

Table of Contents

Introduction to DFT	1-1
Objectives:	1-1
Introduction	1-1
Functional Testing and DFT	1-1
Fault Models	1-2
Levels of Circuit Abstraction	1-3
Types of Fault Models	1-4
Stuck-at Fault Model	1-5
Stuck Open Fault Model	1-6
Bridge Fault Model	1-7
Behavioral Fault Model	1-7
Toggle Fault Model	1-7
Transition Delay Fault Model	1-7
Path Delay Fault Model	1-7
Summary - Fault Models	1-7
Automatic Test Pattern Generation	1-9
The ATPG Tool	1-9
The ATPG Vector Generation Process	1-10
ATPG Verification	1-14
ATPG Improves Test	1-14
Fault Coverage	1-15
Introduction to DFT Review	1-16
Scan	2-1
Objectives:	2-1
Manufacturing Test and DFT	2-1
Ad-Hoc and Structured DFT	2-2
Types of Structured DFT	2-3
Scan Design	2-3
Non-Scan Logic	2-4
Scan flip-flops	2-4
Scan Logic	2-5
Multiple Scan Chains	2-6
Scan Test Sequence	2-7
Scan Timing	2-8
Initial Scan Test Sequence	2-8
Scan Input / Output Timing	2-9
Scan Output Timing	2-10
Input Timing	2-11

Output Timing	2-11
Testing Scan Logic	2-12
Scan Logic Fault Detection	2-13
Scan Data Alignment Principles	2-13
Shifting Phase - What's Important	2-14
DC Scan Test Failures	2-14
AC Scan	2-15
Signal Path Timing	2-16
The Transition Delay Test	2-17
Dynamic Hazards	2-17
Path Delay Testing	2-18
Robust Delay Rules	2-19
Scan Launch and Capture Techniques	2-19
Launch On Shift (LOS)	2-20
Functional Launch	2-21
Functional Launch Example	2-22
Debugging AC Scan	2-23
AC Scan Time Measurements	2-24
Delay Test – Low Voltage Stress	2-24
DFT Clocks and Phase Lock Loops	2-25
PLL Chop Clock	2-26
Scan - Review	2-27
Boundary Scan	3-1
Objectives:	3-1
Boundary Scan IEEE 1149.1	3-1
Boundary Scan Control Pins	3-2
Boundary Scan TAP Controller	3-3
Boundary Scan Instructions	3-4
Boundary Scan Register Functions	3-5
Boundary Scan Register Logic	3-6
Boundary Scan Timing	3-7
Boundary Scan and Component Test	3-8
Boundary Scan and In-Circuit Test	3-9
The IEEE 1149.1 Specification	3-10
Boundary Scan - Review	3-11
BIST	4-1
Objectives:	4-1
BIST	4-1
BIST Architecture	4-1
Memory BIST	4-3
Logic BIST	4-4

LFSR - Pattern Generation	4-4
MISR - Output Compression	4-7
Error Reporting	4-7
Logic BIST Test Sequence	4-8
IO BIST	4-8
DFT Considerations	4-11
Bist Review	4-12
Simulation and Test Vector Development	5-1
Objectives:	5-1
Introduction	5-1
Test Vectors	5-1
Logic Simulation	5-2
Simulation Languages	5-3
Testbench Introduction	5-6
Test Vector Languages	5-7
JEDEC Test Vector Language	5-7
Tester-Specific Vector Languages	5-8
STIL - Standard Test Interchange Language	5-12
Simulation and Test Vector Review	5-20
Testbenches	6-1
Objectives:	6-1
Simple Testbenches and Getting Data From Simulation	6-1
Stimulus-Only Testbench With Visual Inspection	6-2
The \$display, \$write, \$strobe, \$monitor Facilities	6-4
Value Change Dump Files	6-6
Additional VCD Capabilities	6-14
Additional Waveform File Formats	6-14
Testbenches in an ATE Style	6-14
Value Change Dumps From ATE-Style Simulation	6-22
More Advanced Testbench Concepts	6-36
Multiple Device Interfaces	6-36
Stimulus Generators	6-40
ScoreBoards and Golden Models	6-41
Coverage Analysis	6-41
Advanced Testbench Summary	6-41

Testbenches Review 6-43

Simulation to ATE 7-1

 Objectives: 7-1

 Moving from Simulation To ATE 7-1

 Cycleization 7-2

 Translating Cycleized Data to ATE 7-3

 From ATPG To ATE. 7-5

 STIL Features That Support ATPG Vectors 7-5

 Hand-Crafting And Manipulating Vector Files 7-9

 Some Tools and Forms of Vector Manipulation 7-9

 Developing Software For Vector Manipulation 7-10

 Producing Vector Files from Data 7-10

Simulation to ATE Review 7-12

Resources and ReferencesResources-1

GlossaryGlossary-1

Answers to Review Questions Answers-1

 Introduction to DFT Review Answers-1

 Scan - Review Answers-3

 Boundary Scan - Review..... Answers-4

 Bist - Review Answers-5

 Simulation and Test Vector Review Answers-7

 Testbenches Review Answers-8

 Simulation to ATE Review Answers-9