

12-V to 100-V Input, 0.2-A Output Switching Converter

Check for Samples: [UCC25230](#)

FEATURES

- Highly Integrated Converter Operating as a Buck, or Isolated Forward-Flyback, Flybuck™
- Wide Operating Input Voltage Range from 12 V to 100 V, 105-V Surge.
- Up to 0.2-A Output Current
- 9-V Always Available VDD Output with up to 2-mA Current Capability
- Thermally Enhanced 4-mm x 4-mm SON-8/S-PVSON-N8 (DRM) Package
- Internally Set Fixed 380-kHz Switching Frequency
- Internal 2-ms Duration Soft Start
- Voltage Mode Control with Input Feed Forward Allows Optimal Output Filter Design
- 2% Accuracy Internal 2.5-V Reference
- V_{DD} UVLO
- Cycle-by-Cycle Current Limit with Frequency Fold Back for Initial Start up Under High Capacitive Loads
- Input UVLO and OVLO with Input Good Signal
- Integrated 110-V, High and Low-Side Switches

APPLICATIONS

- High Density Isolated Standby Bias Supplies
- DC-to-DC Converters

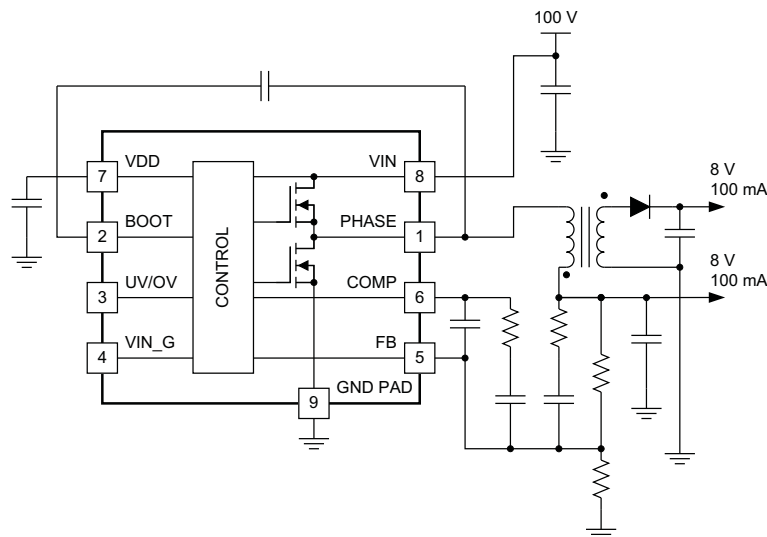
DESCRIPTION

The UCC25230 is a highly integrated PWM converter operating as an isolated forward flyback. It has high-side and low-side power switches integrated and the control circuit with all key converter functions included. The power stage requires only one- or multiple winding coupled inductor and output capacitors for the complete solution. Voltage-mode feed-forward control with external compensation allows optimal output filter selection over wide input voltage range. The UCC25230 has fixed frequency set internally at 380 kHz. It also includes input voltage UVLO and OVLO comparators with hysteresis and input-good, open-collector output signal which can be used to enable PWM controllers.

UCC25230 is available in a thermally enhanced 8-pin SON package with PowerPad™ serving as a ground pin.

Other features include internal soft start and cycle-by-cycle current protection. Measured efficiency of isolated converter over input voltage and output current ranges are shown in [Figure 2](#).

Isolated Buck Converter



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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.

ORDERING INFORMATION

TEMPERATURE RANGE, $T_A = T_J$	PACKAGE	TAPE AND REEL QTY.	PART NUMBER
-40°C to +125°C	SON-8/S-PVSON-N8 (DRM)	250	UCC25230DRMT
		3000	UCC25230DRMR

ABSOLUTE MAXIMUM RATINGS⁽¹⁾⁽²⁾

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

		MIN	MAX	UNIT
Supply voltage range, V_{IN}	DC	-0.3	100	V
	Repetitive surge < 200 ms		105	
Output voltage on PHASE	DC	-0.3	$V_{IN} + 0.5$	
	Repetitive pulse < 100 ns	-2	$V_{IN} + 1$	
Voltage	BOOT with respect to PHASE	-0.3	10	
Voltage	VDD	-0.3	10	
Voltage	FB, UV/OV, COMP	-0.3	VDD	
Voltage	V_{IN_G}	-0.3	5.5	
ESD rating	HBM		2	kV
	CDM		500	V
Sink current	PHASE (peak)		220 (internally limited)	mA
Source current	PHASE (peak)		-220 (internally limited)	
Operating virtual junction temperature range, T_J		-40	150	°C
Operating ambient temperature range, T_A		-40	125	
Storage temperature, T_{STG}		-65	150	
Lead temperature (soldering, 10 sec.)			300	

- (1) Stresses beyond those listed under "absolute maximum ratings" may cause permanent damage to the device. These are stress ratings only, and functional operation of the device at these or any other conditions beyond those indicated under "recommended operating conditions" is not implied. Exposure to absolute-maximum-rated conditions for extended periods may affect device reliability.
- (2) All voltages are with respect to GND. Currents are positive into, negative out of the specified terminal. Consult Packaging Section of the Databook for thermal limitations and considerations of packages.

THERMAL INFORMATION

THERMAL METRIC ⁽¹⁾		UCC25230	UNITS
		DRM	
		8 PINS	
θ_{JA}	Junction-to-ambient thermal resistance ⁽²⁾	33.9	°C/W
θ_{JCTop}	Junction-to-case (top) thermal resistance ⁽³⁾	33.2	
θ_{JB}	Junction-to-board thermal resistance ⁽⁴⁾	11.4	
ψ_{JT}	Junction-to-top characterization parameter ⁽⁵⁾	0.4	
ψ_{JB}	Junction-to-board characterization parameter ⁽⁶⁾	11.7	
θ_{JBot}	Junction-to-case (bottom) thermal resistance ⁽⁷⁾	2.3	

(1) For more information about traditional and new thermal metrics, see the *IC Package Thermal Metrics* application report, [SPRA953](#).

(2) 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 JEDEC-standard 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, ψ_{JT} , estimates the junction temperature of a device in a real system and is extracted from the simulation data for obtaining θ_{JA} , using a procedure described in JESD51-2a (sections 6 and 7).

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

(7) The junction-to-case (bottom) thermal resistance is obtained by simulating a cold plate test on the exposed (power) pad. No specific JEDEC standard test exists, but a close description can be found in the ANSI SEMI standard G30-88.

RECOMMENDED OPERATING CONDITIONS

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

PARAMETER	MIN	TYP	MAX	UNIT
Supply voltage range, V_{IN}	12	48	75, (100 V for 1 ms)	V
Supply bypass capacitor, C_{VIN}		1.0		μ F
Supply bypass capacitor, C_{VDD}	0.1	1.0	2.2	
Operating junction temperature range	-40		+125	°C

ELECTRICAL CHARACTERISTICS

$V_{IN} = 48\text{ V}$, 1- μF capacitor from V_{IN} to GND, 1- μF capacitor from V_{DD} to GND, $T_A = T_J = -40^\circ\text{C}$ to 125°C , (unless otherwise noted)

PARAMETER		TEST CONDITION	MIN	TYP	MAX	UNITS
Supply Currents						
I _{VIN}	Quiescent current	V _{IN} = 5 V		0.5	2	mA
I _{VINO}	V _{IN} operating current	FB = COMP		4.5	10	
VDD Regulator						
V _{DD}	VDD, output voltage		8.46	9	9.54	V
	Line regulation	17 V < V _{IN} < 75 V		±5	±40	mV
	Load regulation	-2 mA < I _{VDD} < 0 mA		±5	±40	
	VDD current limit (when V _{DD} = 5.5 V)		-2	-6	-13	mA
Internal Undervoltage Lockout (V _{DD_UVLO})						
VDD _{rising}	VDD rising threshold		7.0	7.5	8	V
VDD _{hyst}	VDD threshold hysteresis		0.4	0.7	1.1	
VDD _{falling}	VDD falling threshold		6.3	6.8	7.3	
Undervoltage (external programmable)						
	Falling threshold		0.9	1.0	1.1	V
	I _{hyst}		7	11	18	μA
Overvoltage (external programmable)						
	OVLO Rising threshold		4.5	5	5.5	V
	I _{hyst}		-15	-22	-40	μA
VIN Power GOOD						
	PG output sink resistance	I _{PG} = 5 mA to 10 mA		50	100	Ω
Oscillator						
f	Oscillator frequency fixed		324	380	445	kHz
DC _{MIN}	Minimum duty cycle	FB = 3.0 V			0%	
DC _{MAX}	Maximum duty cycle	FB = 2.0 V	85%			
	Frequency variation	12 V < V _{IN} < 75 V	-15%		15%	

ELECTRICAL CHARACTERISTICS (continued)

$V_{IN} = 48\text{ V}$, 1- μF capacitor from VIN to GND, 1- μF capacitor from VDD to GND, $T_A = T_J = -40^\circ\text{C}$ to 125°C , (unless otherwise noted)

PARAMETER		TEST CONDITION	MIN	TYP	MAX	UNITS
Error Amplifier						
	REF voltage	FB = COMP, (T = 25°C)	2.42	2.50	2.58	V
		FB = COMP, (T = -40 to 125°C)	2.40	2.50	2.60	
Avol	Avol open loop voltage gain		40	80		dB
	Input leakage current, FB				±2	μA
I _{COM(sink)}	COMP sink current	V _{COMP} = 4.5 V	2	4.8	10	mA
I _{COM(source)}	COMP source current	V _{COMP} = 4.5 V	-2	-6.1	-12	
V _{OL}	COMP voltage range	I _{COMP} = 100 μA		.4	1.2	V
V _{OH}	COMP voltage range	I _{COMP} = -100 μA	VDD-1.2	VDD-0.7	VDD	
Soft Start						
	Time for COMP to ramp	FB = COMP	1.75	2.05	2.35	ms
Output						
	R _{DS(on)} high	V _{IN} = 48 V		6	15	Ω
	R _{DS(on)} low	V _{IN} = 48 V		5	10	
	Max average current			200		mA
ILIMIT ⁽¹⁾						
	ILIMIT phase high	V _{IN} = 30 V	-600	-400	-220	mA
	Propagation delay, blanking delay plus ILIMIT delay		60	100	140	ns
	ILIMIT phase low	V _{IN} = 30 V	220	400	600	mA
	Propagation delay, blanking delay plus ILIMIT delay ⁽²⁾		60	100	140	ns

(1) Continued operation while in ILIM could exceed the maximum power dissipation for the device. For Non-Isolated applications additional external over current protection may be required.

(2) Specified by design, not production tested.

DEVICE INFORMATION

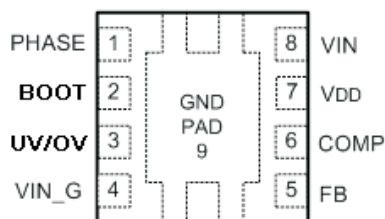


Figure 1.

TERMINAL FUNCTIONS

TERMINAL		I/O	DESCRIPTION
NAME	NO.		
PHASE	1	O	Phase output of high-side and low-side power FETs.
BOOT	2	I	0.1-μF capacitor connected between BOOT and PHASE pins along with the internal diode between BOOT and VDD provides supply voltage to the drive circuit of the upper power FET.
UV/OV	3	I	Input to internal comparators. Internal linear regulator remains functional. A bypass cap of at least 1000 pF is recommended.
VIN_G	4	O	VIN power good. Open drain output, state determined by UV/OV pin.
FB	5	I	Error amplifier inverting input. Connect to output voltage divider with compensation circuit to this pin.
COMP ⁽¹⁾	6	O	Output of error amplifier.
VDD	7	O	Output of internal linear regulator. Bypass VDD pin to GND pins close to device package with a high quality, low ESR 1-μF ceramic capacitor.
VIN	8	I	Input supply for the power MOSFET switches and internal bias regulator. Bypass VIN pins to GND pins close to device package with a high quality, low ESR 1-μF ceramic capacitor.
GND PAD	9	-	Thermal ground pad and electrical ground for the device.

(1) Input feed forward control with RAMP magnitude $V_{IN} \times 6\%$.

Detailed Pin Description

PHASE (pin 1): Output of the internal high and low sides of the internal synchronous FETS. This output drives the external power inductor, or primary side of a coupled inductor for multiple outputs.

BOOT (pin 2): Connect a 0.1-μF capacitor between the BOOT pin and the PHASE pin. This provides the necessary level shift voltage to drive the internal upper FET gate.

UV/OV (pin 3): Input to the internal window comparator with a 1-V and 5-V reference. The input to the UV/OV pin determines the state of the open drain output of VIN_G. This does not determine the operating range of the UCC25230. A bypass cap at least 1000 pF is recommended for noise immunity.

VIN_G (pin 4): Open drain output of The UCC25230's internal comparator. The output state is determined by the voltage on the UV/OV pin. The UCC25230 will continue to function regardless of the state of this pin. Used for controlling external circuitry. Maximum voltage to this pin is 5.5 V.

FB (pin 5): FB is the inverting input of the UCC25230's internal error amplifier. Connect the output voltage sensing divider to this pin. Internal reference is 2.5 V on the non inverting input.

$$R2 = \left(\left(\frac{V_{OUT}}{2.5} \right) - 1 \right) \times R1 \quad (1)$$

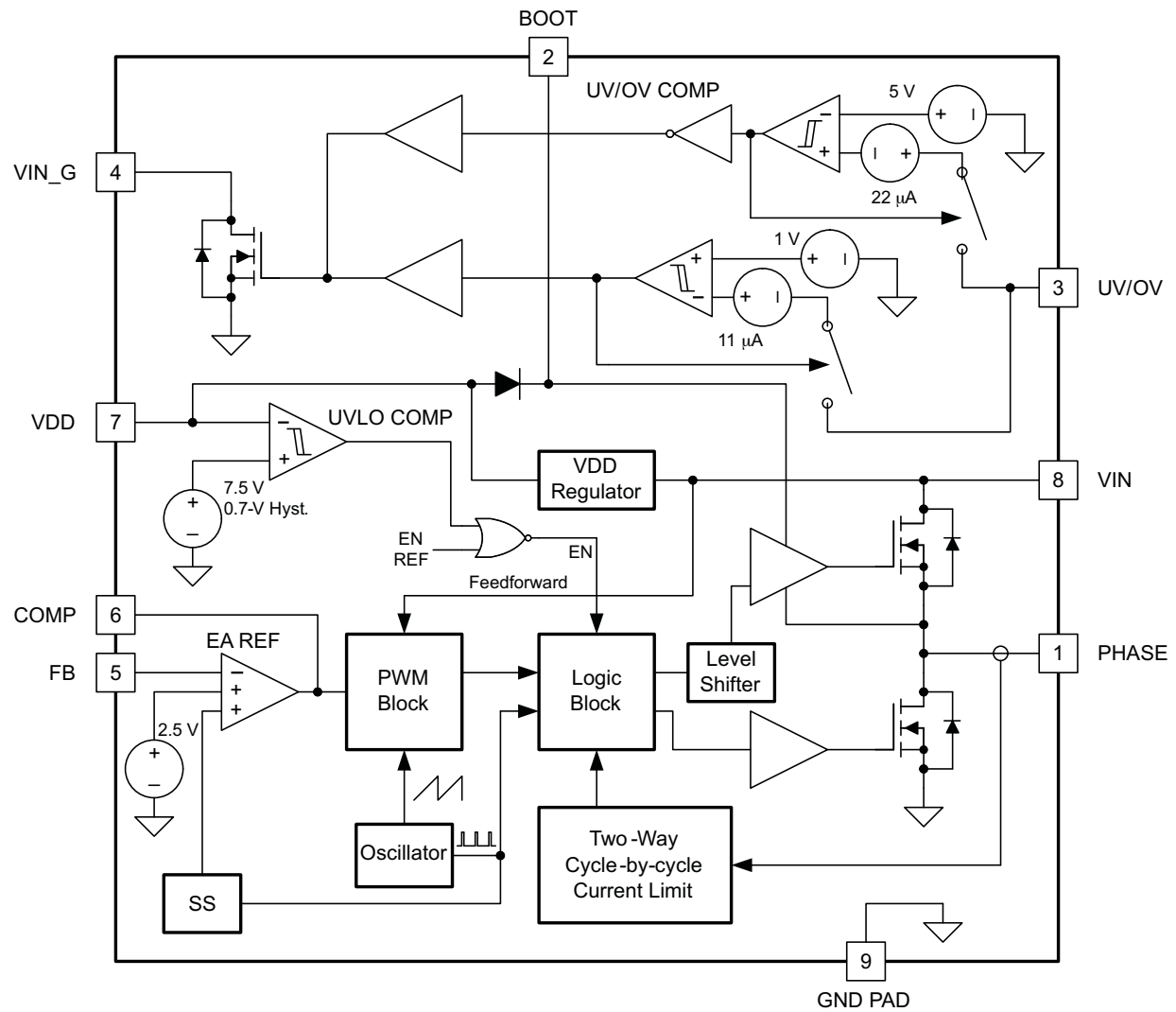
COMP (pin 6): The COMP pin is the internal error amplifier's output. The voltage range of COMP is 0 V to 8.3 V. At steady state, a higher COMP pin voltage results in a larger duty cycle. Add compensation components between this pin and FB. The device has input feed forward control which makes PWM RAMP magnitude $V_{IN} \times 6\%$.

VDD (pin 7): This is the 9-V output of the UCC25230's internal voltage regulator. This output may be used for powering additional circuitry, up to a current of 2 mA, depending on the voltage on the VIN pin. Care must be taken not to exceed the devices total power dissipation.

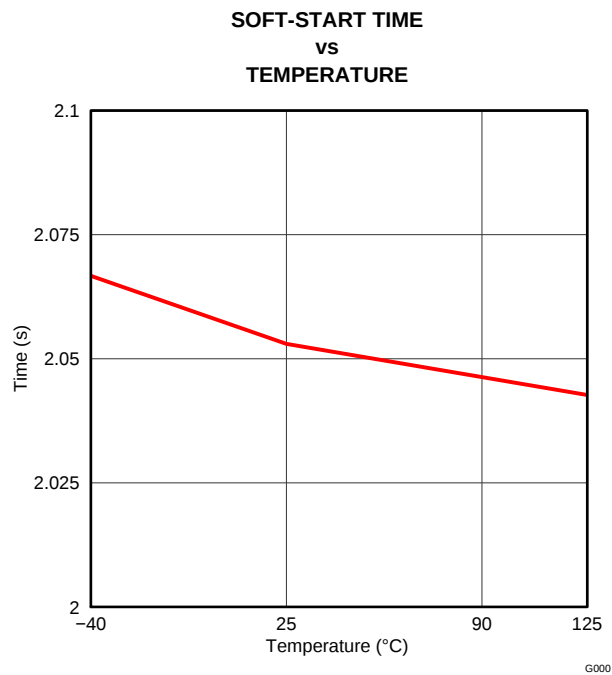
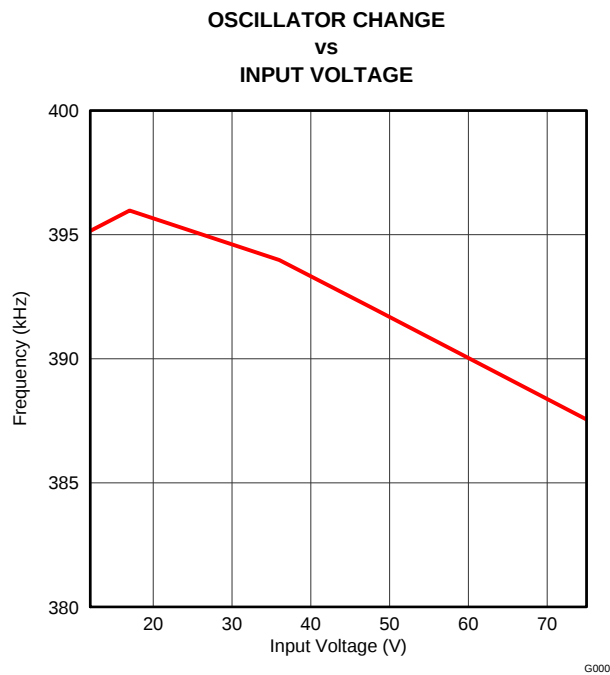
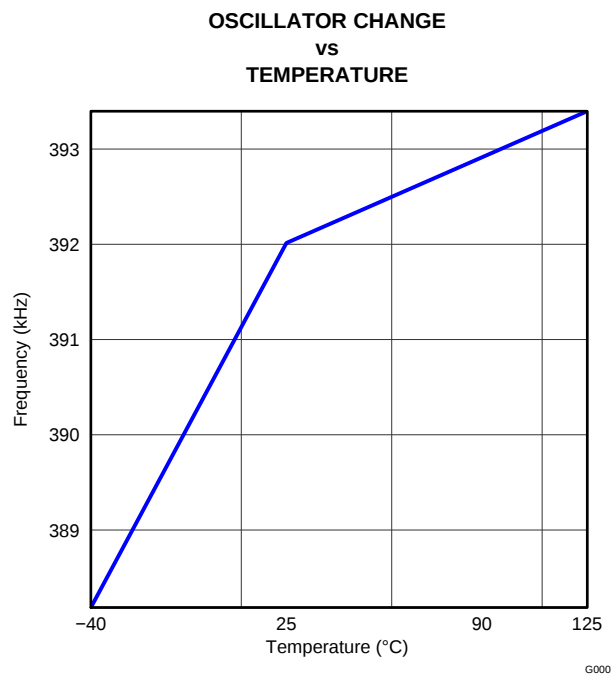
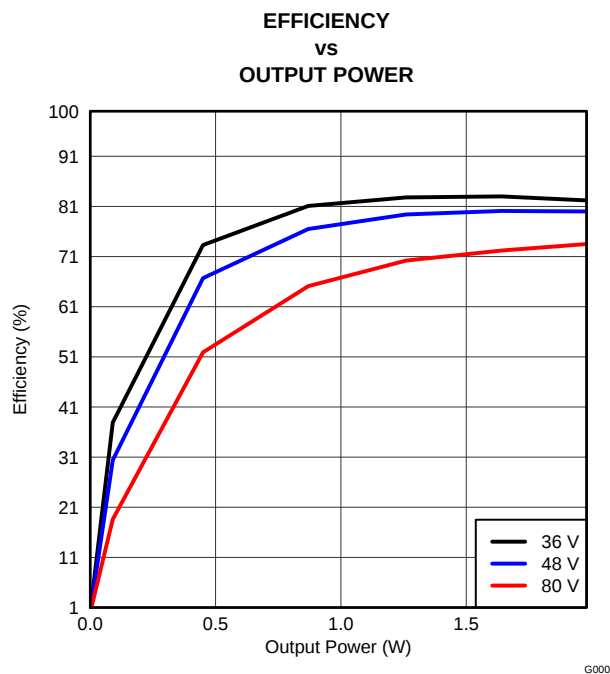
VIN (pin 8): This is the voltage input pin for the UCC25230. It supplies the internal voltage regulator and output switches. Bypass this pin with at least 1-μF low ESR capacitor.

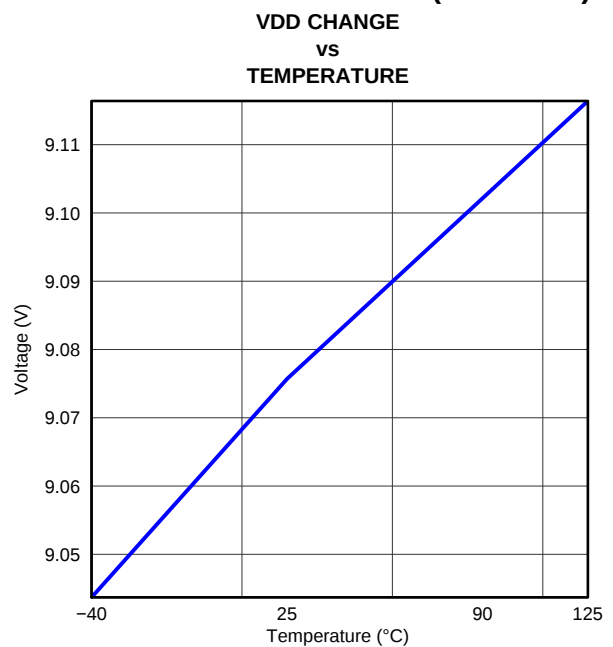
GND PAD (pin 9): GND PAD is the ground reference for the whole device. Tie all signal returns to this point.

Functional Block Diagram



TYPICAL CHARACTERISTICS



TYPICAL CHARACTERISTICS (continued)**Figure 6.**

APPLICATION INFORMATION

Detailed Description

The UCC25230 PWM converter integrates all necessary functions to operate as an isolated auxiliary bias supply. It is capable of operating from an input voltage range of 12 V to 100 V (up to 105-V surge), making it ideal for usage in 24-V or 48-V input telecom applications. High-side and low-side power switches are integrated and provide up to 200 mA of peak output current. The UCC25230 is an ideal, complementary solution to primary-side or secondary-side PWM control methodologies as it provides bias voltages necessary for PWM controllers and/or external peripheral circuitry. UCC25230 is capable of delivering a primary-side and/or secondary-side bias voltage for power supplies. As such, UCC25230 is optimized for Texas Instruments' family of UCD3k digital and analog PWM controllers as well as the C2000 family of microcontrollers.

UCC25230 operates using Texas Instruments' Flybuck™ Topology, which simplifies design versus a traditional flyback topology. Flybuck™ Topology allows a synchronous buck-like design methodology. It also enables a significant reduction in external parts count, and also allows usage of a small 2-winding transformer. The Flybuck™ Topology does not require a third transformer winding or opto-isolator for regulation. Circuits employing extra transformer windings compromise dynamic response, and add to the transformer's physical size and cost. The Flybuck™ is a portmanteau of flyback and buck since the transformer is connected as a flyback converter and the input to output voltage relationship is similar to a buck derived converter.

Typically, an auxiliary bias supply must be designed such that it is the first device in the system to power up, and be the very last device, in the system, to power down. It must be a robust supply, being able to ride through any fault conditions (OV, UV, OTP, etc) and it also must not prematurely shut down the entire power supply. The UCC25230 was designed with these goals in mind:

- A 2-ms soft start ensures a smooth, monotonic startup on both primary and secondary-side voltages.
- Voltage mode with input voltage feedforward allows optimal output filter design.
- Cycle-by-cycle current limit with frequency foldback permits startup under high-capacitive loading.
- Programmable UV/OV detection circuit.
- A VIN_G fault output provides a fast propagation open drain signal to indicate when an overvoltage or undervoltage condition has been detected. The UCC25230 is specifically designed to remain operational when a fault is detected in order to allow for fast external shutdown.

Operation of the Flybuck™ Converter

Figure 7 shows a simplified schematic and the two primary operational states of the Flybuck converter. The power supply is a variation of a Flyback converter and consists of a half bridge power stage S_{HS} and S_{LS} , transformer, primary side capacitor, diode and output capacitor. The output voltage is regulated indirectly by using the primary side capacitor voltage, V_{PRI} , as feedback. The Flybuck is a portmanteau of flyback and buck since the transformer is connected as a flyback converter and the input to output voltage relationship is similar to a buck derived converter, assuming the converter is operating in steady state and the transformer has negligible leakage inductance.

The C_{PRI} and L_{PRI} are charged by the input voltage source V_{IN} during the time the high side switch S_{HS} is on. During this time, diode D1 is reversed biased and the load current is supplied by output capacitor C_O .

During the off time of S_{HS} , S_{LS} conducts and the voltage on C_{PRI} continues to increase during a portion of the S_{LS} conduction time. The voltage increase is due to the energy transfer from L_{PRI} to C_{PRI} . For the remaining portion of the S_{LS} conduction time, the C_{PRI} voltage decreases because of current in L_{PRI} reverses; see the $i_{L_{PRI}}$ and V_{PRI} waveforms in Figure 8. By neglecting the diode voltage drop, conduction dead time and leakage inductance, the input to output voltage conversion ratio can be derived as shown in Equation 2 from the flux balance in L_{PRI} . It can be seen in Equation 2 that the input to output relationship is the same as a buck-derived converter with transformer isolation. The dc voltage V_{PRI} on the primary side capacitor in Equation 3 has the same linear relationship to the input voltage as a buck converter.

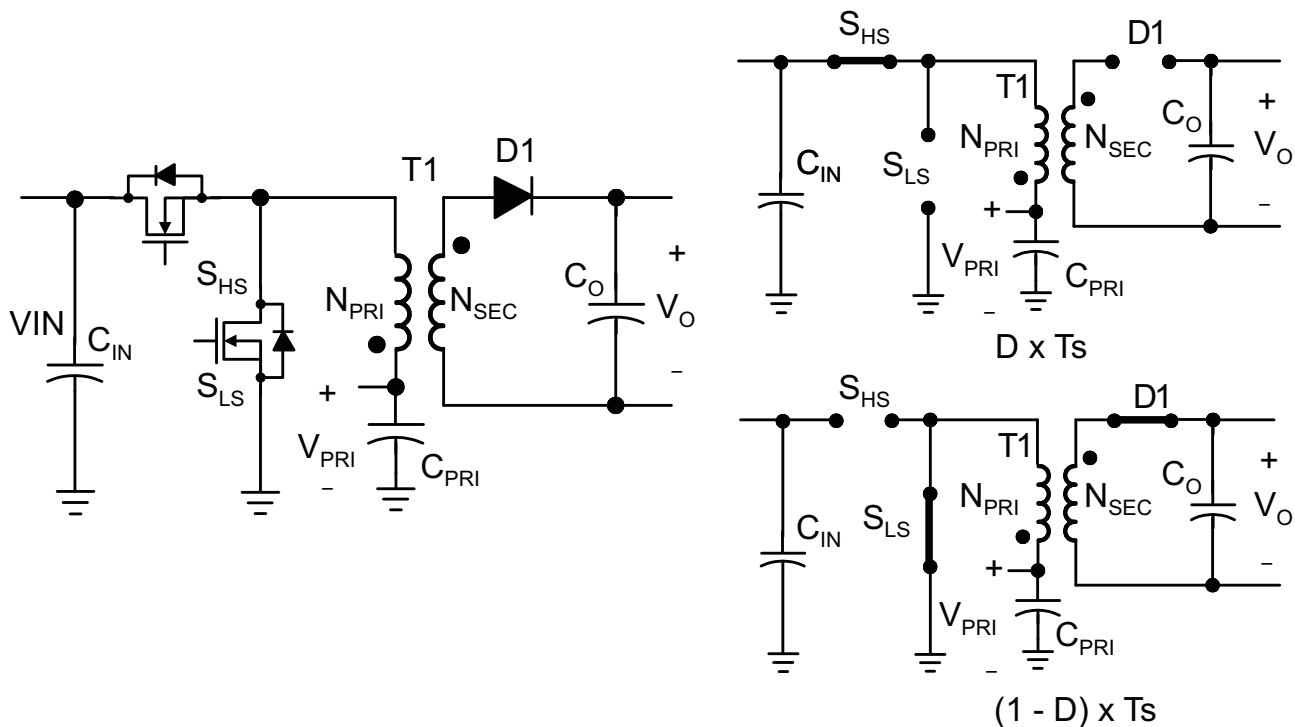


Figure 7. Simplified Schematic with Two Primary Operational States

The small signal model for the Flyback is derived by changing the transformer to the inductor equivalent and reflecting the output filter to the primary side for the circuit shown in Figure 7. Assuming negligible leakage inductance and equivalent series resistance for the capacitors, the V_{PRI} transfer function is similar to the voltage mode control buck power stage transfer function with the exception that the C_O and load are in parallel with the C_{PRI} only for the $1-D$ time. The device has input feed forward control which makes PWM RAMP magnitude $V_{IN} \times 6\%$.

$$\frac{V_O}{V_{IN}} = \frac{N_{SEC}}{N_{PRI}} \times D \quad (2)$$

$$\frac{V_{PRI}}{V_{IN}} = D \quad (3)$$

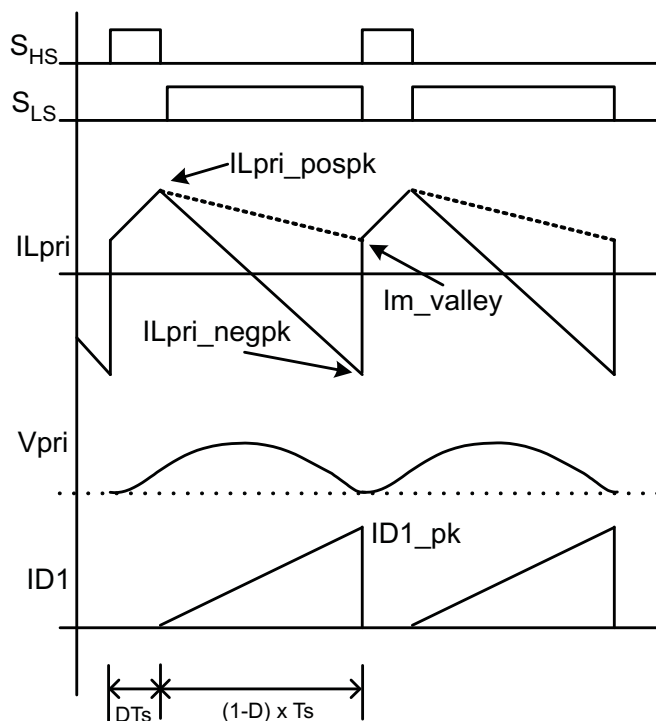


Figure 8. Simplified Voltage and Current Waveforms

Typical Application Diagram

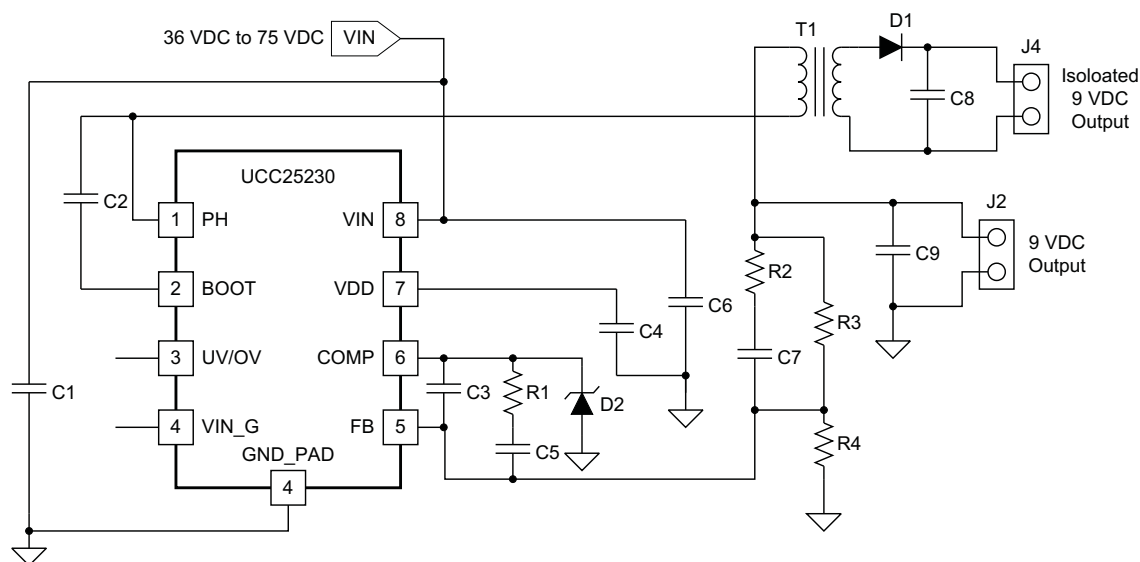


Figure 9. Typical Application Diagram

REVISION HISTORY

Changes from Revision A (November, 2011) to Revision B	Page
Added Integrated 110-V High and Low-Side Switches feature bullet	1
Added note, Input feed forward control with RAMP magnitude $V_{IN} \times 6\%$	6
Added COMP pin description, The device has input feed forward control which makes PWM RAMP magnitude $V_{IN} \times 6\%$	7
Deleted Averaging the secondary side components, an approximate transfer function is shown in and pole location in . R_O is the secondary side load resistance and the R_{LM} is the dc resistance of the primary. R_i is the inverse of the Comp to PH gm.	13
Added The device has input feed forward control which makes PWM RAMP magnitude $V_{IN} \times 6\%$	13

PACKAGING INFORMATION

Orderable Device	Status (1)	Package Type	Package Drawing	Pins	Package Qty	Eco Plan (2)	Lead/Ball Finish (6)	MSL Peak Temp (3)	Op Temp (°C)	Device Marking (4/5)	Samples
UCC25230DRMR	ACTIVE	VSON	DRM	8	3000	Green (RoHS & no Sb/Br)	NIPDAUAG	Level-1-260C-UNLIM	-40 to 125	25230	Samples
UCC25230DRMT	ACTIVE	VSON	DRM	8	250	Green (RoHS & no Sb/Br)	NIPDAUAG	Level-1-260C-UNLIM	-40 to 125	25230	Samples

(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.

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

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TAPE AND REEL INFORMATION


*All dimensions are nominal

Device	Package Type	Package Drawing	Pins	SPQ	Reel Diameter (mm)	Reel Width W1 (mm)	A0 (mm)	B0 (mm)	K0 (mm)	P1 (mm)	W (mm)	Pin1 Quadrant
UCC25230DRMR	VSON	DRM	8	3000	330.0	12.4	4.25	4.25	1.15	8.0	12.0	Q2
UCC25230DRMT	VSON	DRM	8	250	180.0	12.4	4.25	4.25	1.15	8.0	12.0	Q2

TAPE AND REEL BOX DIMENSIONS

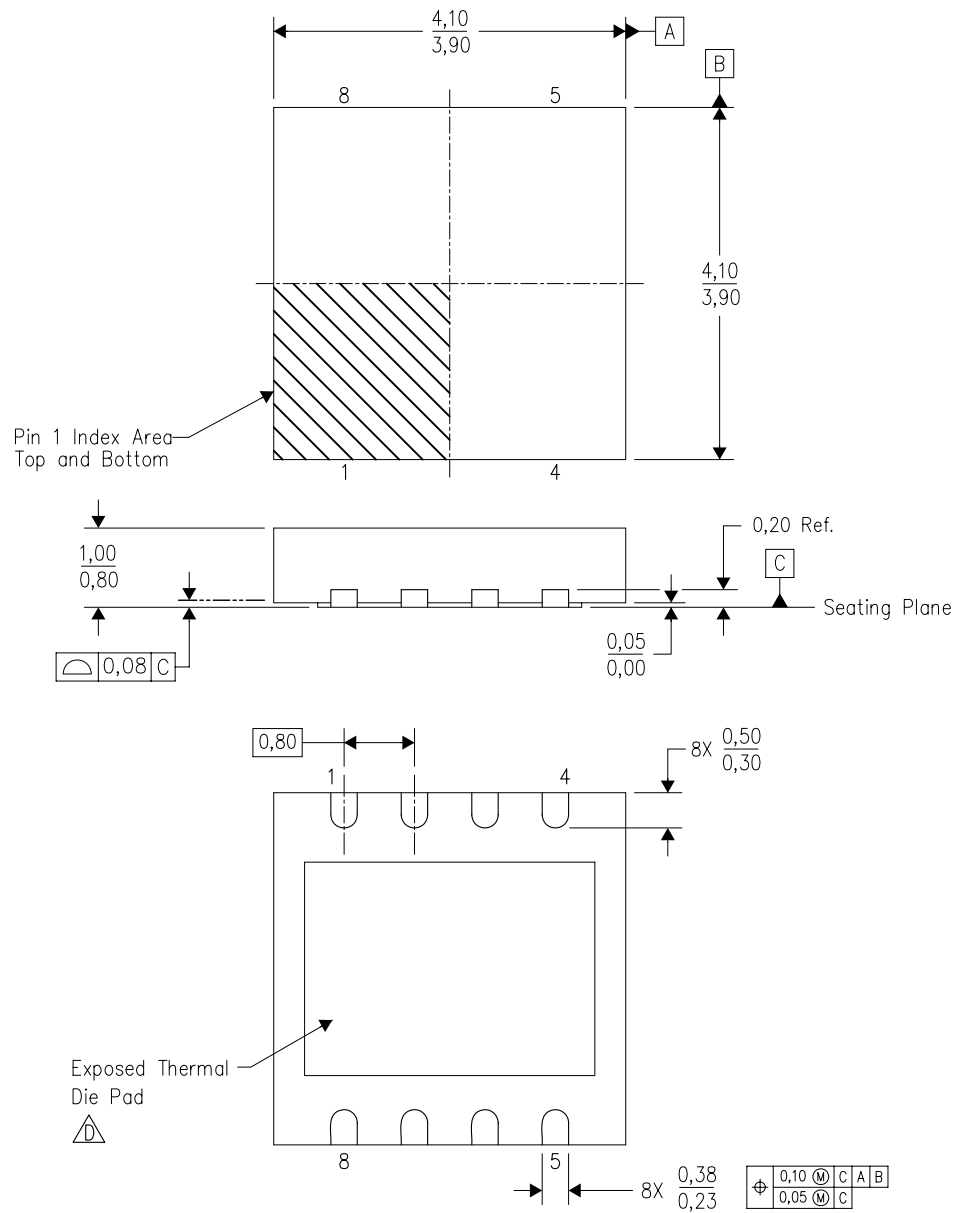


*All dimensions are nominal

Device	Package Type	Package Drawing	Pins	SPQ	Length (mm)	Width (mm)	Height (mm)
UCC25230DRMR	VSON	DRM	8	3000	367.0	367.0	35.0
UCC25230DRMT	VSON	DRM	8	250	210.0	185.0	35.0

DRM (S-PVSON-N8)

PLASTIC SMALL OUTLINE NO-LEAD



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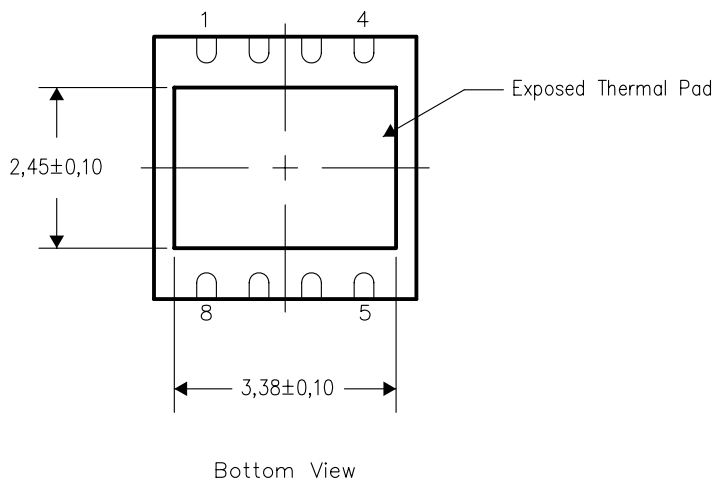
- NOTES:
- A. All linear dimensions are in millimeters. Dimensioning and tolerancing per ASME Y14.5M-1994.
 - B. This drawing is subject to change without notice.
 - C. SON (Small Outline No-Lead) package configuration.
 - The package thermal pad must be soldered to the board for thermal and mechanical performance. See the Product Data Sheet for details regarding the exposed thermal pad dimensions.

THERMAL INFORMATION

This package incorporates an exposed thermal pad that is designed to be attached directly to an external heatsink. The thermal pad must be soldered directly to the printed circuit board (PCB). After soldering, the PCB can be used as a heatsink. In addition, through the use of thermal vias, the thermal pad can be attached directly to the appropriate copper plane shown in the electrical schematic for the device, or alternatively, can be attached to a special heatsink structure designed into the PCB. This design optimizes the heat transfer from the integrated circuit (IC).

For information on the Quad Flatpack No-Lead (QFN) package and its advantages, refer to Application Report, Quad Flatpack No-Lead Logic Packages, Texas Instruments Literature No. SCBA017. This document is available at www.ti.com.

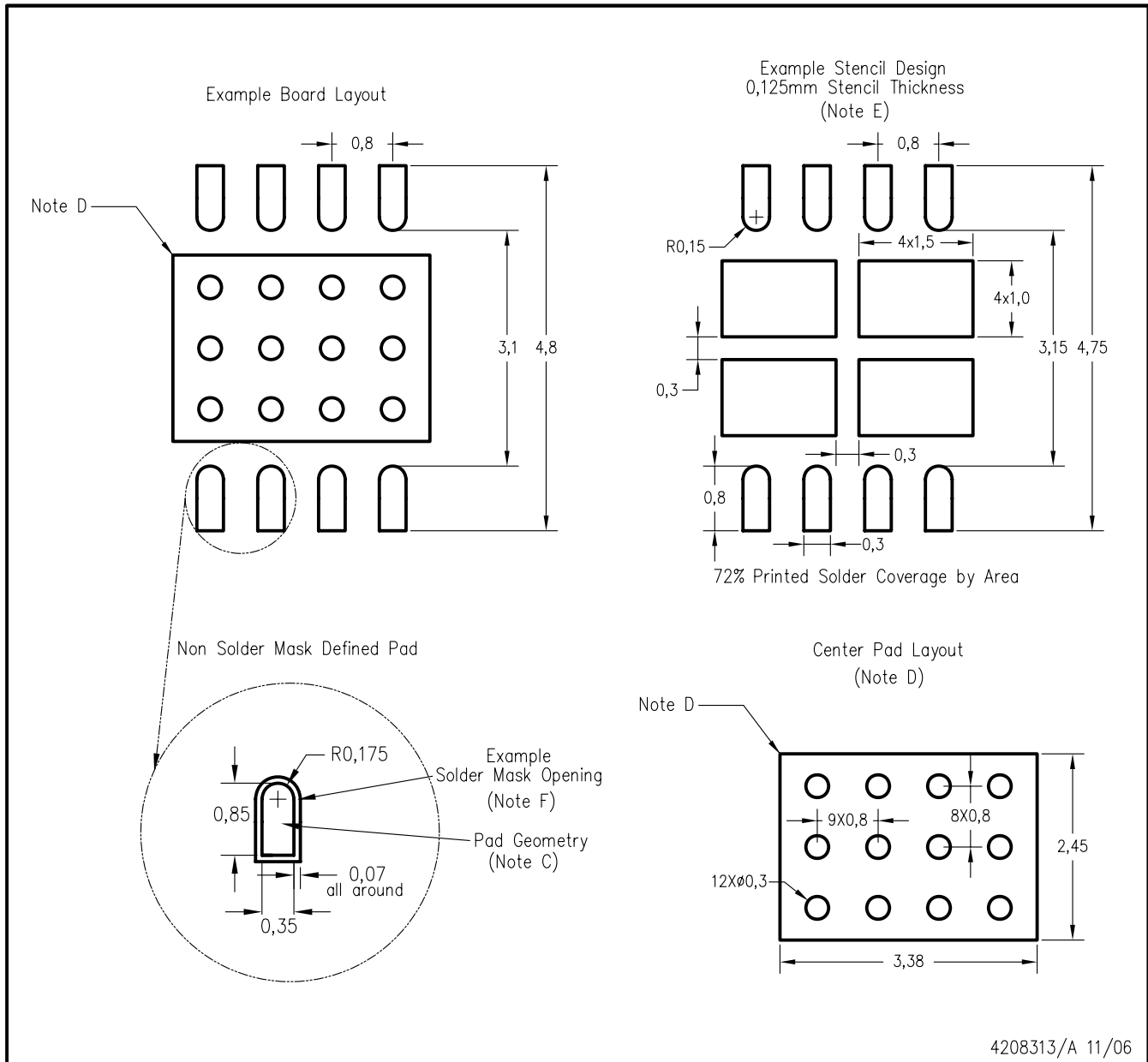
The exposed thermal pad dimensions for this package are shown in the following illustration.



NOTE: All linear dimensions are in millimeters

Exposed Thermal Pad Dimensions

DRM (S-PDSO-N8)



- NOTES:
- A. All linear dimensions are in millimeters.
 - B. This drawing is subject to change without notice.
 - C. Publication IPC-7351 is recommended for alternate designs.
 - D. This package is designed to be soldered to a thermal pad on the board. Refer to Application Note, QFN Packages, Texas Instruments Literature No. SCBA017, SLUA271, and also the Product Data Sheets for specific thermal information, via requirements, and recommended board layout. These documents are available at www.ti.com <<http://www.ti.com>>.
 - E. Laser cutting apertures with trapezoidal walls and also rounding corners will offer better paste release. Customers should contact their board assembly site for stencil design recommendations. Refer to IPC 7525 for stencil design considerations.
 - F. Customers should contact their board fabrication site for solder mask tolerances.

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