

CONTENTS

Preface	ix
Acknowledgements	xiii
Introduction	
Problems of testing VLSI circuits	
A computer aided design verification and test generation system	4
Economics of test	15
References	18
Faults and fault models in VLSI circuits	20
Introduction	20
The effect of scaling on VLSI circuits	21
Permanent faults	23
2.4 Temporary faults	41
2.5 Summary	45
References	46
Simulation techniques for empirical design verification	49
Introduction	49
3.2 Applications of simulation	50
3.3 Simulator design criteria	51
3.4 Gate level simulation	52
3.5 Functional level simulation	63
3.6 Simulating MOS switching circuits	70
3.7 Hardware accelerators for simulation	76
3.8 References	87
4 Fault simulation	86
4 Introduction	86

4.2	Basic techniques for fault simulation	87
4.3	Functional level fault simulation	95
4.4	Fault simulation of MOS circuits	99
4.5	Alternatives to fault simulation	101
4.6	References	105
5	Automatic test pattern generation techniques	107
5.1	Introduction	107
5.2	Test generation for combinational circuits	108
5.3	Test generation in sequential circuits	128
5.4	Test generation techniques at functional level	134
5.5	Test generation in MOS circuits	141
5.6	References	144
6	Design-for-testability techniques	147
6.1	Introduction	147
6.2	<i>Ad hoc</i> or retrofit methods	150
6.3	Structured approaches	151
6.4	Built-in self-test techniques	163
6.5	References	192
7	Hybrid design-for-testability techniques	195
7.1	Introduction	195
7.2	The Highly Integrated Logic Device Observer (HILDO)	198
7.3	LSSD On-Chip Self-Test (LOCST)	200
7.4	Signature Analysis and Scan Path (SASP)	202
7.5	Conclusions	212
7.6	References	217
8	Hardware fault tolerance using redundancy	214
8.1	Introduction	214
8.2	Redundancy techniques	215
8.3	Totally self-checking circuits	225
8.4	VLSI processor designs	245
8.5	Summary	247
8.6	References	247
9	The design of self-checking circuits using information redundancy	250
9.1	Introduction	250
9.2	General theory of the low cost residue codes	251
9.3	Hardware required to implement a residue checking scheme	254

9.4	Applications of residue coding	258
9.5	Properties of the residue codes	263
9.6	The design of a self-checking data path using coding techniques	274
9.7	Data path architecture	274
9.8	Checking hardware	278
9.9	Data path implementation	283
9.10	Testing the mod 3 residue data path	287
9.11	Error-detecting/correcting codes in the design of the data path	289
9.12	Conclusions	296
9.13	References	298
10	Programmable Logic Array and Random Access Memory testing	300
10.1	Introduction to Programmable Logic Array (PLA) testing	300
10.2	PLA structure and fault models	301
10.3	PLA test pattern generation techniques	305
10.4	Structural PLA testability techniques	307
10.5	Concurrent error detection in PLAs	326
10.6	Introduction to random access memory testing	330
10.7	RAM structures and fault models	331
10.8	Test pattern generation algorithms for RAMs	335
10.9	Concurrent error detection in memories	342
10.10	Random testing techniques applied to RAMs	346
10.11	References	347
	The application of knowledge-based systems to the testing of digital circuits	351
	Introduction	351
	Basic components in an expert system	352
	Applications of expert systems in testing	355
	Application of expert systems in design for testability	365
	References	372
	Index	375