IPC-2231

DFX Guidelines

Developed by the DFX Standards Subcommittee (1-14) of the Printed Board Design Committee (1-10) of IPC

Users of this publication are encouraged to participate in the development of future revisions.

Contact:

IPC

Table of Contents

1 SCOPE ... 1
1.1 Purpose ... 1
1.2 Goals of This Document ... 1
1.3 Limitations of This Document ... 1

2 APPLICABLE DOCUMENTS ... 1
2.1 IPC ... 1
2.2 SAE International ... 2
2.3 IEEE ... 2
2.4 JEDEC ... 2
2.5 Government ... 2

3 TERMS AND DEFINITIONS ... 3

4 OVERVIEW OF DESIGN FOR EXCELLENCE (DFX) PRACTICES ... 4
4.1 Design for Manufacturing (DFM) ... 4
4.2 Printed Board Design for Fabrication (DFF) ... 4
4.3 Design for Assembly (DFA) ... 5
4.4 Design for Test/Testability (DFT) ... 5
4.5 Design for Cost (DFC) ... 5
4.6 Design for Reliability (DFR) ... 5
4.7 Design for Environment (DFE) ... 6
4.8 Design for Reuse ... 6

5 PRINTED BOARD ASSEMBLY DESIGN PROCESS ... 6
5.1 Overview ... 6
5.2 Concept Design and Analysis ... 6
5.2.1 Overview ... 6
5.2.2 Inputs ... 7
5.2.3 Tasks ... 7
5.2.4 Outputs ... 7
5.3 Detailed Design ... 7
5.3.1 Overview ... 7
5.3.2 Inputs ... 7
5.3.3 Tasks ... 8
5.3.4 Outputs ... 8
5.4 Design Release ... 8
5.4.1 Overview ... 8
5.4.2 Inputs ... 8
5.4.3 Tasks ... 8
5.4.4 Outputs ... 9
5.5 First Build Support ... 9
5.5.1 Overview ... 9
5.5.2 Inputs ... 9
5.5.3 Tasks ... 9
5.5.4 Outputs ... 9
5.6 Product Validation ... 9
5.6.1 Overview ... 9
5.6.2 Inputs ... 9
5.6.3 Tasks ... 9
5.6.4 Outputs ... 9
5.7 Support ... 10
5.7.1 Overview ... 10

6 BOARD ASSEMBLY PROCESSES ... 10
6.1 Scope ... 10
6.2 Solder Mask ... 10
6.3 Components ... 10
6.4 Panel/Array ... 10
6.5 Clearance ... 10
6.6 Component Placement/Mounting ... 11
6.7 Thermal Pad Outgassing ... 11
6.8 Fiducials ... 12
6.9 Tooling ... 12
6.10 Pb-Free Solder Assembly Temperatures ... 12
6.10.1 Copper Flooding and Thermal Relief ... 12
6.10.2 Heat Sensitive Components ... 12
6.10.3 Assembly Effects on Printed Board Assembly Materials ... 13
6.10.4 Moisture Sensitivity ... 13
6.11 Surface Mount Paste Printing ... 13
6.12 Machine Soldering ... 13
6.12.1 Single Point Automated Soldering Systems ... 13
6.12.2 Reflow Soldering ... 13
6.12.3 Convection Reflow ... 13
6.12.4 Vapor Phase Reflow ... 13
6.12.5 Pin in Paste/Paste in Hole/Intrusive Soldering ... 14
6.12.6 Wave Soldering ... 14
6.12.7 Selective Soldering/Point-to-Point Soldering ... 14
6.12.8 Point-to-Point Soldering ... 14
6.12.9 Selective Dip Soldering ... 14
6.13 Laser Soldering ... 14
6.14 Manual/Rework Soldering ... 14
6.14.1 Soldering Iron ... 14
6.14.2 Vacuum Tipped Soldering Iron ... 14
6.14.3 Hand Hot Air/Gas Soldering ... 15
6.14.4 BGA/Area Array Rework ... 15

6.14.5 Mini-Pot (Solder Fountain) Wave Rework 15
6.15 Cleaning 15
6.16 Underfill 15
6.17 Conformal Coating 16
6.18 Design Guidelines for System Enclosures/ Box Builds 16

7 DESIGN FOR TESTABILITY (DFT) 17
7.1 Conceptual Design 17
7.2 Preliminary Design – Block Diagram 17
7.3 Detailed Circuit Design 18
7.4 DFT Considerations 18
7.4.1 Design for Testability Metrics 19
7.5 Support 19
7.6 Prognostics and Health Management 20
7.7 References 20
7.7.1 IEEE Standards for DFT 20
7.7.2 Industry Standards and Guidelines 20
7.7.3 Military Standards and Guidelines 20
7.7.4 Commercially Available DFT Guidelines 20

8 DESIGN FOR COST 20
8.1 Bill of Material (BOM) Costs 20
8.2 Printed Board and Assembly Costs 21
8.3 Sustaining Costs 21
8.4 Test Costs 21
8.5 Rework and Repair Costs 21

9 DESIGN FOR RELIABILITY 22
9.1 Physics of Failure / Reliability Physics 22
9.2 Solder Joint Reliability 23
9.3 Tin Whisker Risk Considerations 23
9.4 CTE of Common Materials (CTE) 23
9.5 Comparative Reliability Matrix 23

10 DESIGN FOR THE ENVIRONMENT 26
10.1 Sustainability 26
10.2 Materials 26
10.3 Regulatory 26
10.3.1 End-of-Life 26
10.3.2 Life Cycle Assessments 26

11 DESIGN FOR REUSE 27
11.1 Designing for Reuse within an Organization 27
11.2 Designing for Reuse by Third Parties 27

12 CHECK LISTS COMPARISONS 28

13 ACRONYMS 43

Figures

Figure P-6 Plated-Through-Hole (PTH) 3
Figure 9-1 Well Wetted Through-Hole Solder Joint 25
Figure 9-2 Well Wetted Surface Mount Discrete Solder Joint 25
Figure 9-3 Well Wetted Surface Mount J-Lead Joints 25
Figure 9-4 Well Wetted Surface Mount BGA Solder Joints 25

Tables

Table 7-1 Design and Testability Activities Integrated During Various Phases of Product Development 17
Table 9-1 Cyclic Services Environment over Design Life 24

DFX Guidelines

1 SCOPE

This document provides guidelines for establishing a best practice methodology for use in developing a formal DFX (Design for Manufacturing, Fabrication, Assembly, Testability, Cost, Reliability, Environment, Reuse) process for layout of printed board assemblies that utilize surface mount and through hole devices.

1.1 Purpose The document provides a DFX process framework to establish a discipline of design review necessary to perform a detailed analysis of manufacturability attributes commonly found in electronics hardware for fabrication and around which to model a printed board assembly.

1.2 Goals of This Document The goals of this document are to:

- Use a multi-discipline engineering assessment tactic on elements influencing DFX.
- Allow the user to establish standardized DFX checklist(s) for major design elements such as bare printed board fabrication, printed board assembly manufacturing, electrical testability, and elements influencing product reliability, reuse, and impact on environment.

1.3 Limitations of This Document Electronics hardware defined under this DFX review process is limited to features of influence on DFX for bare printed board and printed board assembly.

2 APPLICABLE DOCUMENTS

2.1 IPC[1]

J-STD-001 Requirements for Soldered Electrical and Electronic Assemblies

IPC-T-50 Terms and Definitions for Interconnecting and Packaging Electronic Circuits

IPC-CH-65 Guidelines for Cleaning of Printed Boards and Assemblies

IPC-D-279 Design Guidelines for Reliable Surface Mount Technology Printed Board Assemblies

IPC-D-325 Documentation Requirements for Printed Boards, Assemblies and Support Drawings

IPC-A-610 Acceptability of Electronic Assemblies

IPC-A-630 Acceptability Standard for Manufacture, Inspection, and Testing of Electronic Enclosures

IPC-SM-785 Guidelines for Accelerated Reliability Test of Surface Mount Solder Attachments

IPC-CC-830 Qualification and Performance of Electrical Insulating Compound for Printed Wiring Assemblies

IPC-2221 Generic Standard on Printed Board Design

IPC-2222 Sectional Design Standard for Rigid Organic Printed Boards

IPC-2223 Sectional Design Standard for Flexible Printed Boards

IPC-2224 Sectional Standard for Design of PWBs for PC Cards

IPC-2225 Sectional Design Standard for Organic Multichip Modules (MCM-L) and MCM-L Assemblies

IPC-2226 Sectional Design Standard for High Density Interconnect (HDI) Printed Boards

IPC-2581 Generic Requirements for Printed Board Assembly Products Manufacturing Description Data and Transfer Methodology

IPC-2615 Printed Board Dimensions and Tolerances

IPC-4761 Design Guide for Protection of Printed Board Via Structures

1. www.ipc.org