

## Copper Hybrid Bond Interconnections for Chip-On-Wafer Applications

Tuesday, May 30, 2023, 10:30 a.m. – 12:00 p.m.

Chairs: Thomas Gregorich (Infinera) and Chaoqi Zhang (Qualcomm)

Moderator: Jan Vardaman (TechSearch International)

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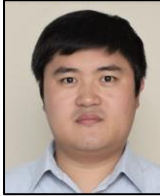
**RESONAC**

Chemistry for Change

## *Copper Hybrid Bond Interconnections for Chip-On-Wafer Applications*



*Chair*  
**Thomas Gregorich**  
Infirera



*Chair*  
**Chaoqi Zhang**  
Qualcomm



*Moderator*  
**Jan Vardaman**  
TechSearch International



*Speaker*  
**Eric Beyne**  
IMEC



*Speaker*  
**Kenneth Larsen**  
Synopsys



*Speaker*  
**Raja Swaminathan**  
AMD



*Speaker*  
**Thomas Uhrmann**  
EVG



*Speaker*  
**Chris Scanlan**  
Besi



*Speaker*  
**Xavier Brun**  
Intel

As one of the primary building-blocks of IC packages, electrical interconnections are evolving rapidly to address increasing ultra-high bandwidth requirements. Copper Hybrid Bonds deliver the highest-density chip-to-chip interconnect and are seen as a key enabling technology for ultra-high bandwidth devices/systems such as vertically-stacked chiplets.

This Special Session will explore the applications, requirements, and challenges of Copper Hybrid Bonds (CHB) for Chip-to-Wafer (C2W) applications. Wafer-to-wafer CHB has been in HVM for many years and continues to expand. While C2W is in production, challenges remain. This panel will discuss challenges and solutions for the expanded use of C2W Copper Hybrid Bonds.

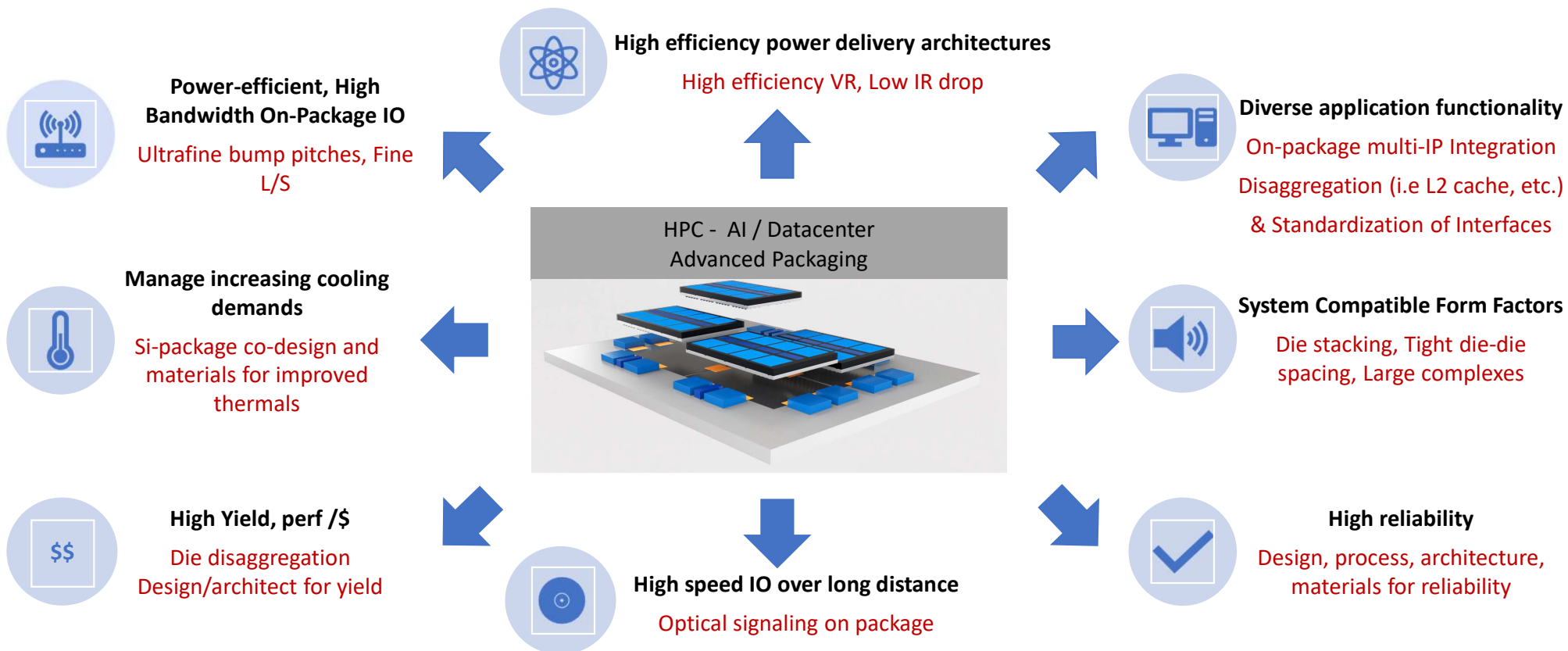
# Copper Hybrid Bond Interconnections for Chip-to-Wafer Applications

**Xavier F. Brun**

*Intel Corporation, Assembly Test Technology Development  
Chandler, AZ, United States*

*Ack. Sai A., Pooya T., Kaladhar R., Adel E., AP&PL Team*

# Heterogeneous Packaging Requirements

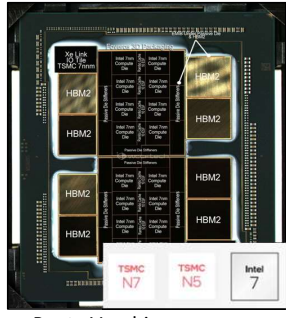


**Copper Hybrid Bonding (CHB) performance benefits drives adoption in HPC AI / Datacenter applications**

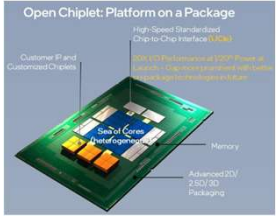
# CHB HI Challenges & Opportunities

## External IP/die/pkg Integration Challenge

- Standardization of Bond Interface (enabling mix-foundry HI)
- Design rule/ Design co-optimization
- 3D HBI protocol standardization



Source: WCCF TECH INC.

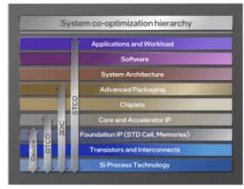


Universal Chiplet Interconnect Express

Source: UCle

## Cost Challenge

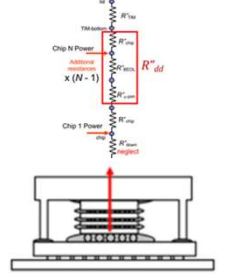
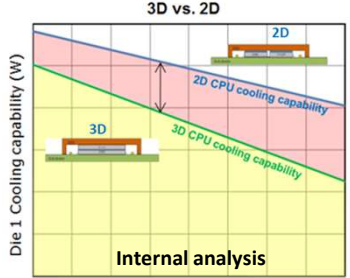
- Current C2W HB cost limits wide product adoption (logic) vs. solder solution
- Standardization / Supplier Ecosystem
- System technology co-optimization (STCO)



Source: A. Kelleher IEDM'22

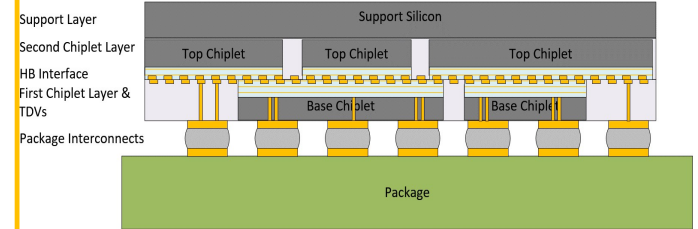
## Thermal Challenge

- Lower 3D pkg cooling capability



Source: Heterogeneous Integration Roadmap Chapter 20

## HI with Hybrid Bonding [Quasi-Monolithic Chips (QMC)]



Elsherbini, A., et al. "Enabling Next Generation 3D Heterogeneous Integration Architectures on Intel Process." 2022 IEDM. IEEE, 2022.

## C2W HBI Yield Challenge

- Die-Wafer, Stack Die- Substrate
- Improved alignment accuracy for pitch scalability
- Controlled wafer/die warpage and stress
- Stacked die coplanarity

## New Material Challenge

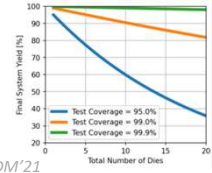
- Low cost/reliable Die to Die fill materials
- Bonding surface protection material
- Carrier materials / clean or PL chemistries
- Thermal interface materials

## Power delivery Challenge

- 3D stacking (active on active)
- Need EDA tools

## Test Challenge

- New test strategy for fine pitch
- Need better test coverage



Source: A. Elsherbini, IEDM'21

**Need 3D HBI interface standardization to help CHB adoption**  
**System technology co-optimization key to HI with C2W Hybrid Bonding**



# C2W Hybrid Bonding Technology Challenges

## Metrology Challenge

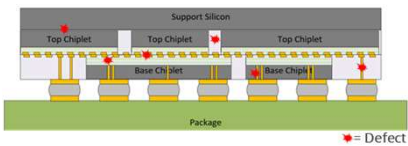
- In-line metrology & inspection for real time process feedback



- AI/ML Training Integration for High-Precision, High TPT Recess Metrology



- High Speed, Localized, Non-destructive Defect Detection



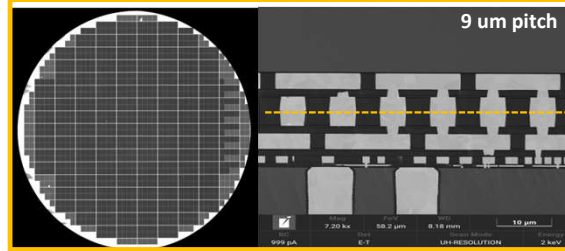
## Process & Thermal Mechanical Challenges

- CMP for Cu dishing control
- Clean singulation solution
- Sit time control for plasma activation
- Thermal budget for the process flow
- Control overall stress of the package

### Surface Topography Optimization

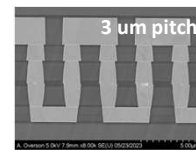


## Void-Free Bonding with Extremely High Placement Accuracy (< 1μm)



## Test & Reliability Challenges

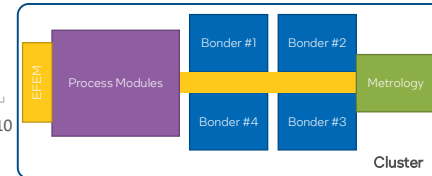
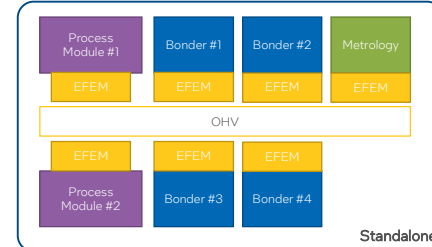
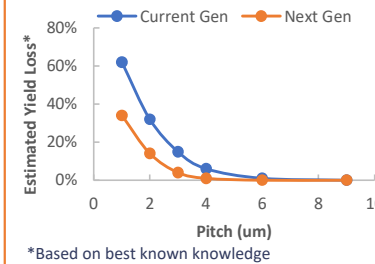
- New test strategy with tight pitch pads
- Reliability for hybrid bonding (Cu-Cu & dielectric bond strength)



## C2W Equipment Challenge

- Scalability for Reducing Pitch
- Cleanliness Control
- Active Thermal Control
- Run Rate Optimization

### Yield Impact from Bonder Accuracy



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# Die-to-Wafer Hybrid bonding Technology Roadmap

Eric Beyne, imec



This is also the Main driver for 2.5D and 3D integration technologies:

- Increasing system complexity
  - Increasing need for heterogeneous integration – not only SOC
  - Increasing die-to-die interconnect data bandwidth:
    - more interconnect channels,
    - higher interconnect speeds per interconnect
  - Reducing die-to-die interconnect energy:
    - Shorter distance interconnect
    - Scaled, lower capacitance interconnects
    - Lower voltage
- } Very high aggregate bandwidth

⇒ It is not about the number of interconnects but rather the available (local) interconnect density enabled by interconnect pitch scaling

- Solder  $\mu$ bump technology:  $50 \Rightarrow 25 \mu\text{m}$  pitch today
- Wafer-to-Wafer Hybrid bonding:  $10 \Rightarrow 1 \mu\text{m}$  pitch today

- Solder  $\mu$ bump technology:  $50 \Rightarrow 25 \mu\text{m}$  pitch today

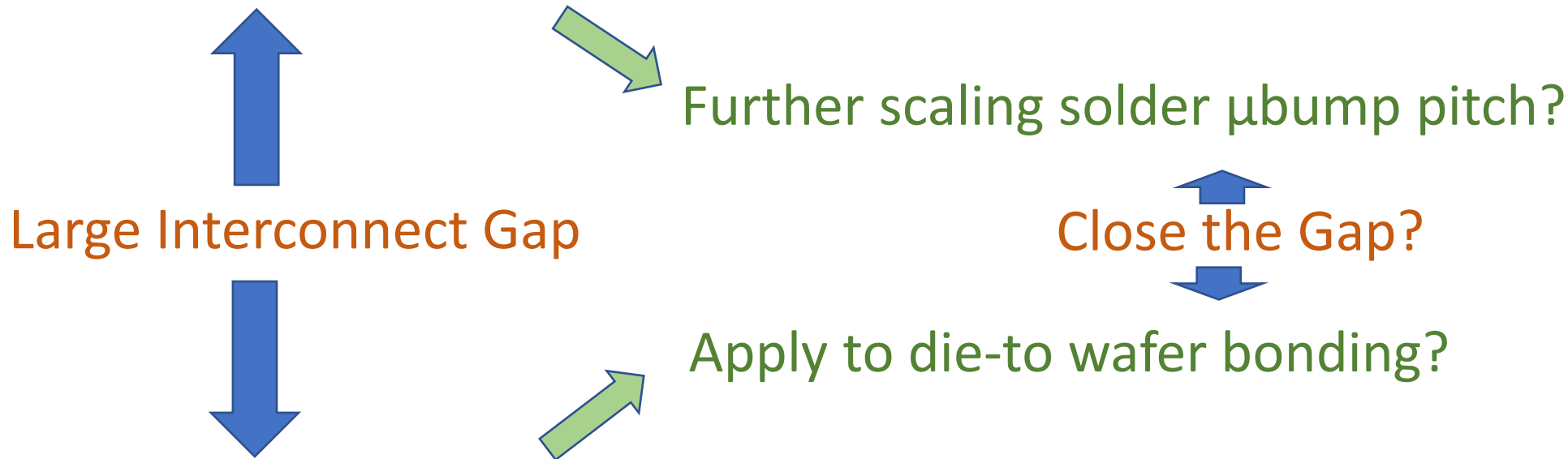


Large Interconnect Gap



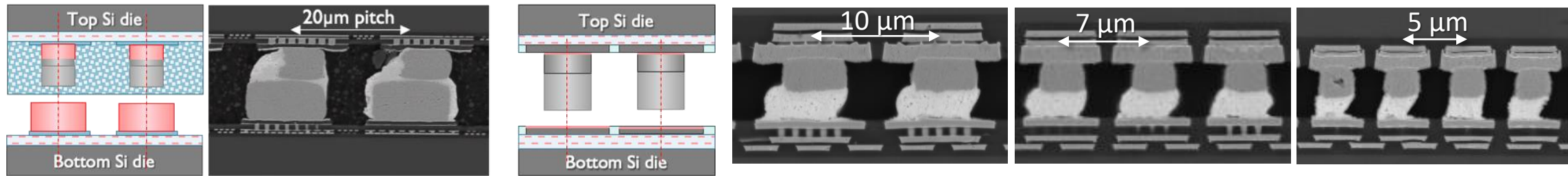
- Wafer-to-Wafer Hybrid bonding:  $10 \Rightarrow 1 \mu\text{m}$  pitch today

- Solder  $\mu$ bump technology:  $50 \Rightarrow 25 \mu\text{m}$  pitch today

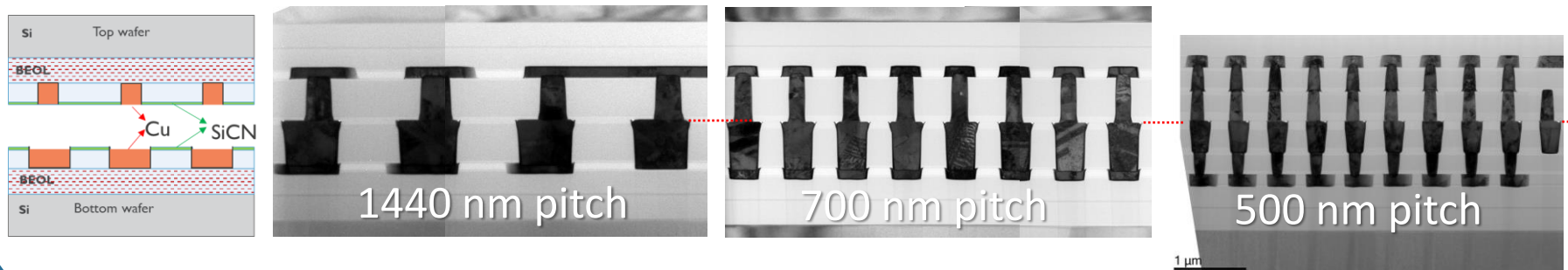


- Wafer-to-Wafer Hybrid bonding:  $10 \Rightarrow 1 \mu\text{m}$  pitch today

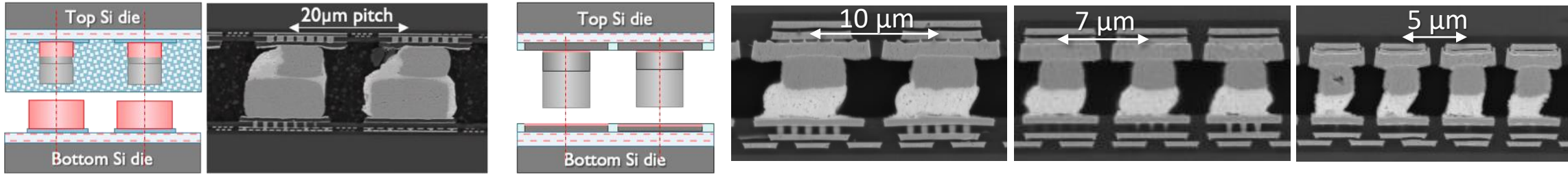
- Solder  $\mu$ bump technology:  $20 \Rightarrow 10 \Rightarrow 7 \Rightarrow 5 \mu\text{m}$  pitch



- Wafer-to-Wafer Hybrid bonding:  $2 \mu\text{m} \Rightarrow 700\text{nm} \Rightarrow 500\text{nm}$  pitch

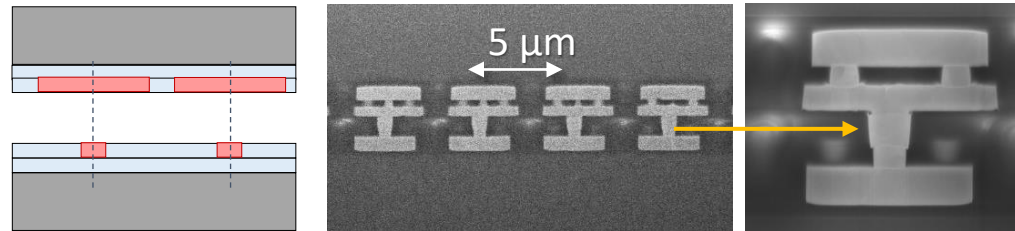


- Solder  $\mu$ bump technology:  $20 \Rightarrow 10 \Rightarrow 7 \Rightarrow 5 \mu\text{m}$  pitch

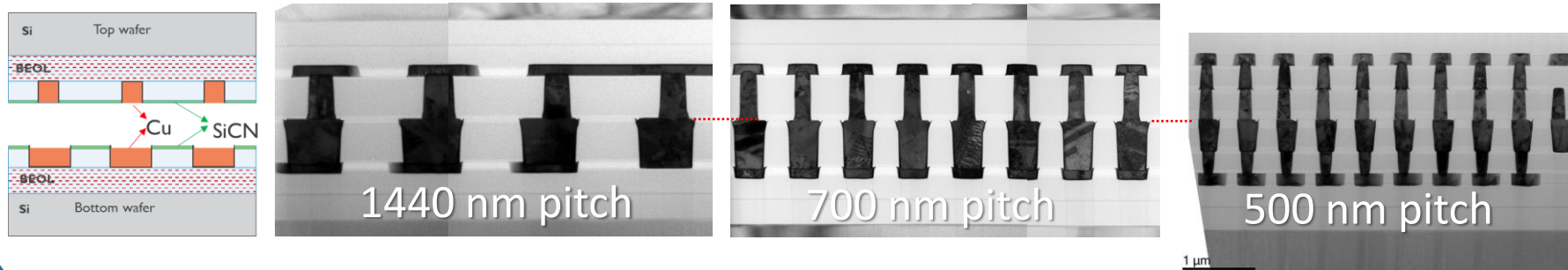


- Die-to wafer Hybrid bonding:  $10 \Rightarrow 5 \Rightarrow 2 \mu\text{m}$  pitch

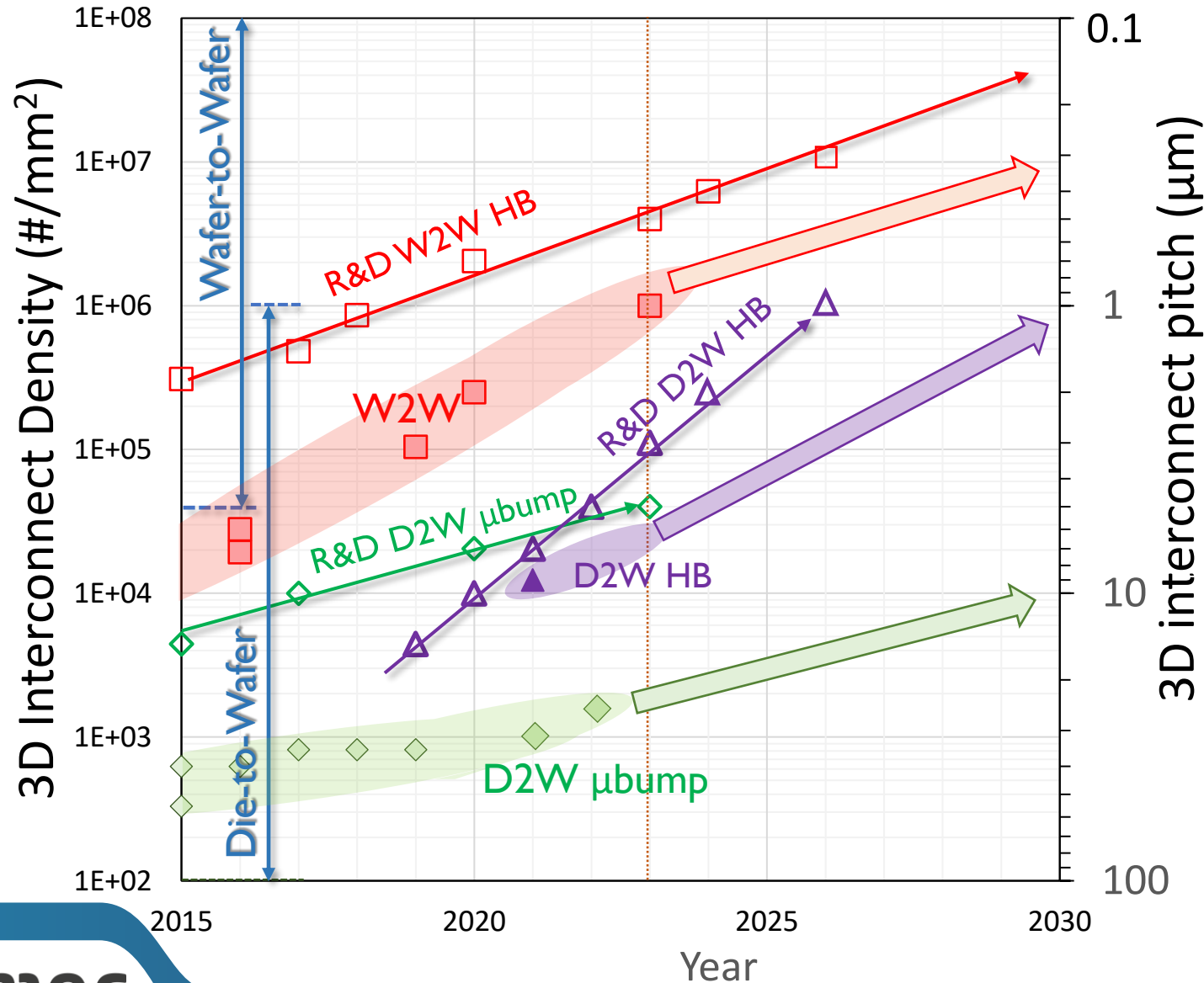
- Ultra clean dicing
- Post dicing die cleaning
- Ultra-clean, High precision, High UPH D2W placement



- Wafer-to-Wafer Hybrid bonding:  $2 \mu\text{m} \Rightarrow 700\text{nm} \Rightarrow 500\text{nm}$  pitch



# 3D Interconnect Roadmap – imec R&D & Industry



R&D roadmap 5 to 10 year ahead of industry adoption

*D2W Hybrid bonding will fill the 10 to 1 µm pitch gap between µBump bonding and W2W HB bonding*

- W2W HB - imec R&D
- W2W HB - industry
- △ D2W HB - imec R&D
- △ D2W HB - industry
- ◇ D2W µBump - imec R&D
- ◇ D2W µBump - industry

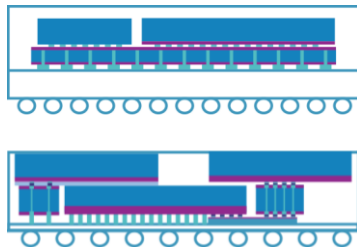
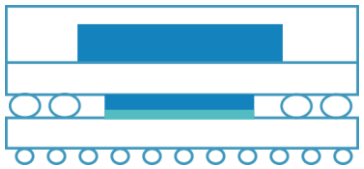
D2W= Die-to-wafer bonding  
W2W= Wafer-to-Wafer bonding  
HB= Hybrid bonding

# The 3D Interconnect Technology Landscape

## 3D-SIP

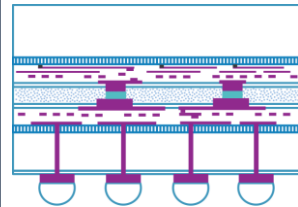
Package stacking

- Multi-die Packaging
- Interposer “2.5D”
- Embedded Die

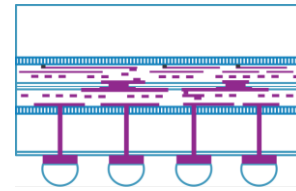


## 3D-SIC

Die Stacking  
μbump

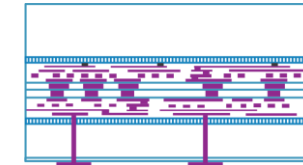


Die Stacking  
Hybrid bonding

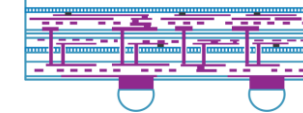


## 3D-SOC

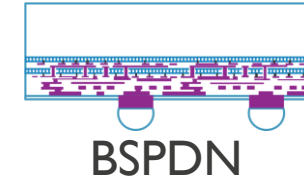
Wafer-to-Wafer  
Hybrid bonding



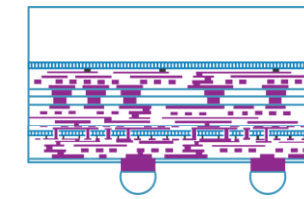
Dielectric bonding  
μTSV



Wafer-to-Wafer  
Sequential

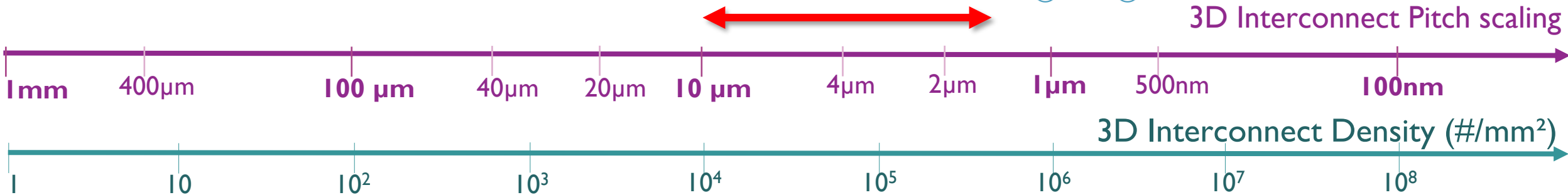
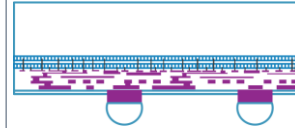


BSPDN



## 3D-IC

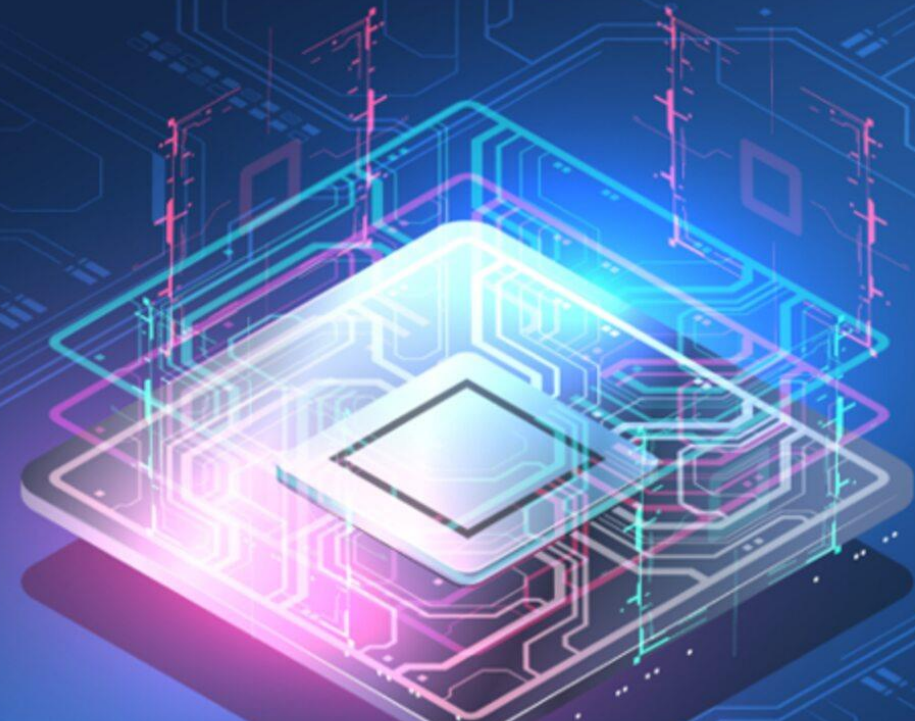
Transistor  
Stacking





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# Enabling Robust 3DHI Products: A Quality and Reliability Perspective

# Broader 3DHI Challenges

## Design

- Architecture exploration
- Multi-X verification & analysis

## Manufacturing

- Chiplet / interconnect / system quality
- Scalability

## Deployment

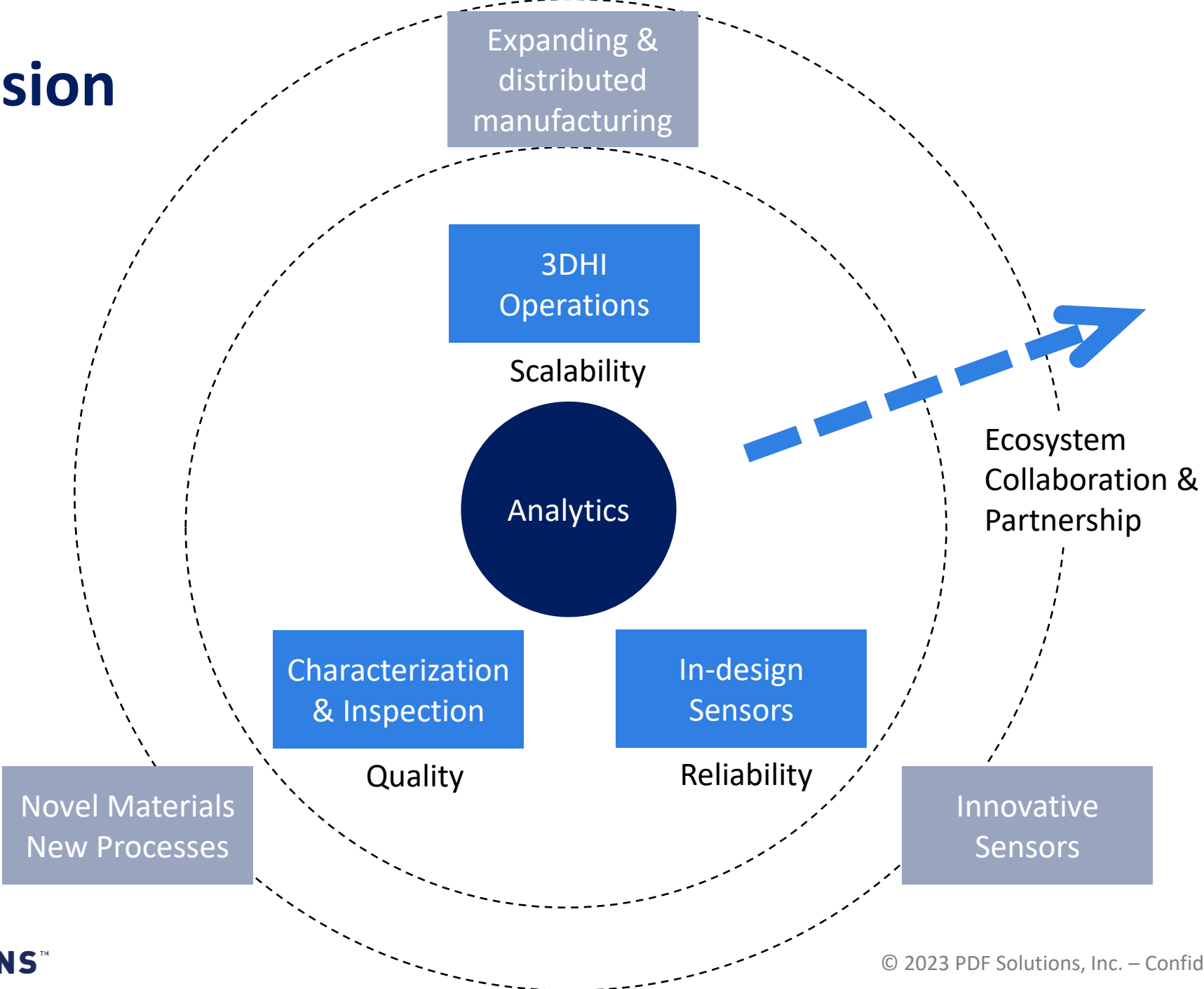
- Reliability
- Safety

SDTCO

Security

Resiliency

# PDF Mission



# PDF Capabilities: Hybrid Bonding Use Cases

Design

Ramp

Production

Deployment



Process Control  
+ Assembly Ops  
+ Test Ops

Real-time 3DHI operations and test control  
E142 Single device traceability



Manufacturing  
Analytics

End-to-end, anywhere to anywhere, correlation & problem-solving

DirectScan (ebeam)  
+  
Characterization Vehicle  
Infrastructure (probed)

Massively parallel characterization of  
alignment / resistivity / performance ...



In-circuit sensors and  
control

Pre/post-assembly stress  
Burn-in / in-field aging

Software

Hardware

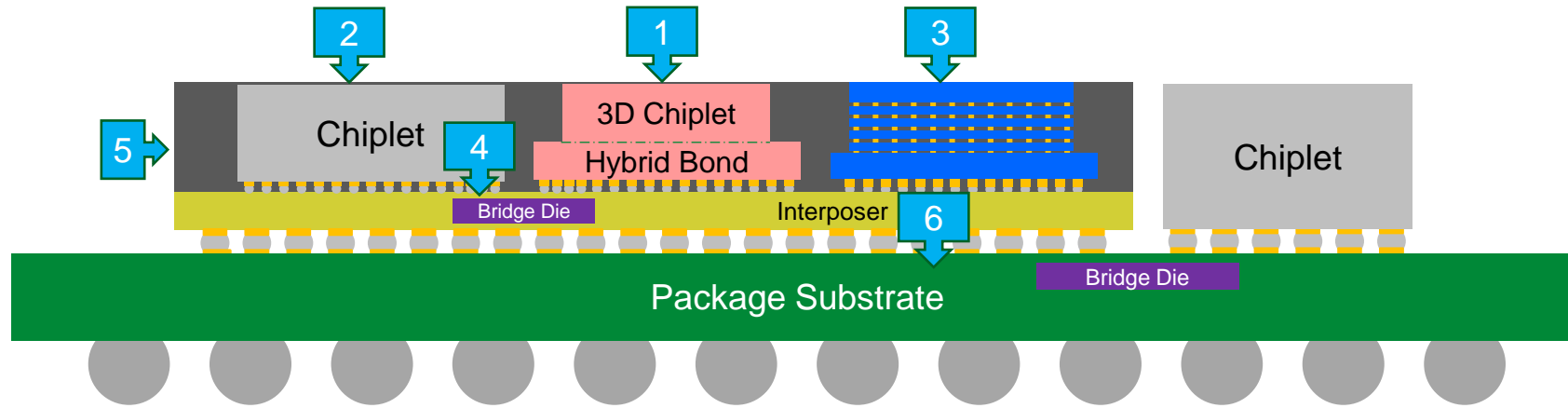


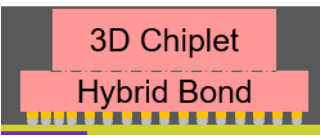
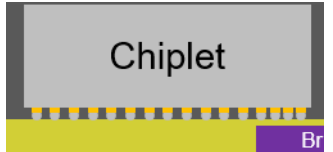
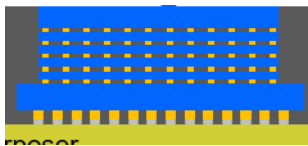
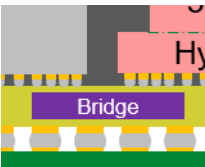

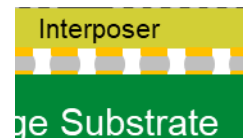
# Chip-to-Wafer Hybrid Bonding Opportunities and Challenges

2023 ECTC Special Session on Copper Hybrid Bonds

Chris Scanlan  
SVP Technology, Besi

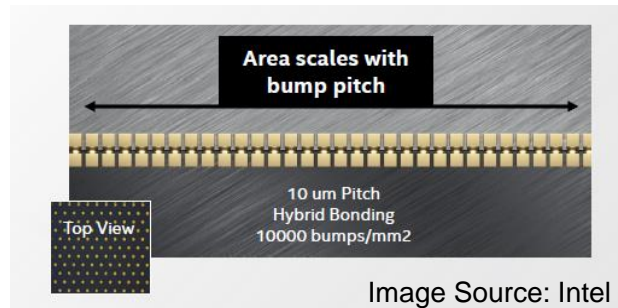
# New 3D Chiplet Structures Use Variety of Processes



<p>1</p> <p>Hybrid Bonding</p> 	<p>2</p> <p>Chip to Wafer TCB</p> 	<p>3</p> <p>High Bandwidth Memory Stacking</p> 	<p>4</p> <p>Embedded Bridge Die Attach</p> 	<p>5</p> <p>Wafer Level Die Molding</p> 	<p>6</p> <p>HD Interposer to Substrate</p> 
<p>8800 CHAMEO Ultra Plus</p>	<p>9800 TC Next C2W</p>	<p>8800 CHAMEO Ultra Plus 8800 TC Advanced</p>	<p>8800 Chameo Ultra</p>	<p>FML</p>	<p>2200 evo</p>

Enables faster, more complex devices with submicron placement accuracy.

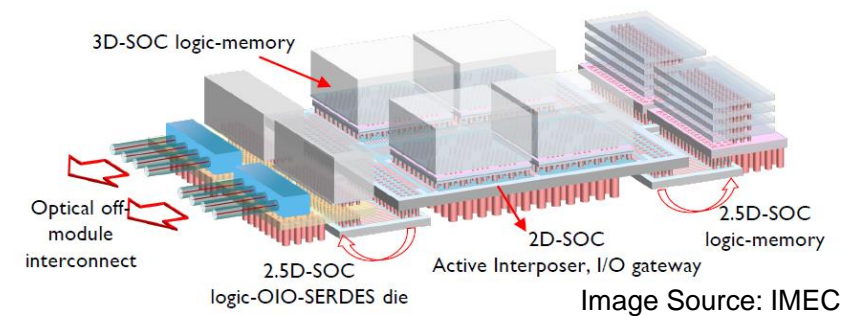
## Direct Cu-Cu Interconnect in 3D



1000x increase in contact density



## Heterogeneous integration of chiplets



More transistors per package

### Increased Performance

- Increased data transfer
- Higher bandwidth
- Higher speed

### Lower Cost of Ownership

- Higher die yield
- Lower energy per bit
- Lower cost per contact
- Lower heat dissipation

### Design Flexibility

- New 3D chiplets
- Fab node optimization
- Customized designs
- Highly configurable

# 8800 Chameo Ultra Plus Chip-to-Wafer Hybrid Bonder



First high-volume die-to-wafer hybrid bonder

In production since Q1 2022

200 nm alignment accuracy

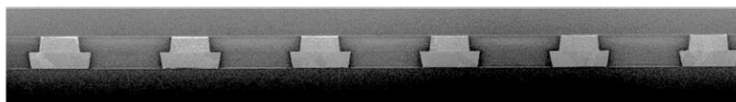
At high speed of up to 2000 UPH

Designed for use in front-end fab environment

Optional cluster line integration via collaboration with AMAT

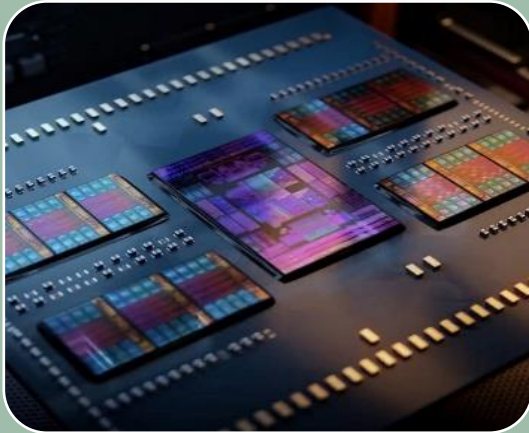
100 nm accuracy machine available in 2023

Roadmap to 50 nm accuracy





## HPC



**Logic + Memory  
Core on Core**

AI  
Datacenters  
Gaming

## Advanced Memory



**Advanced Memory Stacking**

HBM4  
DRAM

## Mobile



**Application Processors  
mmWave RF**

Smartphones

## Sensors and Photonics



**Integrated Silicon Photonics**

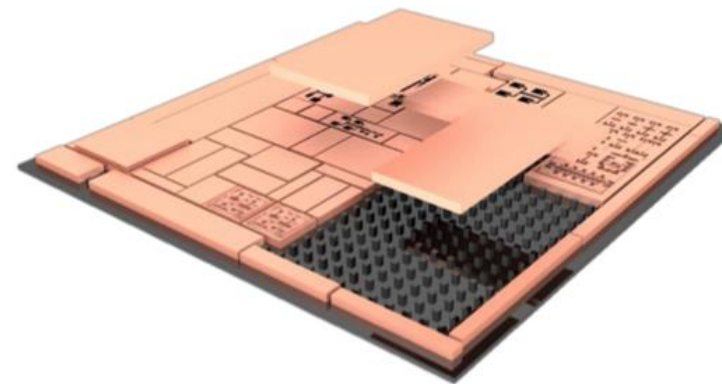
Image Sensors  
AR/VR Display

# Challenges to Broad Adoption of Interoperable Chiplets

Chiplets promise to allow integration of functional blocks from multiple companies into a single device, speeding development and reducing development cost

But several challenges must be addressed to integrate chiplets from different companies:

- Control and compatibility of the bonding surfaces
- Standardization of communication protocols and physical interfaces (e.g. UCIe)
- EDA tools and design flows
- Testability and verification of the individual chiplets and the assembly
- Performance binning and matching
- Yield ownership
- Failure analysis methods and ownership
- Product liability and allocation of risk
- Margin stacking
- Supply-chain management and logistics





# 3D ADVANCED PACKAGING ENABLING MOORE'S LAW'S NEXT FRONTIER

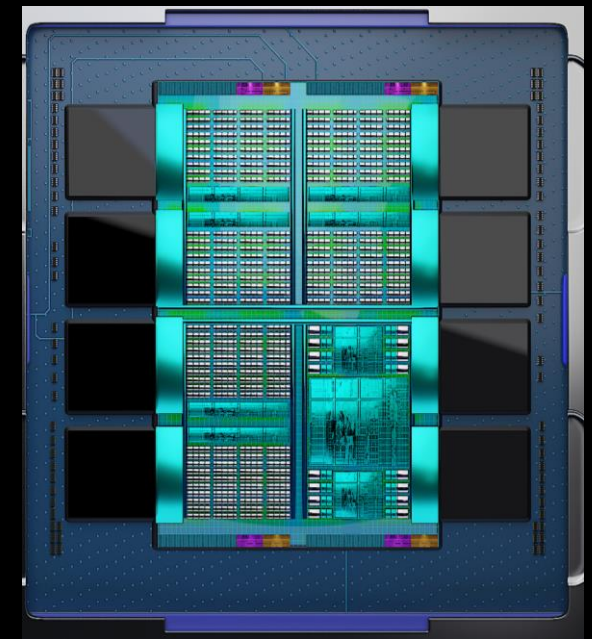
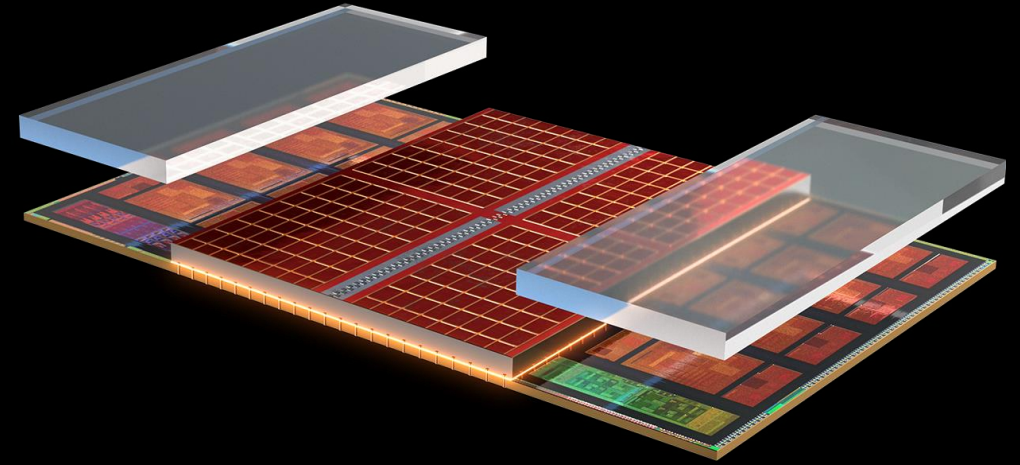
HYBRID BONDING COMES ALIVE TO ENABLE THE FUTURE OF  
HIGH- PERFORMANCE & AI COMPUTING

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**RAJA SWAMINATHAN**

AMD CORPORATE VP

ADVANCED PACKAGING LEADER



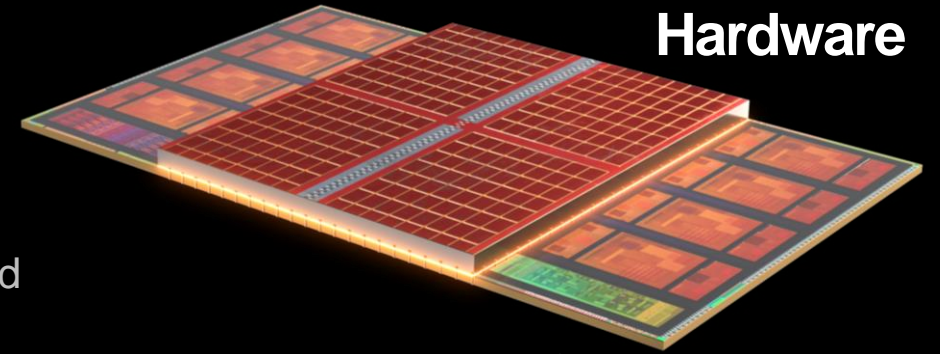
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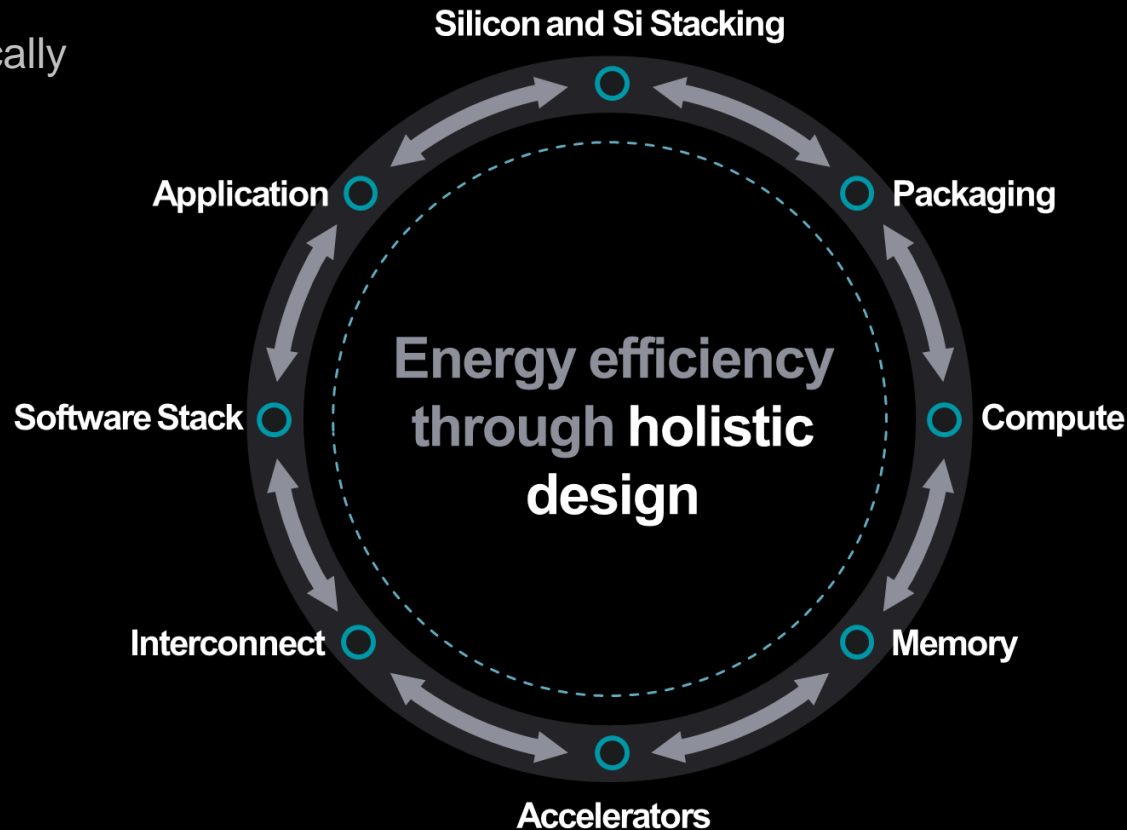
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# Energy efficiency requires holistic innovation

- Energy efficiency is the primary limiter. We must innovate in new dimensions:
  - System-level optimizations; Domain-specific heterogeneous architecture
  - Tight integration of compute and memory with chiplet architectures, advanced packaging, new interconnects
  - Leveraging AI holistically



Hardware



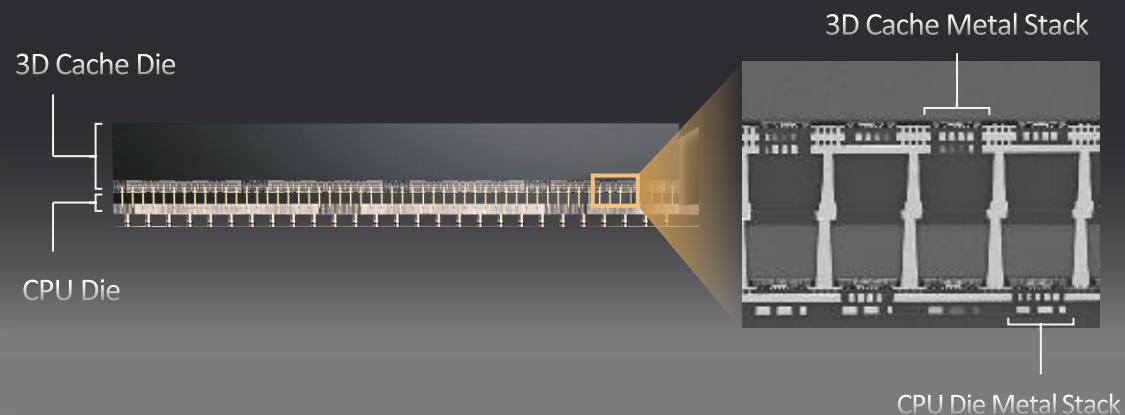
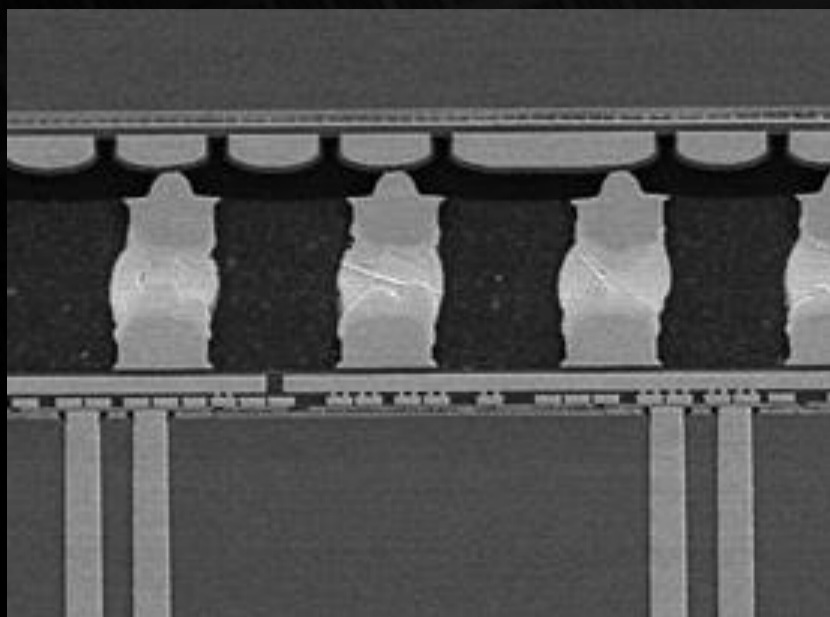
Software and Applications



# 3D ARCHITECTURES

## HYBRID BONDING DRIVING MOORE'S LAW SCALING

### Other 3D Architectures



### 3D Hybrid Bonding

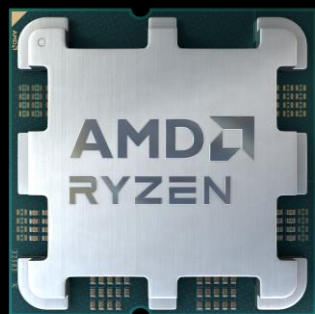
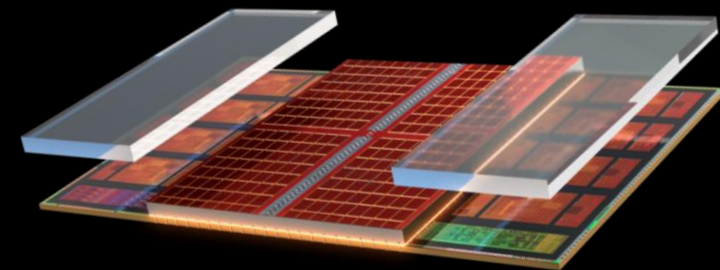
> 3X

Interconnect Energy Efficiency  
Compared to Micro Bump 3D

> 15X

Interconnect Density  
Compared to Micro Bump 3D

# AMD RYZEN™ 7 7800X3D



up to  
8 Cores  
16 Threads

up to  
5.0 GHz  
Boost

up to  
104 MB  
L2+L3 Cache

120W+  
TDP

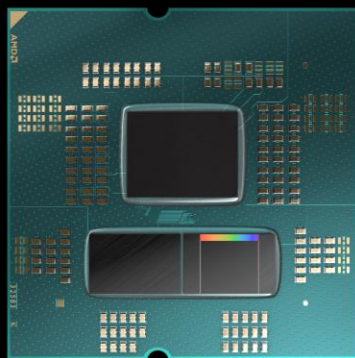


Processor architecture

5nm Technology

# AMD RYZEN™ 9 7950X3D

Ultimate processor for gamers and creators



up to  
16 Cores  
32 Threads

up to  
5.7 GHz  
Boost

up to  
144 MB  
L2+L3 Cache

120W  
TDP

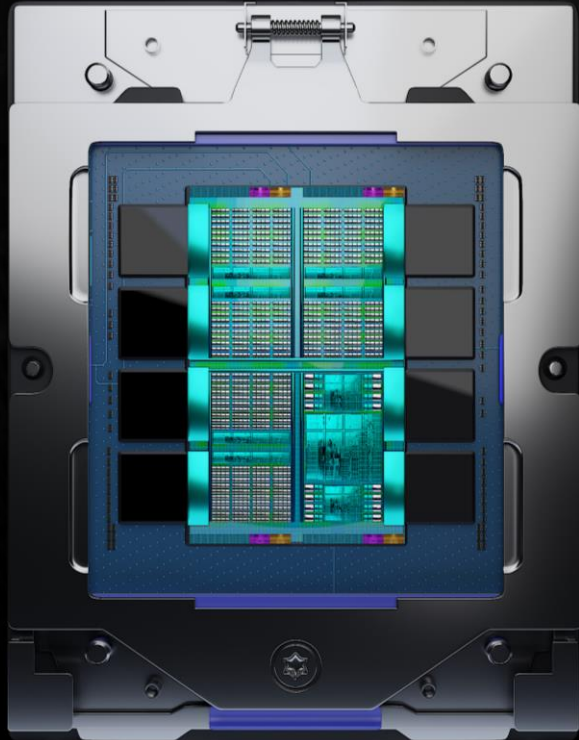


Processor architecture

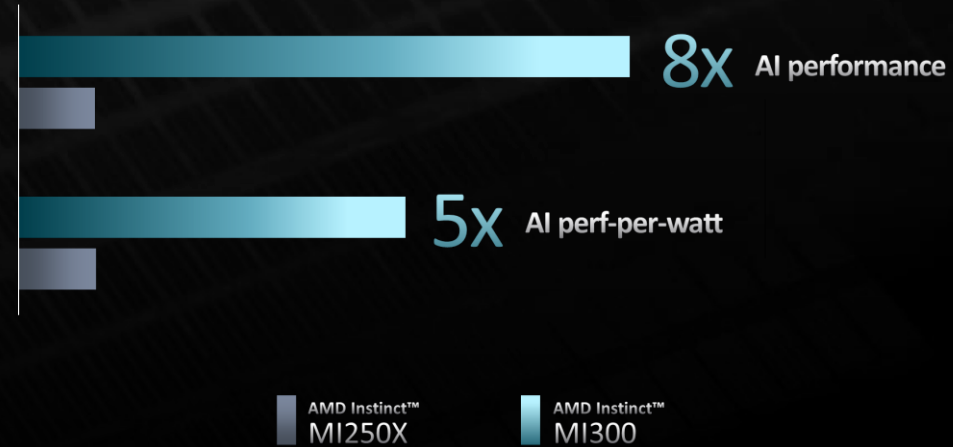
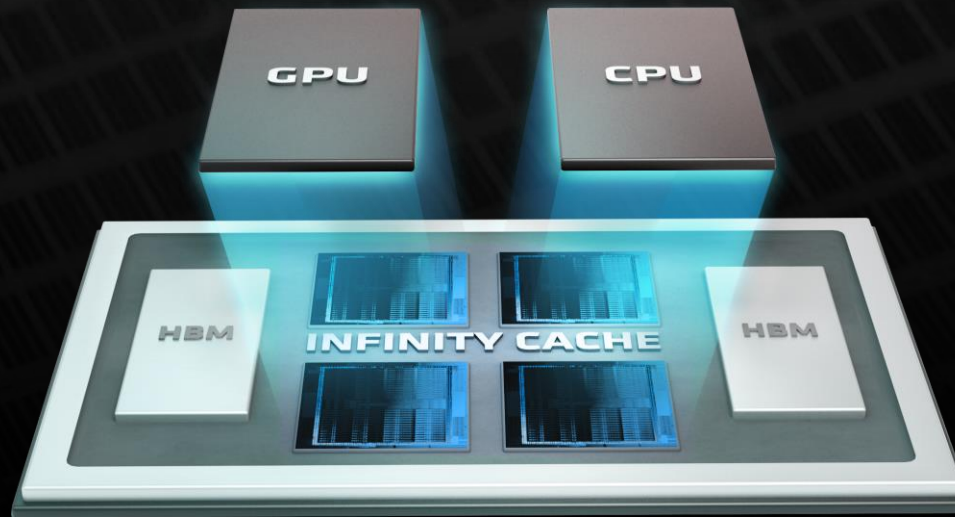
5nm Technology

# AMD INSTINCT™ MI300

The world's first data center integrated CPU + GPU



AMD CDNA™ 3 Unified Memory APU Architecture



146B  
Transistors

128GB  
HBM3

**AMD**  
CDNA 3  
Next-Gen  
Accelerator  
Architecture



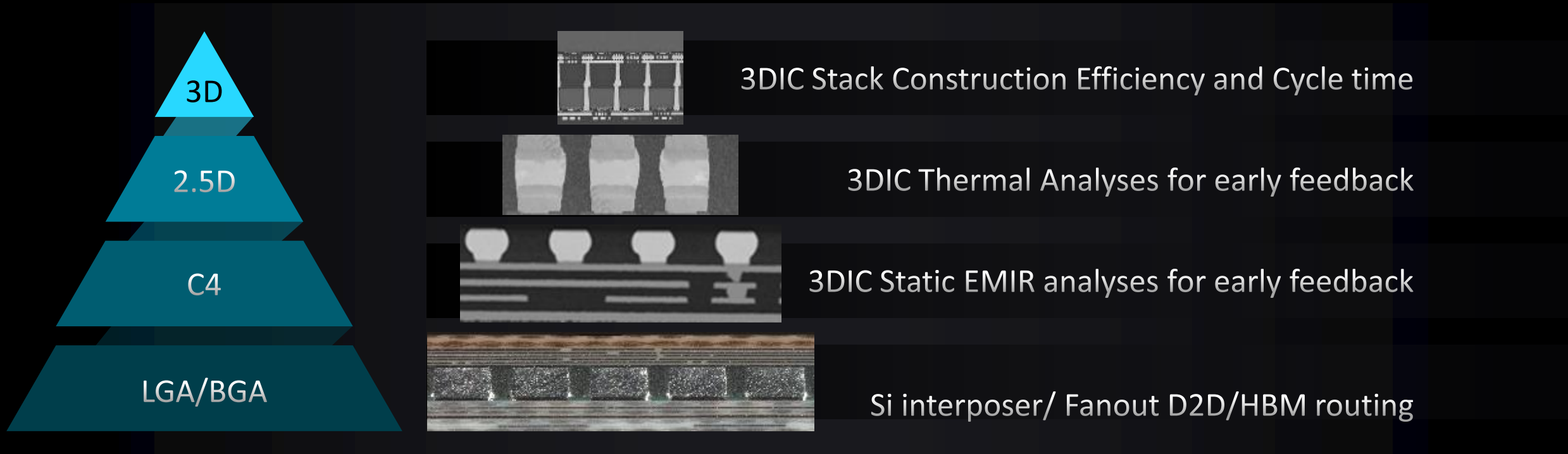
24 Leadership  
Data Center  
CPU cores

Enabled By  
**3D**

Advanced Chiplet Packaging



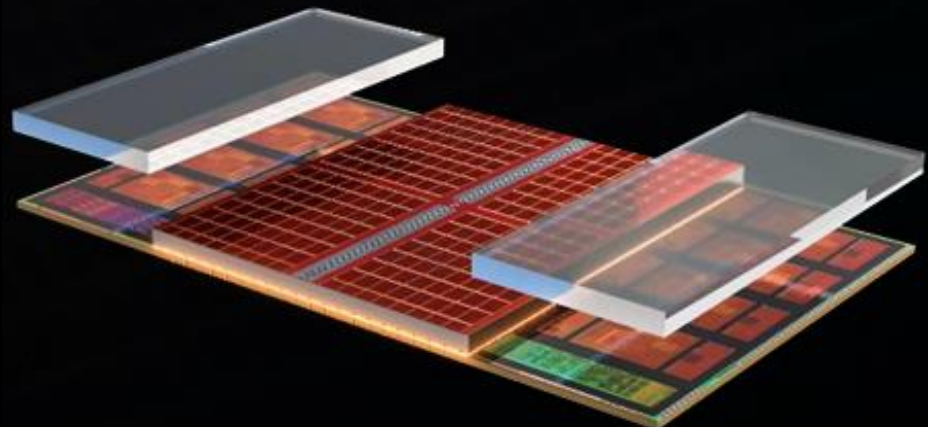
# DESIGN AUTOMATION OPPORTUNITIES



**MULTI-SCALE DESIGN/PROCESS OPTIMIZATION NEEDED TO MANAGE WARPAGE AND INTERCONNECT RELIABILITY**

# NEXT GEN 3D ARCH REQUIRES NEXT GEN EDA TOOLS

**1) STANDARDIZE DRC TOOL SET**  
DRC decks spanning all design components in 2.5D/3D architectures



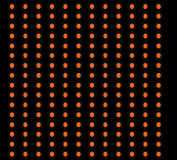
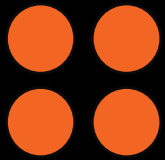
**2) ENABLE TRUE SILICON-PACKAGE CO-DESIGN**  
Proliferate common tool platform across silicon and package designs

**3) STANDARDIZE FILE FORMATS**  
Create a seamless tool-to-tool interaction from design to analysis

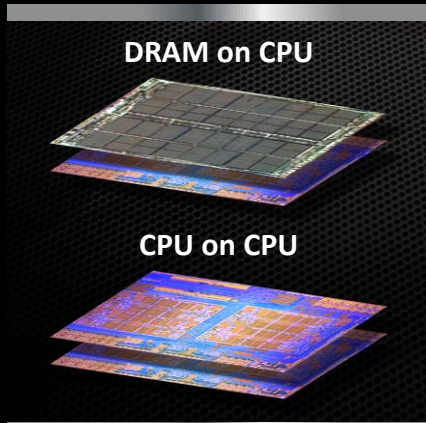
**4) INCREASE TOOL CAPACITY**  
EDA tools to stay lockstep with design pin count increases

## EDA TOOL ECOSYSTEM NEEDS TO MERGE SILICON AND PACKAGE TOOLCHAINS

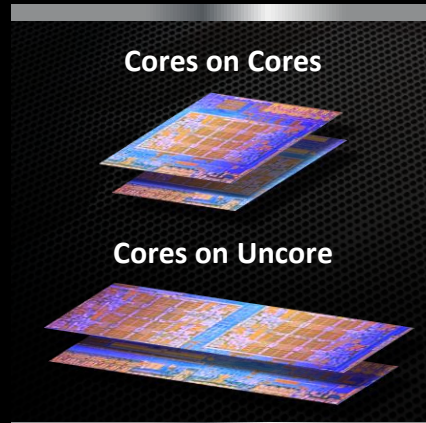
# FUTURE OF 3D STACKING



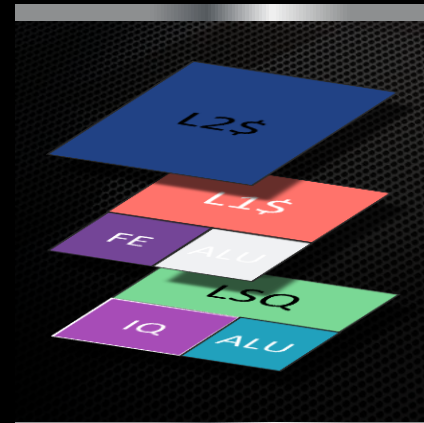
TSV Pitch



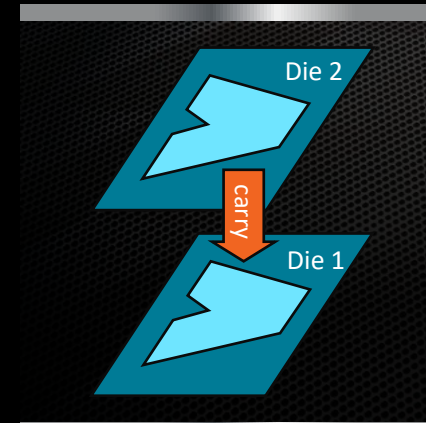
FULL DIE-TO-DIE



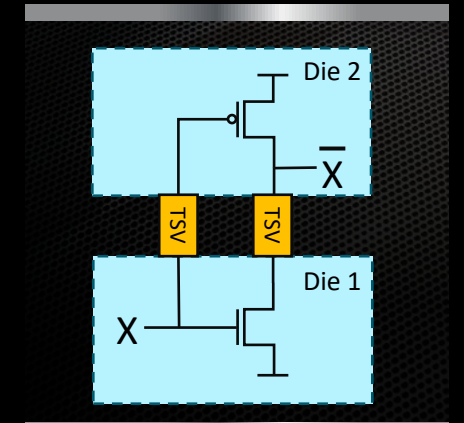
IP ON IP



MACRO IN MACRO



IP FOLDING/SPLITTING



CIRCUIT SLICING

ADVANCED PACKAGING CAN ENABLE INTEGRATION SCHEMES NOT POSSIBLE WITH MONOLITHIC DESIGNS



2023 ECTC Panel Discussion

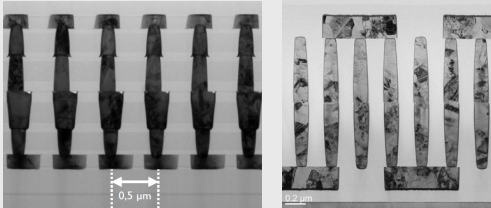
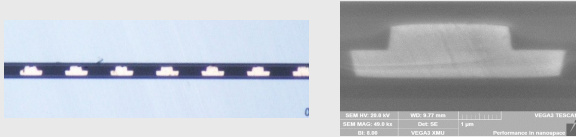
# D2W Considerations

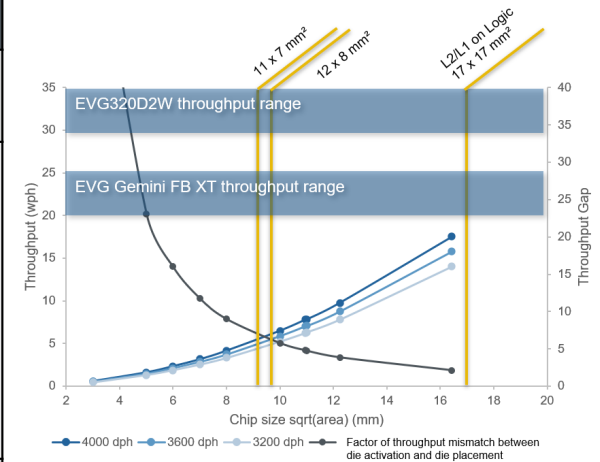
Dr. Thomas Uhrmann | Business Development Director



# D2W vs W2W Hybrid Bonding



	Hybrid W2W Bonding	Hybrid D2W Bonding
<b>Maturity</b>	Wafer Bonding Equipment and Process are matured since 2010	Process and Equipment maturity is starting to yield but still many difficulties
<b>Contact Pitch</b>	<p>&lt;1<math>\mu</math>m pitch in production &lt;500nm in development</p> 	<p>Currently 9<math>\mu</math>m pitch in production Roadmap for 2023: 2<math>\mu</math>m</p> 
<b>Equipment Capability</b>	Alignment: <50nm (3s) Post Bond Overlay: <75nm (3s)	Alignment: <150nm Post Bond Overlay: ~350nm
<b>Die Size</b>	Die Size and Grid Matching required	No limitations in die size and system segmentation
<b>Segmentation</b>	Each bonding layer consist of one node	Each chiplet can consist of a different node
<b>Yield</b>	Cumulative yield of each bonded layer	Cumulative yield can be avoided by testing
<b>Throughput</b>	>25 bonds per hour	Related to chip size and amount of chiplets per system



- Direct placement throughput matching is impossible to achieve, as pre-processing and die placement show a throughput difference between 2x to 10x for standard die sizes
- For small dies of less than 6x6mm<sup>2</sup> D2W bonding cost is strongly increasing
- W2W bonding can offer improved cost / yield ratio





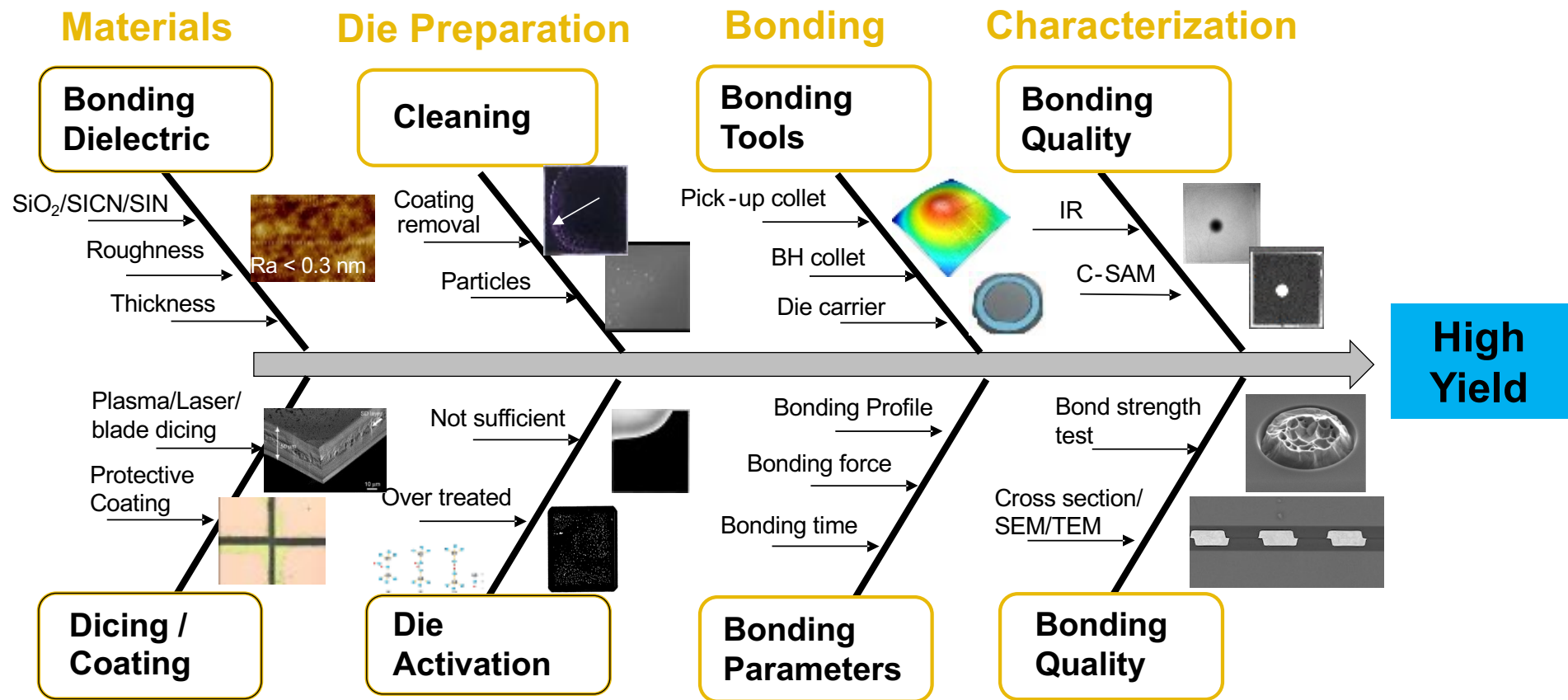
# D2W Hybrid Bonding | Many ways to succeed...

	Co-D2W	Reconstructed W2W	DP-D2W	SA-D2W
<b>Transfer Method</b>	Collective Bonding (Die Level Bonding)	Reconstructed W2W (Anorganic Fill Process)	Direct placement of activated dies using Flip Chip Bonder	Self Assembly on hydrophilic guiding pads
<b>Pro's</b>	<ul style="list-style-type: none"> <li>Proven technology</li> <li>Die Activation and cleaning equivalent to W2W hybrid bonding</li> <li>Oxide management</li> <li>Rework on carrier feasible</li> </ul>	<ul style="list-style-type: none"> <li>Proven process</li> <li>High yield, clean process</li> <li>All based on standardized wafer-based manufacturing equipment</li> </ul>	<ul style="list-style-type: none"> <li>Versatile method</li> <li>Die thickness invariant</li> </ul>	<ul style="list-style-type: none"> <li>Avoids high precision flip chip bonder and potential cost saving</li> <li>Die thickness invariant</li> </ul>
<b>Con's</b>	<ul style="list-style-type: none"> <li>Error propagation of D2W + W2W alignment</li> <li>Cost of carrier prep, utilization and clean</li> <li>Die thickness needs to be in narrow range</li> </ul>	<ul style="list-style-type: none"> <li>W2W bonding process is heavily impacted by die grid and filling factor between dies</li> </ul>	<ul style="list-style-type: none"> <li>Bonding interface needs to be touched</li> <li>Die handling especially for multi die stacks such as SRAM, DRAM</li> <li>Particle management during die placement</li> </ul>	<ul style="list-style-type: none"> <li>High precision die preparation using chemical treated zones</li> <li>Dicing potentially affects placement</li> <li>Die strain is affecting self alignment results</li> </ul>
<b>Maturity</b>	Limited volume production proven for several years	Limited volume production	Limited volume production	Experimental results available, Feasibility testing ongoing

*Combination of known good dies on carrier with anorganic wafer level pre processing, post processing and W2W bonding*



# D2W Hybrid Bonding | Process Considerations



Source: ASMPT / EVG Paper "Direct Die to Wafer Cu Hybrid Bonding for Volume Production" – Session 3



**SYNOPSYS**<sup>®</sup>

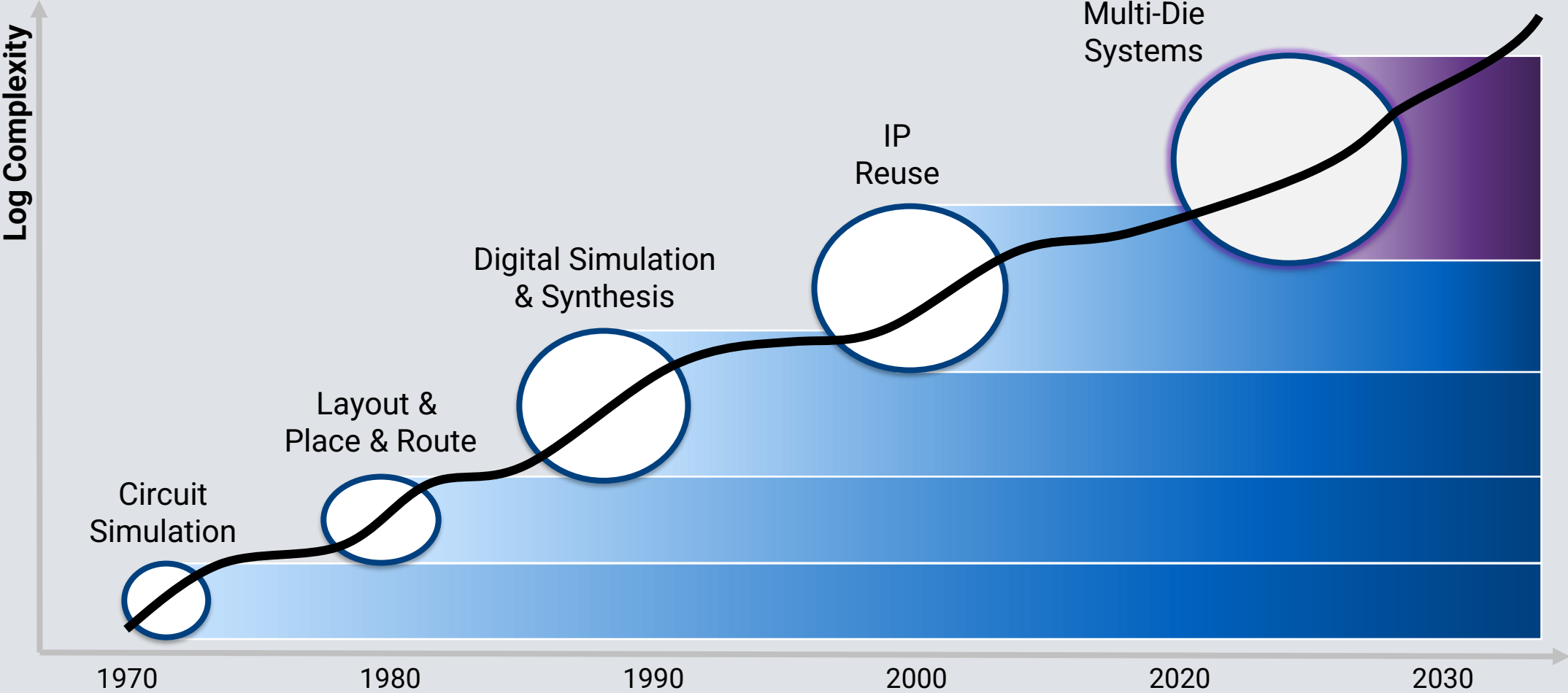


# C2W Cu Hybrid Bonding Design and EDA Perspective

Abhijeet Chakraborty, VP Engineering, Synopsys Inc  
May 30, 2023

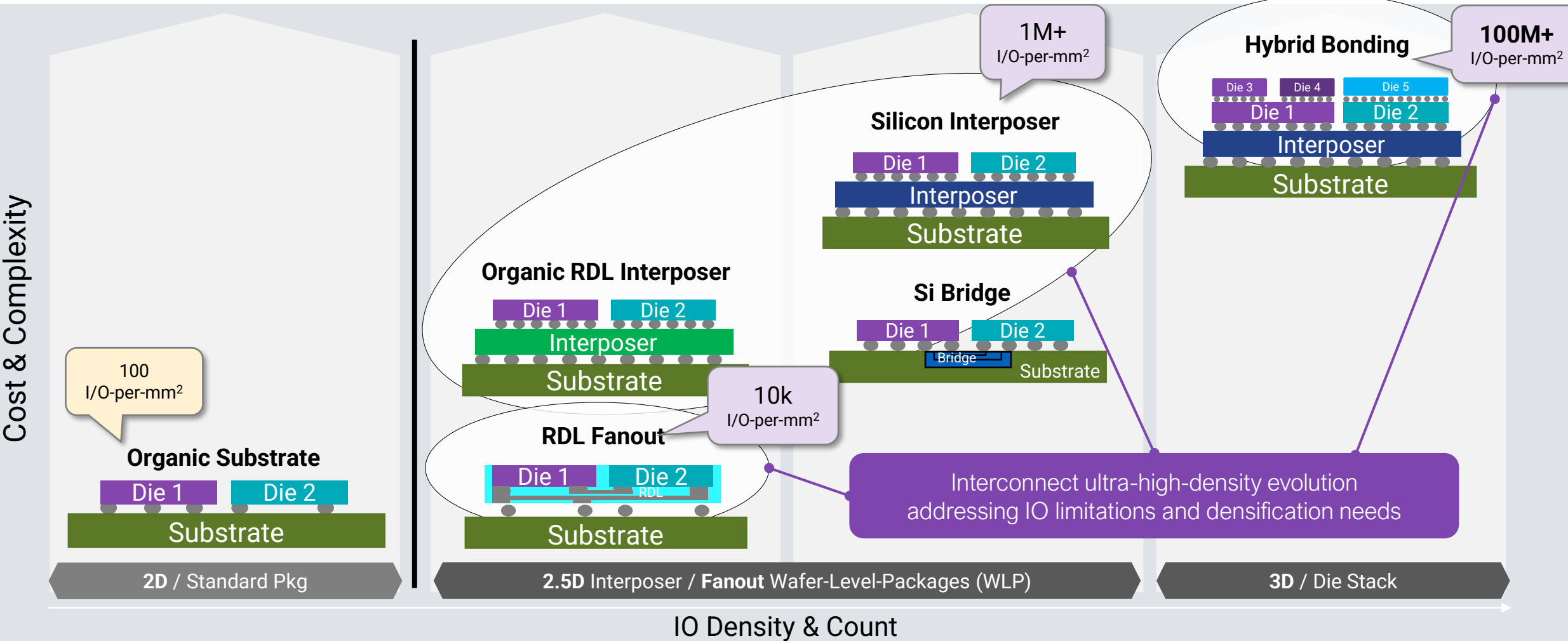


# Semiconductor Design Productivity Waves



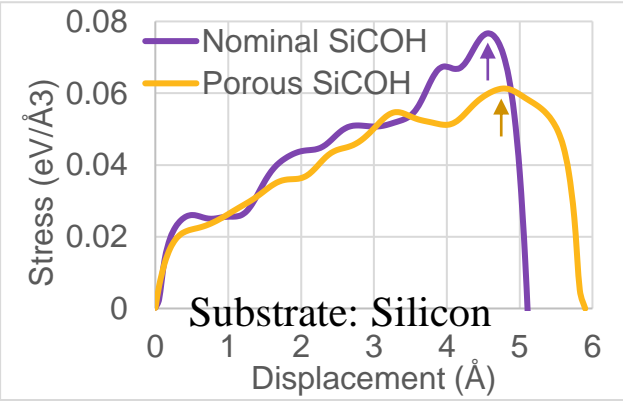
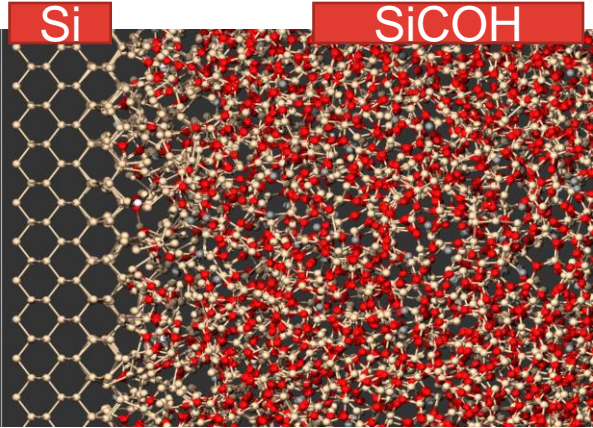
# System Optimization

Choice is driven by power/performance/form-factor/cost/time

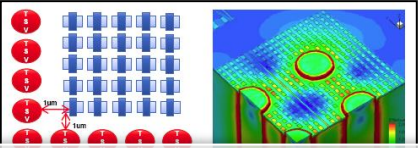


# Multi-Domain, Multi-Physics Analysis

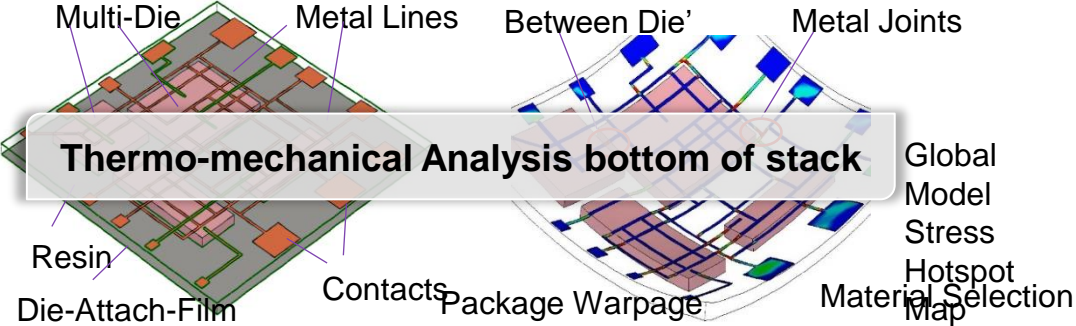
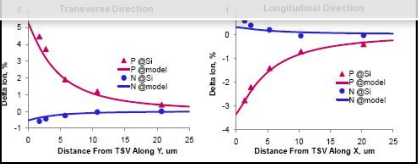
## Mechanical Reliability



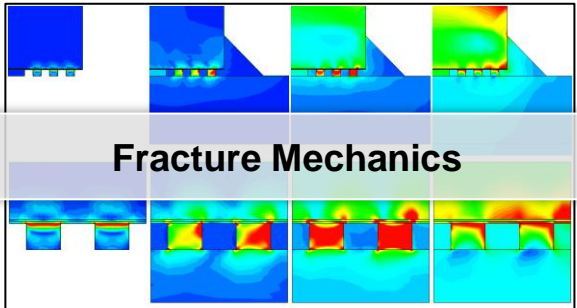
The interface bonding strength between a substrate and a complex material system, such as SiCOH, can be analyzed by molecular dynamics method with Synopsys QuantumATK



**TSV Stress Proximity Effects**



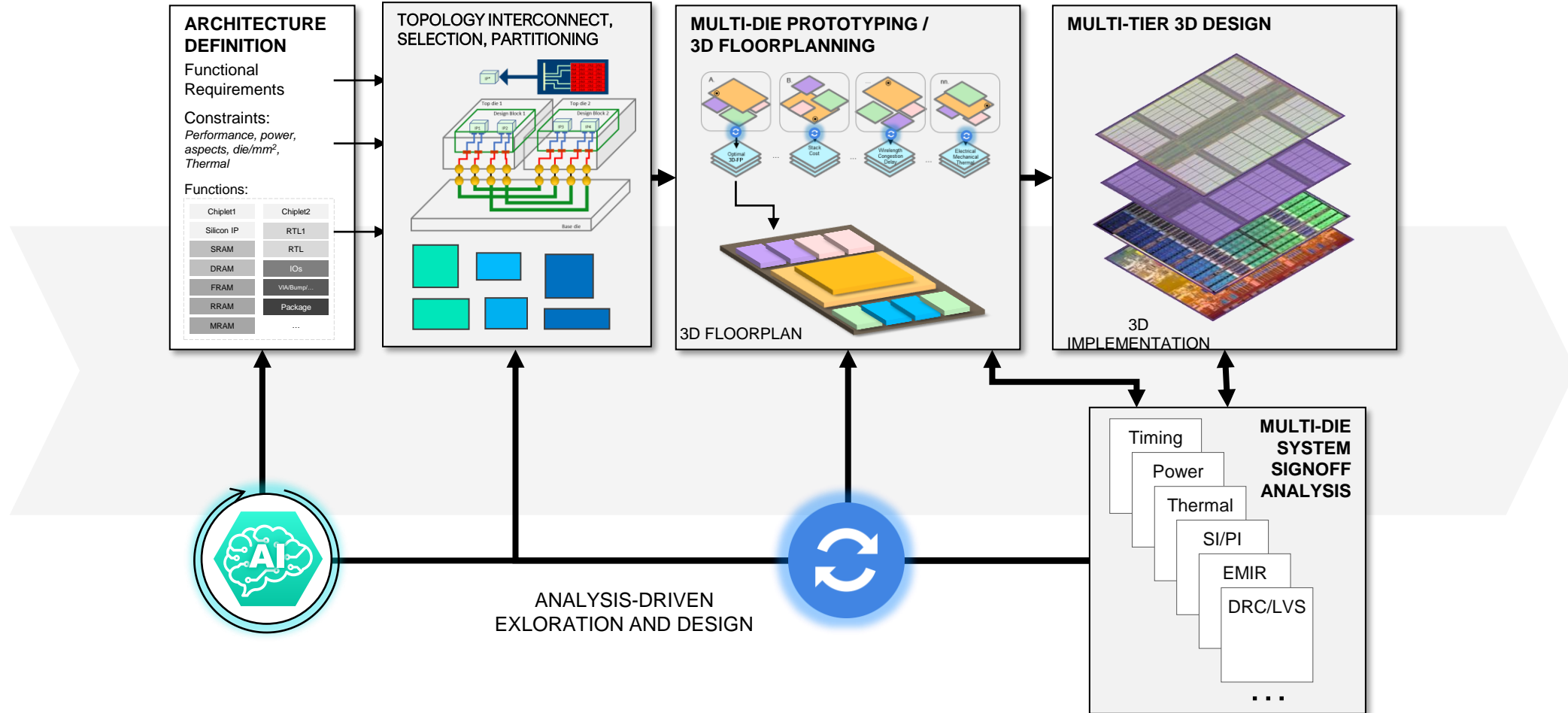
**Thermo-mechanical Analysis bottom of stack**



**Fracture Mechanics**

# Scalable Design Closure

Addressing massive systemic complexity of heterogeneous system

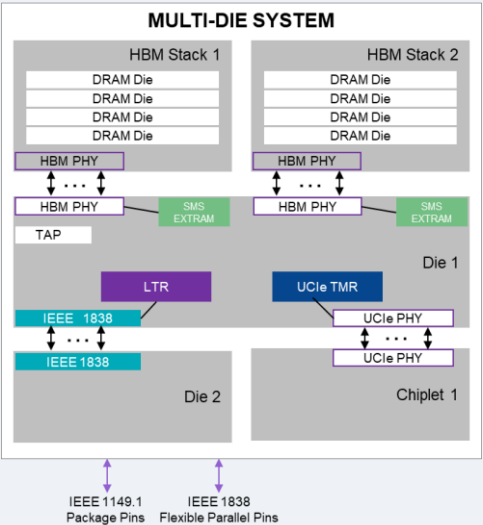


# Manufacturing Ramp and Product Reliability

## Synopsys' TestMAX and the SLM Family of products

### Multi-Die System Test & Repair

Product Quality (KGD, Package, System)

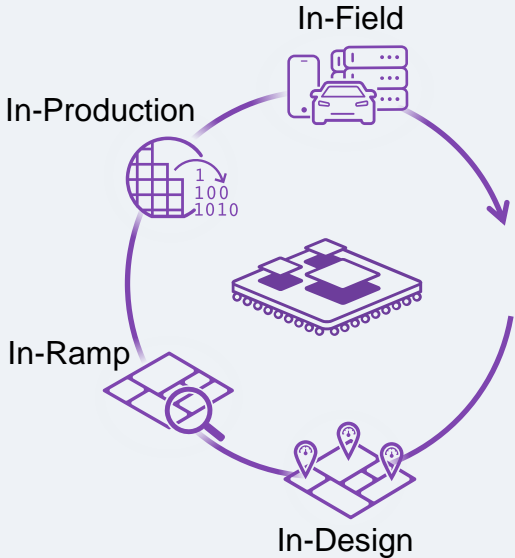


Ensure quality with comprehensive test, debug, repair for multi-die systems

Integrated Test for: Multiple Dies, Memories, Interconnects, and Full-system

### Silicon Lifecycle Management E

Reliability, Yield, Health



Enhance multi-die system operational metrics through environmental, structural, functional monitoring

Solution Comprises: Silicon IP, EDA Software, and Analytics Insights

#### Test Access

IEEE 1838

#### Logic-to-Logic

PHY Monitor, Test & Repair

#### Logic-to-Memory

Ext. Memory BIST & Repair

#### Via / Bump / Interconnect

High volume Lane Test & Repair

#### In-Design

Power/ Performance Optimization

#### In-Ramp

Yield, Failure Analysis

#### In-Production

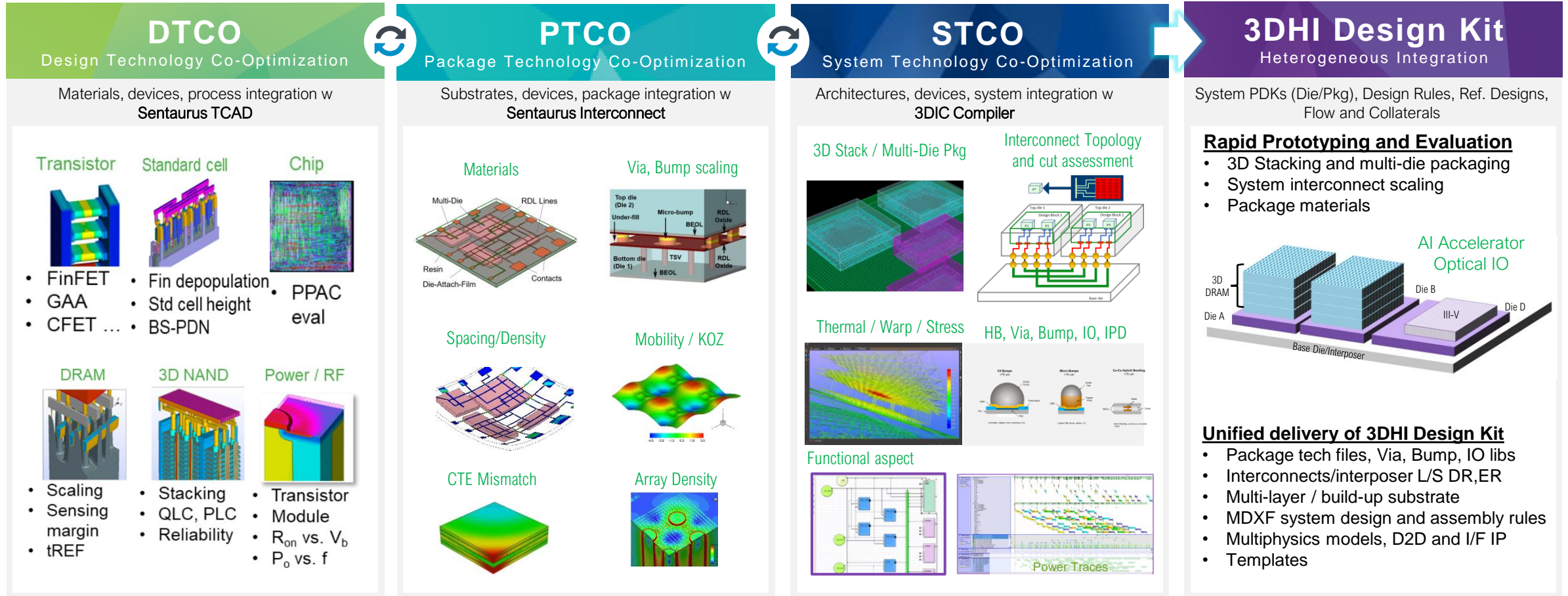
Volume Test, Quality and Traceability

#### In-Field

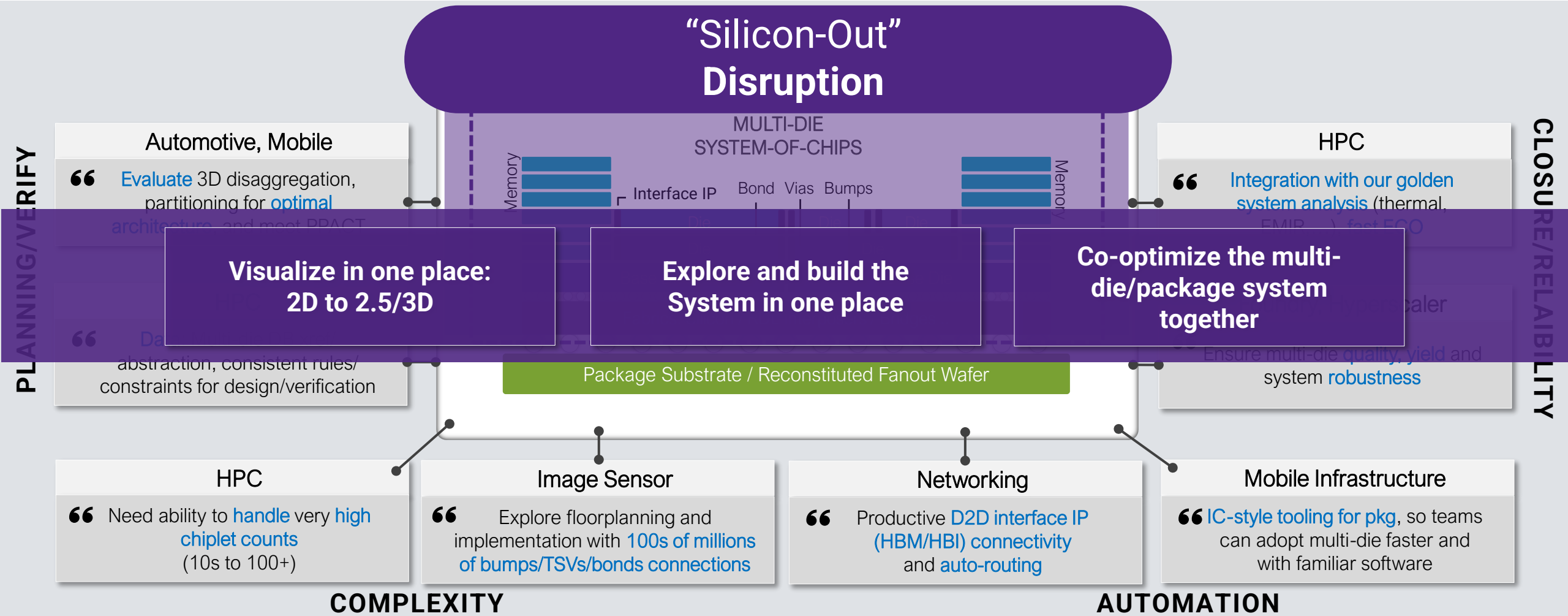
Optimization, Safety, Security, Maintenance

# STCO For Design And Process Optimization

## Design Kits for Multi-Die Systems



# C2W Cu Hybrid Bonding: Opportunities and Challenges



Thank You