shadow Logic

Easy, Affordable, Powerful




© 2006, Bennetts Associates
ASSET InterTech, Inc.

Slide 36
Last revised: March 2006





Easy, Affordable, Powerful

Something To Watch Out For ...



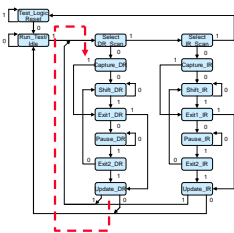
Beware TCK/SysClk synchronisation problems when linking boundary-scan register usage with internal scan chains, especially for at-speed scan protocols such as Launch-On-Shift (LOS) and Launch-On-Capture (LOC).

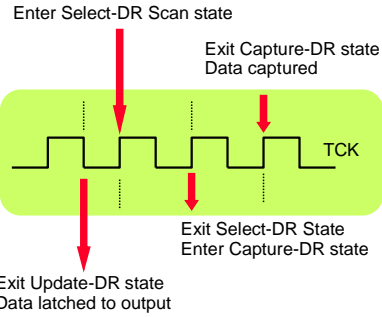

© 2006, Bennetts Associates
ASSET InterTech, Inc.
Slide 37
Last revised: March 2006


BSCAN and ISCAN work with different clocks and different protocols. These differences can cause major problems of synchronisation in an RPCT environment.



Easy, Affordable, Powerful

The 2.5 TCK Problem





□ It takes 2.5 TCK cycles between pattern update and response capture.


© 2006, Bennetts Associates
ASSET InterTech, Inc.
Slide 38
Last revised: March 2006


The time between the exit of the Update-DR state (launch of the pattern) and the enter Capture-DR state (capture of the result) is 2.5 TCKs. This limits the ability to do at-speed testing across interconnects.

At the time of writing, there is only one proprietary solution on the marketplace – LogicVision’s At-Speed Interconnect (ASI)

2.5 TCK Versus LOS/LOC protocols

Easy, Affordable, Powerful

Enter Select-DR Scan state

Exit Update-DR state Data launched

Exit Select-DR State Enter Capture-DR state

Launch Initialise Pattern

Launch Transition Pattern

Timed Capture Response

Launch-On-Shift (LOS)

Launch-On-Capture (LOC)

One solution is to design a dual-mode boundary-scan register:

- Mode 1: TCK-driven, under the control of the TAP controller, and
- Mode 2: SysClk-driven, behaving as if it were an internal scan register but note that the distribution of TCK to the boundary-scan cells may be skewed to reduce simultaneous-output switching problems (*EXTTEST* ground bounce).

© 2006, Bennetts Associates
 ASSET InterTech, Inc.

Slide 39
Last revised: March 2006

The problem is to synchronise the use of the segment of the boundary-scan (JTAG) register with the internal scan-chain protocol. One solution is to design the boundary-scan register to have dual modes: one based on the 1149.1 TAP controller protocol and under the TCK clock, and another where the register is under the control of the internal scan-chain clock (SysClk) and is fully synchronised with the internal scan chains.

Mentor Graphics' Enhanced BScan Cell

Easy, Affordable, Powerful

© 2006, Bennetts Associates
 ASSET InterTech, Inc.

Slide 40
Last revised: March 2006

Another ISCAN Solution

Easy, Affordable, Powerful

- ❑ Enhanced: New *Shift_DR* and *Capture_DR* operations controlled by extra **TMS2** signal plus TCK
- ❑ Allows shift/launch followed by capture as required by internal scan chain protocols.
- ❑ But, beware of clock synchronisation problems: TCK to ISCAN clock, timed capture clock sync.
- ❑ On the board, TMS2 is treated as a compliance enable signal.

© 2006, Bennetts Associates
ASSET InterTech, Inc.

Slide 41
Last revised: March 2006

The diagram shows the 16-state state table for the TAP controller. The value on the state transition arcs is the value of TMS. A state transition occurs on the positive edge of TCK and the controller output values change on the negative edge of TCK.

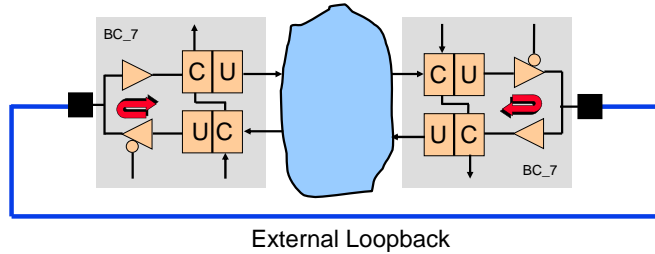
The TAP controller initializes in the **Test_Logic_Reset** state (“**Asleep**” state). While TMS remains a 1 (the default value), the state remains unchanged. In the **Test_Logic_Reset** state and the active (selected) register is determined by the contents of the Hold section of the Instruction register. The selected register is either the Identification register, if present, else the Bypass register. Pulling TMS low causes a transition to the **Run_Test/Idle** state (“**Awake, and do nothing**” state). Normally, we want to move to the **Select IR_Scan** state ready to load and execute a new instruction.

An additional **11** sequence on TMS will achieve this. From here, we can move through the various **Capture_IR**, **Shift_IR**, and **Update_IR** states as required. The last operation is the **Update_IR** operation and, at this point, the instruction loaded into the shift section of the Instruction register is transferred to the Hold section of the Instruction register to become the new current instruction. This causes the Instruction register to be de-selected as the register connected between TDI and TDO and the Data register identified by the new current instruction to be selected as the new target Data register between TDI and TDO. For example, if the instruction is **Bypass**, the Bypass register becomes the selected data register. From now on, we can manipulate the target data register with the generic **Capture_DR**, **Shift_DR**, and **Update_DR** control signals.

Use of IO Wrap

Easy, Affordable, Powerful

- ❑ A weakness of RPCT is that the IO contact itself is not tested – from pad to BS Cell/BS cell to pad.
- ❑ This can be solved by making every cell a Bidirectional cell (BC_7) or self-monitoring cell (BC_9) – called **IO Wrap** - plus using a simple external loopback fixture.



© 2006, Bennetts Associates
ASSET InterTech, Inc.

Slide 42
Last revised: March 2006



RPCT: Other Discussion Points

Easy, Affordable, Powerful

- ❑ Ideally, we would want to keep the number of internal scan chains low to minimise the number of physical touch points, but ...
- ❑ ... this is at variance with the need to maximise the number of internal scan chains to minimise scan-load/scan-unload time i.e. time-on-the-tester.
- ❑ This could result in an Illinois Scan architecture for the internal scan.



© 2006, Bennetts Associates
ASSET InterTech, Inc.

Slide 43
Last revised: March 2006



Illinois Scan: Parallel Serial Full Scan

Easy, Affordable, Powerful

The diagram illustrates the Illinois Scan architecture. On the left, an ATE (Automatic Test Equipment) block is connected to a central block labeled 'Scan'. This central block contains four parallel scan chains, each represented by a yellow bar with a dashed outline. These scan chains are connected to a MISR (Multiple Input Signature Register) block, which is also represented by a yellow bar. The MISR block is then connected to an ATE block on the right.

- ❑ The internal scan chain can be setup as a single serial scan chain or as a set of parallel scan chains.
- ❑ In parallel mode, each chain receives the same deterministic or pseudo-random test pattern. This can result in some loss of coverage.
- ❑ The serial mode is used to "top up" the coverage.

Hamzaoglu & Patel, 1999 FTC, pp. 260-267.
See also ITC2001, P19.3

© 2006, Bennetts Associates
ASSET InterTech, Inc.
Slide 44
Last revised: March 2006

ASSET
THE BROADCAST SCAN COMPANY

Features of VirtualScan

Patent-pending virtual scan technology for broadcasting external scan chains to user selectable number of shorter internal scan chains and compacting them back into original number of external scan chains.

Automatically inserts broadcaster and compactor circuitry

Outputs complete virtual scan netlist

Includes tools for scan insertion and synthesis

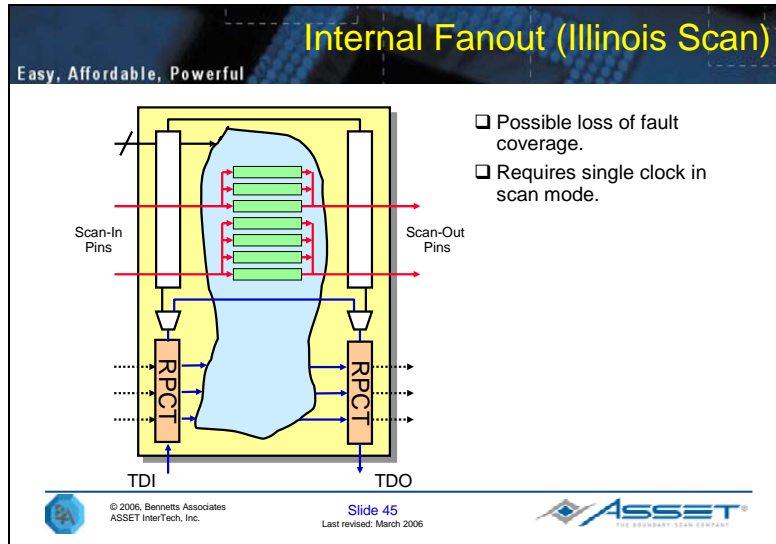
Uses an enhanced virtual scan ATPG

Static and dynamic compaction of ATPG patterns

Advanced multiple clock domain handling using proprietary multiple-capture-per-cycle scheme

Can be used with scan chains inserted using third party tools

Fully compatible with SynTest's existing DFT tools as well as TurboDebug-SOC/Scan and TurboDiagnosis-Scan for debug, diagnosis and failure analysis of scan chains.



Reduced pin count test (RPCT) is becoming popular as a way of keeping down the cost of test for devices that are “fully loaded” with internal scan, BIST and 1149.1 boundary scan or JTAG. Companies such as IBM, Motorola and now Philips are using part of the boundary-scan register to access the low data-rate functional pins of a device in lieu of engaging these pins through a dedicated driver/sensor pin channel. High data-rate pins, such as Scan-In, Scan-Out and Clock pins are contacted directly. The boundary-scan register is designed to allow segments to be addressed through the TAP using private instructions, such as INTEST-RPCT. The addressed segment is used for serial-to-parallel access on the input side, and parallel-to-serial access on the output side. The remainder of the boundary-scan register is left in transparent mode.

Fanout Via the Boundary-Scan Register

Easy, Affordable, Powerful

- ❑ Uses part of the BScan register to access internal scan chains using a serial-in/parallel-load protocol.
- ❑ This would require an *INTEST*-like instruction on the non-RPCT segment of the BScan register (which might cause problems on unused cells in the non-RPCT segment).
- ❑ Clock scheme becomes complex if synchronised with clock used to load the RPCT segment.

Philips proposal

© 2006, Bennetts Associates
ASSET InterTech, Inc. Slide 46
Last revised: March 2006 ASSET
THE BOUNDARY-SCAN COMPANY

Reduced pin count test (RPCT) is becoming popular as a way of keeping down the cost of test for devices that are “fully loaded” with internal scan, BIST and 1149.1 boundary scan or JTAG. Companies such as IBM, Motorola and now Philips are using part of the boundary-scan register to access the low data-rate functional pins of a device in lieu of engaging these pins through a dedicated driver/sensor pin channel. High data-rate pins, such as Scan-In, Scan-Out and Clock pins are contacted directly. The boundary-scan register is designed to allow segments to be addressed through the TAP using private instructions, such as INTEST-RPCT. The addressed segment is used for serial-to-parallel access on the input side, and parallel-to-serial access on the output side. The remainder of the boundary-scan register is left in transparent mode.

RPCT: Other Discussion Points

Easy, Affordable, Powerful

- ❑ RPCT addresses the “number of pins contacted” problem. It does not address the “test data volume reduction” problem.
- ❑ But, combined with test-data compression techniques, the volume of test data will also be reduced.

© 2006, Bennetts Associates
ASSET InterTech, Inc. Slide 47
Last revised: March 2006 ASSET
THE BOUNDARY-SCAN COMPANY