

LTC1283

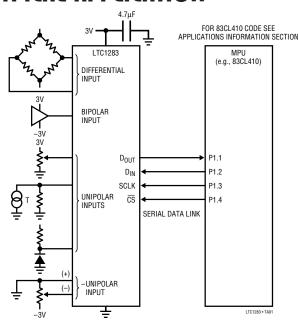
FEATURES

- Single Supply 3.3V or ±3.3V Operation
- Software Programmable Features: Unipolar/Bipolar Conversions 4 Differential/8 Single-Ended Inputs MSB- or LSB-First Data Sequence Variable Data Word Length
- Built-In Sample-and-Hold
- Direct 4-Wire Interface to Most MPU Serial Ports and all MPU Parallel Ports
- 15kHz Maximum Throughput Rate

KEY SPECIFICATIONS

- Minimum Guaranteed Supply Voltage: 3V
- Resolution: 10 Bits
- Offset Error: ±0.5LSB Max
- Linearity Error: ±0.5LSB Max
- Gain Error (LTC1283A): ±1LSB Max
- Conversion Time: 44µs
- Supply Current: 350µA Max, 150µA Typ

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Linearity Plot

3V Single Chip 10-Bit Data Acquisition System

DESCRIPTION

The LTC1283 is a 3V data acquisition component which contains a serial I/O successive approximation A/D converter. It uses LTCMOS[™] switched capacitor technology to perform either 10-bit unipolar, or 9-bit plus sign bipolar A/D conversions. The 8-channel input multiplexer can be configured for either single-ended or differential inputs (or combinations thereof). An on-chip sample-and-hold is included for all single-ended input channels.

The serial I/O is designed to be compatible with industrystandard full-duplex serial interfaces. It allows either MSBor LSB-first data and automatically provides 2's complement output coding in the bipolar mode. The output data word can be programmed for a length of 8-, 10-, 12-, or 16-bit. This allows easy interface to shift registers and a variety of processors.

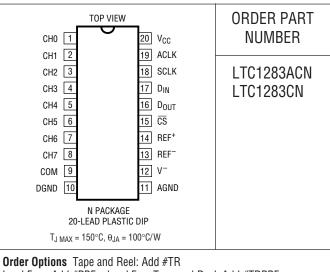
Both the LTC1283A and LTC1283 are specified with offset and linearity errors less than ± 0.5 LSB. The LTC1283A has a gain error limit of ± 1 LSB. The 1283 is specified with a gain error limit of ± 2 LSB for applications where gain is adjustable or less critcial.

ABSOLUTE MAXIMUM RATINGS

(Notes 1 and 2)

Supply Voltage (V _{CC}) to GND or V ⁻ 12V
Voltage
Analog and Reference
Inputs $(V^{-}) - 0.3V$ to $V_{CC} + 0.3V$
Digital Inputs0.3V to 12V
Digital Outputs $-0.3V$ to V _{CC} + 0.3V
Negative Supply Voltage (V–) –6V to GND
Power Dissipation 500mW
Operating Temperature
LTC1283AC, LTC1283C 0°C to 70°C
Storage Temperature Range –65°C to 150°C
Lead Temperature (Soldering, 10 sec) 300°C

PACKAGE/ORDER INFORMATION



Lead Free: Add #PBF Lead Free Tape and Reel: Add #TRPBF Lead Free Part Marking: http://www.linear.com/leadfree/

RECOMMENDED OPERATING CONDITIONS

SYMBOL	PARAMETER	CONDITIONS	LTC1283/L Min typ		UNITS
Vcc	Positive Supply Voltage	V ⁻ = 0V	3.0	3.6	V
V-	Negative Supply Voltage	V _{CC} = 3.3V	-3.6	0	V
fsclk	Shift Clock Frequency	V _{CC} = 3V	0	500	kHz
f _{ACLK}	A/D Clock Frequency	$V_{CC} = 3V$ $T_A \le 25^{\circ}C$ $T_A \le 70^{\circ}C$	0.01 0.05	1.00 1.00	MHz MHz
tcyc	Total Cycle Time	See Operating Sequence	10 SCLK + 48 ACLK		Cycles
thCS	Hold Time, $\overline{\text{CS}}$ Low After Last SCLK \downarrow	V _{CC} = 3V	0		ns
t _{hDI}	Hold Time, D _{IN} After SCLK↑	V _{CC} = 3V	200		ns
t _{suCS}	Setup Time $\overline{\text{CS}}\downarrow$ Before Clocking in First Address Bit (Note 8)	V _{CC} = 3V	2 ACLK Cycles + 1µs		
t _{suDI}	Setup Time, D _{IN} Stable Before SCLK↑	V _{CC} = 3V	400		ns
t whaclk	ACLK High Time	V _{CC} = 3V	250		ns
twlaclk	ACLK Low Time	V _{CC} = 3V	400		ns
twhcs	CS High Time During Conversion	V _{CC} = 3V	44		ACLK Cycles



CONVERTER AND MULTIPLEXER CHARACTERISTICS (Note 3)

				LTC1283A			LTC1283		
PARAMETER	CONDITIONS		MIN	TYP MAX	(MIN	ТҮР	MAX	UNITS
Offset Error	(Note 4)	•		±0.	5			±0.5	LSB
Linearity Error	(Notes 4 and 5)			±0.	5			±0.5	LSB
Gain Error	(Note 4)	•		±1.0)			±2.0	LSB
Minimum Resolution for Which No Missing Codes are Guaranteed		•		10				10	Bits
Reference Input Resistance				10			10		kΩ
Analog and REF Input Range	(Note 6)			(V [−]) − 0.	05V to V	′ _{CC} + 0.0	5V		V
On Channel Leakage Current (Note 7)	On Channel = 3V Off Channel = 0V	•		1				1	μΑ
	On Channel = 0V Off Channel = 3V	•		-1				-1	μΑ
Off Channel Leakage Current (Note 7)	On Channel = 3V Off Channel = 0V	•		-1				-1	μΑ
	On Channel = 0V Off Channel = 3V	•		1				1	μΑ

AC CHARACTERISTICS (Note 3)

				LTC	1283/LTC1	283A	
SYMBOL	PARAMETER	CONDITIONS		MIN	TYP	MAX	UNITS
t _{ACC}	Delay Time From $\overline{\text{CS}}\downarrow$ to D _{OUT} Data Valid	(Note 8)			2		ACLK Cycles
t _{SMPL}	Analog Input Sample Time	See Operating Sequence			5		SCLK Cycles
t _{CONV}	Conversion Time	See Operating Sequence			44		ACLK Cycles
t _{dDO}	Delay Time, SCLK \downarrow to D _{OUT} Data Valid	See Test Circuts	•		400	900	ns
t _{dis}	Delay Time, CS↑ to D _{OUT} Hi-Z	See Test Circuits	•		240	500	ns
t _{en}	Delay Time, 2nd CLK \downarrow to D _{OUT} Enabled	See Test Circuits	•		300	800	ns
t _{hDO}	Time Output Data Remains Valid After SCLK \downarrow				75		ns
t _f	D _{OUT} Fall Time	See Test Circuits	•		90	300	ns
t _r	D _{OUT} Rise Time	See Test Circuits	•		80	300	ns
CIN	Input Capacitance	Analog Inputs On Channel			65		pF
		Off Channel			5		pF
		Digital Inputs			5		pF

DIGITAL AND DC ELECTRICAL CHARACTERISTICS (Note 3)

				LTC	1283/LTC1	283A	
SYMBOL	PARAMETER	CONDITIONS		MIN	ТҮР	MAX	UNITS
V _{IH}	High Level Input Voltage	V _{CC} = 3.6V	•	1.7			V
V _{IL}	Low Level Input Voltage	$V_{CC} = 3V$	•			0.45	V
I _{IH}	High Level Input Current	$V_{IN} = V_{CC}$	•			2.5	μA
IIL	Low Level Input Current	$V_{IN} = 0V$	•			-2.5	μΑ
V _{OH}	High Level Output Voltage	$V_{CC} = 3V, I_0 = -20\mu A$ $I_0 = -200\mu A$	•	2.6 2.0	2.8		V V
V _{OL}	Low Level Output Voltage	$V_{CC} = 3V, I_0 = 20\mu A$ $I_0 = 400\mu A$	•		0.05 0.10	0.30	V V



DIGITAL AND DC ELECTRICAL CHARACTERISTICS The \bullet denotes the specifications which apply over the full operating temperature range, otherwise specifications are at T_A = 25°C. (Note 3)

				LTC	1283/LTC1	283A	
SYMBOL	PARAMETER	CONDITIONS		MIN	ТҮР	MAX	UNITS
I _{OZ}	Hi-Z Output Leakage	V _{OUT} = V _{CC} , CS High	•			3	μΑ
		$V_{OUT} = 0V, \overline{CS}$ High	•			-3	μΑ
ISOURCE	Output Source Current	V _{OUT} = 0V			-4.5		mA
I _{SINK}	Output Sink Current	V _{OUT} = V _{CC}			4.5		mA
I _{CC}	Positive Supply Current	CS High, REF+ Open	•		150	350	μΑ
I _{REF}	Reference Current	V _{REF} = 2.5V	•		250	500	μΑ
-	Negative Supply Current	$\overline{\text{CS}}$ High, V ⁻ = -3V	•		-1	-50	μΑ

Note 1: Stresses beyond those listed under Absolute Maximum Ratings may cause permanent damage to the device. Exposure to any Absolute Maximum Rating condition for extended periods may affect device reliability and lifetime.

Note 2: All voltage values are with respect to ground with DGND, AGND and REF⁻ wired together (unless otherwise noted).

Note 3: $V_{CC} = 3V$, $V_{REF}^+ = 2.5V$, $V_{REF}^- = 0V$, $V^- = 0V$ for unipolar mode and -3V for bipolar mode, ACLK = 1MHz, SCLK = 0.25MHz unless otherwise specified.

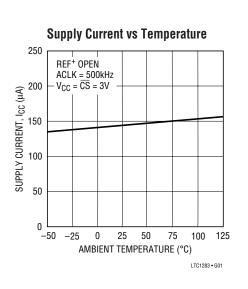
Note 4: These specifications apply for both unipolar and bipolar modes. In bipolar mode, one LSB is equal to the bipolar input span (2VRFF) divided by 1024. For example, when $V_{\text{REF}} = 2.5V$, 1LSB (bipolar) = 2(2.5V)/1024 = 4.88mV.

Note 5: Linearity error is the deviation from ideal of the slope between the two end points of the transfer curve.

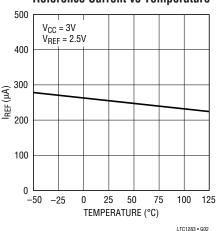
Note 6: Two on-chip diodes are tied to each reference and analog input which will conduct for reference or analog input voltages one diode drop below V⁻ or one diode drop above V_{CC}. Be careful during testing at low V_{CC} levels, as high level reference or analog inputs can cause this input diode to conduct, especially at elevated temperatures, and cause errors for inputs near full scale. This spec allows 50mV forward bias of either diode. This means that as long as the reference or analog input does not exceed the supply voltage by more than 50mV, the output code will be correct.

Note 7: Channel leakage current is measured after the channel selection. Note 8: To minimize errors caused by noise at the chip select input, the internal circuitry waits for two ACLK falling edges after a chip select falling edge is detected before responding to control input signals. Therefore, no attempt should be made to clock an address in or data out until the minimum chip select setup time has elapsed.

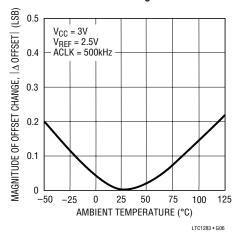
TYPICAL PERFORMANCE CHARACTERISTICS



Reference Current vs Temperature

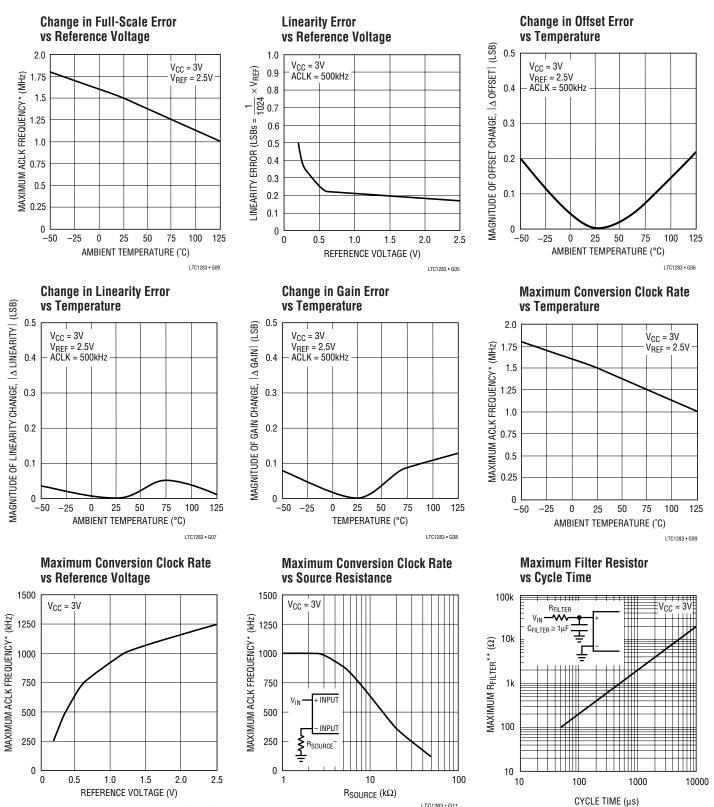


Unadjusted Offset Error vs Reference Voltage





TYPICAL PERFORMANCE CHARACTERISTICS



LTC1283 • G10

*Maximum ACLK frequency represents the ACLK frequency at which a 0.1LSB shift in the error at any code transition from its 100kHz value is first detected.

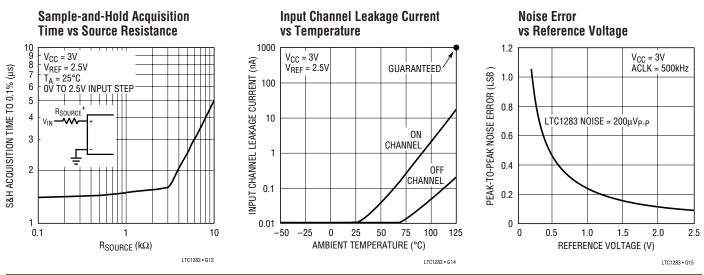
**Maximum R_{FILTER} represents the filter resistor value at which a 0.1LSB change in full-scale error from its value at R_{FILTER} = 0 is first detected.

1283fb

LTC1283 • G12



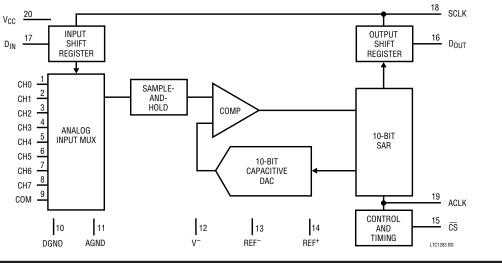
TYPICAL PERFORMANCE CHARACTERISTICS



PIN FUNCTIONS

#	PIN	FUNCTION	DESCRIPTION
1-8	CH0-CH7	Analog Inputs	The analog inputs must be free of noise with respect to AGND.
9	СОМ	Common	The common pin defines the zero reference point for all single-ended inputs. It must be free of noise and is usually tied to the analog ground plane.
10	DGND	Digital Ground	This is the ground for the internal logic. Tie to the ground plane.
11	AGND	Analog Ground	AGND should be tied directly to the analog ground plane.
12	V-	Negative Supply	Tie V ⁻ to most negative potential in the circuit. (Ground in single supply applications.)
13, 14	REF ⁻ , REF ⁺	Reference Inputs	The reference inputs must be kept free of noise with respect to AGND.
15	CS	Chip Select Input	A logic low on this input enables data transfer.
16	D _{OUT}	Digital Data Output	The A/D conversion result is shifted out of this output.
17	DIN	Data Input	The A/D configuration word is shifted into this input.
18	SCLK	Shift Clock	This clock synchronizes the serial data transfer.
19	ACLK	A/D Conversion Clock	This clock controls the A/D conversion process.
20	V _{CC}	Positive Supply	This supply must be kept free of noise and ripple by bypassing directly to the analog ground plane.

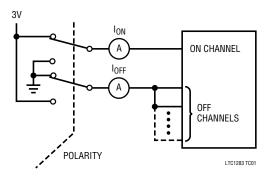
BLOCK DIAGRAM



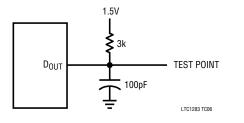


TEST CIRCUITS

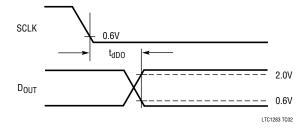
On and Off Channel Leakage Current



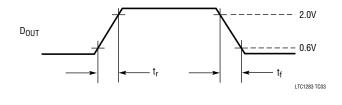
Load Circuit for $t_{dDO},\,t_r,\,t_f$ and t_{en}



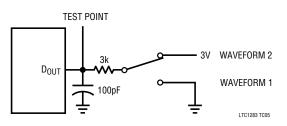
Voltage Waveforms for D_{OUT} Delay Time, t_{dDO}



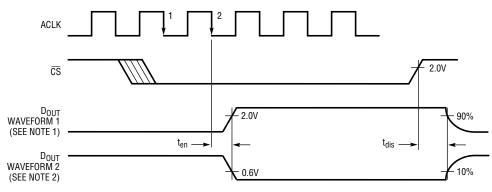
Voltage Waveform for $D_{OUT}\,Rise$ and Fall Times, t_r and t_f



Load Circuit for t_{dis}



Voltage Waveforms for t_{en} and t_{dis}



NOTE 1: WAVEFORM 1 IS FOR AN OUTPUT WITH INTERNAL CONDITIONS SUCH THAT THE OUTPUT IS HIGH UNLESS DISABLED BY THE OUTPUT CONTROL.

NOTE 2: WAVEFORM 2 IS FOR AN OUTPUT WITH INTERNAL CONDITIONS SUCH THAT THE OUTPUT IS LOW UNLESS DISABLED BY THE OUTPUT CONTROL.

TECHNOLOGY

LTC1283 TC04

The LTC1283 is a 3V data acquisition component which contains the following functional blocks:

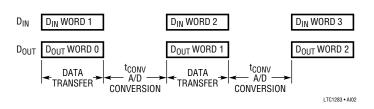
- 1. 10-bit successive approximation capacitive A/D converter
- 2. Analog multiplexer (MUX)
- 3. Sample-and-hold (S&H)
- 4. Synchronous, full duplex serial interface
- 5. Control and timing logic

DIGITAL CONSIDERATIONS

1. Serial Interface

The LTC1283 communicates with microprocessors and other external circuitry via a synchronous, full duplex, 4wire serial interface (see Operating Sequence). The shift clock (SCLK) synchronizes the data transfer with each bit being transmitted on the falling SCLK edge and captured on the rising SCLK edge in both transmitting and receiving systems. The data is transmitted and received simultaneously (full duplex).

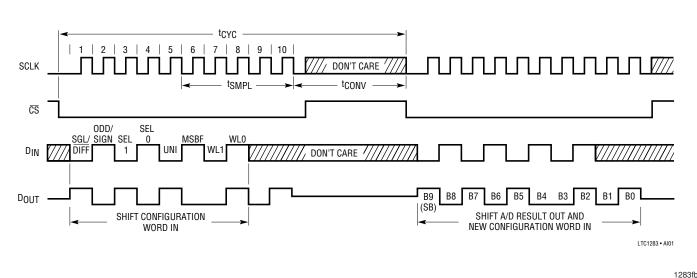
Data transfer is initiated by a falling chip select (\overline{CS}) signal. After the falling \overline{CS} is recognized, an 8-bit input word is shifted into the D_{IN} input which configures the LTC1283 for the next conversion. Simultaneously, the result of the previous conversion is output on the D_{OUT} line. At the end of the data exchange the requested conversion begins and \overline{CS} should be brought high. After t_{CONV}, the conversion is complete and the results will be available on the next data transfer cycle. As shown below, the result of a conversion is delayed by one \overline{CS} cycle from the input word requesting it.



2. Input Data Word

The LTC1283 8-bit input data word is clocked into the D_{IN} input on the first eight rising SCLK edges after chip select is recognized. Further inputs on the D_{IN} pin are then ignored until the next CS cycle. The eight bits of the input word are defined as follows:

DATA INPU	T (D _{IN}) WO	RD:		UNIPOLAR/ BIPOLAR			
SGL/ DIFF	ODD/ SIGN	SELECT 1	SELECT 0	UNI MSBF		WL1	WL0
	MUX AE	DDRESS			MSB-FIRST LSB-FIRST		LTC1283 • Al03



Operating Sequence (Example: Differential Inputs (CH3-CH2), Bipolar, MSB-First and 10-Bit Word Length)

Multiplexer (MUX) Address

The first four bits of the input word assign the MUX configuration for the requested conversion. For a given channel selection, the converter will measure the voltage between the two channels indicted by the + and - signs in the selected row of Table 1. Note that in differential mode

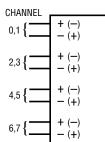
 $(SGL/\overline{DIFF} = 0)$ measurements are limited to four adjacent input pairs with either polarity. In single-ended mode, all input channels are measured with respect to COM. Figure 1 shows some examples of multiplexer assignments.

Table 1. Multiplexer Channel Selection

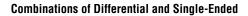
М	UX ADDF	RESS		DIF	FERE	NTIA	L CH/	ANNE	L SE	LECT	ION	M	UX ADD	RESS		SI	NGLE	E-EN	DED	CHA	NNE	L SEI	LECT	TION
SGL/	ODD/	SEL	ECT									SGL/	ODD/	SELE	CT									
DIFF	SIGN	1	0	0	1	2	3	4	5	6	7	DIFF	SIGN	1	0	0	1	2	3	4	5	6	7	COM
0	0	0	0	+	-							1	0	0	0	+								-
0	0	0	1			+	-					1	0	0	1			+						-
0	0	1	0					+	-			1	0	1	0					+				_
0	0	1	1							+	_	1	0	1	1							+		_
0	1	0	0	-	+							1	1	0	0		+							-
0	1	0	1			-	+					1	1	0	1				+					_
0	1	1	0					-	+			1	1	1	0						+			-
0	1	1	1							-	+	1	1	1	1								+	-

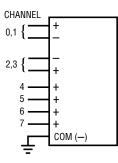
4 Differential

8 Single-Ended









Changing the MUX Assignment "On the Fly"

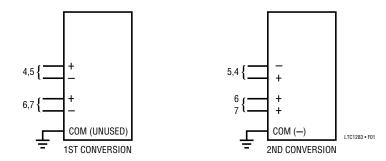


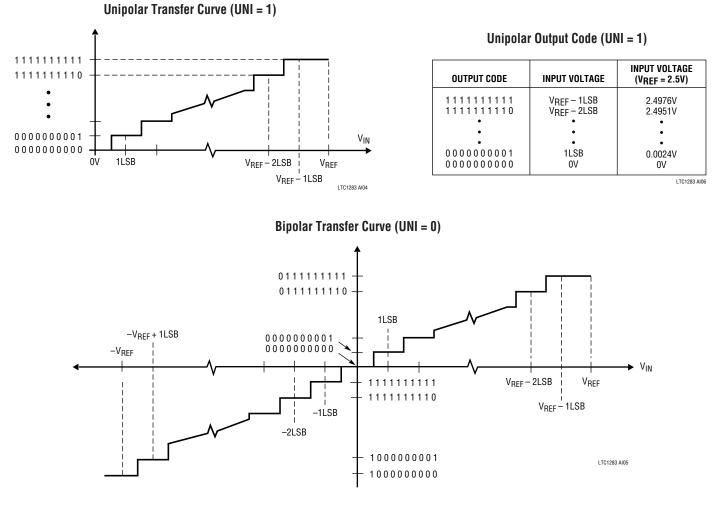
Figure 1. Examples of Multiplexer Options on the LTC1283



Unipolar/Bipolar (UNI)

The fifth input bit (UNI) determines whether the conversion will be unipolar or bipolar. When UNI is a logical one, a unipolar conversion will be performed on the selected

input voltage. When UNI is a logical zero, a bipolar conversion will result. The input span and code assignment for each conversion type are shown in the figures below.



Bipolar Output Code (UNI = 0)

OUTPUT CODE INPUT VOLTAGE						
VREF – 1LSB VREF – 2LSB	2.4951V 2.4902V					
•	•					
• 1LSB 0V -1LSB -2LSB	• 0.0049V 0V -0.0049V -0.0098V					
•	•					
•						
-(V _{REF}) + 1LSB -(V _{REF})	-2.4951V -2.5000V					
	VREF - 1LSB VREF - 2LSB 1LSB 0V -1LSB -2LSB -(VREF) + 1LSB					

vulfAGE F = 2.5V) 4951V 4902V ∙

MSB-First/LSB-First Format (MSBF)

The output data of the LTC1283 is programmed for MSBfirst or LSB-first sequence using the MSBF bit. For MSBfirst output data the input word clocked to the LTC1283 should always contain a logical one in the sixth bit location (MSBF bit). Likewise for LSB-first output data, the input word clocked to the LTC1283 should always contain a zero in the MSBF bit location. The MSBF bit in a given D_{IN} word will control the order of the next D_{OUT} word. The MSBF bit affects only the order of the output data word. The order of the input word is unaffected by this bit.

MSBF	OUTPUT FORMAT
0	LSB-First
1	MSB-First
	LTC1283 AI08

Word Length (WL1, WL0)

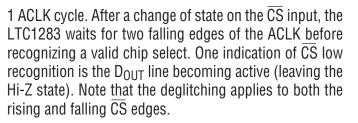
The last two bits of the input word (WL1 and WL0) program the output data word length of the LTC1283. Word lengths of 8-, 10-, 12- or 16-bit can be selected according to the following table. The WL1 and WL0 bits in a given D_{IN} word control the length of the present, not the next, D_{OUT} word. **WL1 and WL2 are never "don't cares"** and must be set for the correct D_{OUT} word length even when a "dummy" D_{IN} word is sent. On any transfer cycle, the word length should be made equal to the number of SCLK cycles sent by the MPU.

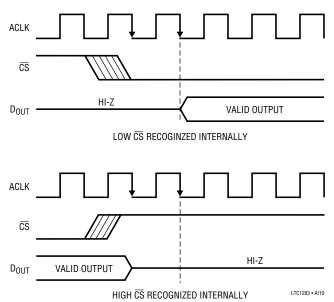
OUTPUT WORD LENGTH	WLO	WL1
8 Bits	0	0
10 Bits	1	0
12 Bits	0	1
16 Bits	1	1

Figure 2 shows how the data output (D_{OUT}) timing can be controlled with word length selection and MSB/LSB-first format selection.

3. Deglitcher

A deglitching circuit has been added to the chip select input of the LTC1283 to minimize the effects of errors caused by noise on that input. This circuit ignores changes in state on the $\overline{\text{CS}}$ input that are shorter in duration than





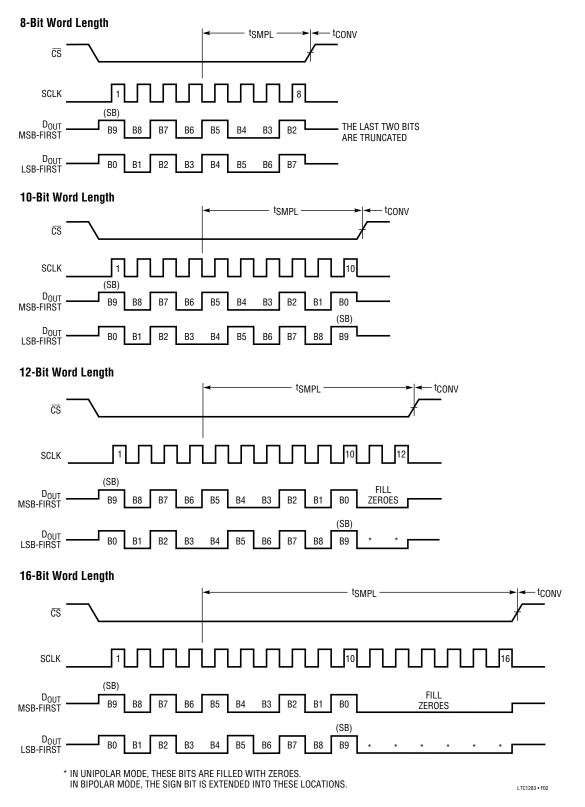
4. $\overline{\text{CS}}$ Low During Conversion

In the normal mode of operation, $\overline{\text{CS}}$ is brought high during the conversion time (see Figure 3). The serial port ignores any SCLK activity while $\overline{\text{CS}}$ is high. The LTC1283 will also operate with $\overline{\text{CS}}$ low during the conversion. In this mode, SCLK must remain low during the conversion as shown in Figure 4. After the conversion is complete, the D_{OUT} line will become active with the first output bit. Then the data transfer can begin as normal.

5. Microprocessor Interfaces

The LTC1283 can interface directly (without external hardware) to most popular microprocessor (MPU) synchronous serial formats (see Table 2). If an MPU without a serial interface is used, then four of the MPU's parallel port lines can be programmed to form the serial link to the LTC1283. Included here are three serial interface examples and one example showing a parallel port programmed to form the serial interface.









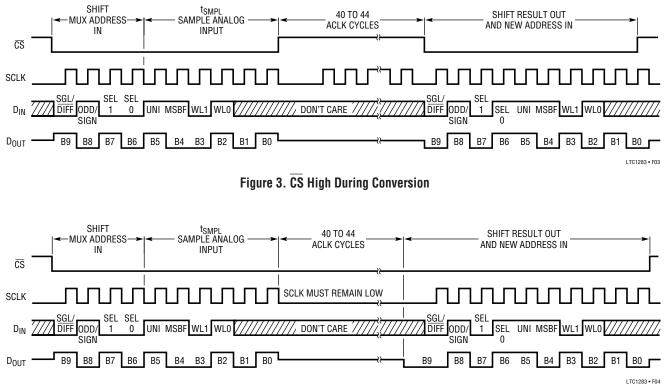


Figure 4. \overline{CS} Low During Conversion

Table 2. 3V Microprocessor with Hardware Serial Interfaces Compatible with the LTC1283*

PART NUMBER	TYPE OF INTERFACE
Motorola MC68HC11 MC68HC05	SPI SPI
RCA CDP68HC05	SPI
National Semiconductor COP800 Family HPC16000 Family	MICROWIRE/PLUS [†] MICROWIRE/PLUS [†]
Texas Instruments TMS70C02 TMS70C42	Serial Port Serial Port

*Contact factory for interface information for processors not on this list [†]MICROWIRE/PLUS is a trademark of National Semiconductor Corp.

Serial Port Microprocessors

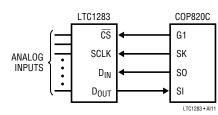
Most synchronous serial formats contain a shift clock (SCLK) and two data lines, one for transmitting and one for receiving. In most cases data bits are transmitted on the falling edge of the clock (SCLK) and captured on the rising edge. However, serial port formats vary among MPU manufacturers as to the smallest number of bits that can be sent in one group (e.g., 4-bit, 8-bit or 16-bit transfers). They also vary as to the order in which the bits are transmitted (LSB- or MSB-first). The following examples show how the LTC1283 accommodates these differences.

National MICROWIRE (COP820C)

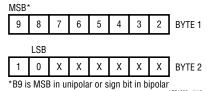
The COP820C transfers data MSB-first and in 8-bit increments. This is easily accommodated by setting the LTC1283 to MSB-first format and 10-bit word length. The data output word is then received by the COP820C in one 8-bit block and one 2-bit block.



Hardware and Software Interface to National Semiconductor COP820C Processor



D_{OUT} from LTC1283 stored in COP820C RAM



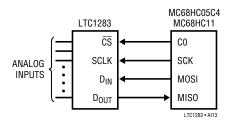
LTC1283 • Al12

MNEMONIC	COMMENTS	MNEMONIC	COMMENTS
LD (F0)←0D	LOAD 0D INTO F0 (D _{IN})	$X(A) \leftarrow \rightarrow (E9)$	LOAD D _{OUT} INTO ACC
LD (D5)←32	CONFIGURE PORT G	SBIT 2	TRANSFER CONTINUES
LD (EE) ←8	CONFIGURE CONTROL REG.	X (A)←→(F3)	LOAD D _{OUT} IN ADDR F3
LD (B)←D4	PORT G DATA REG. INTO B	RBIT 2	STOP TRANSFER
LD (A) ← (F0)	LOAD D _{IN} INTO ACC	LD (B)←D4	PUT PORT G ADDR IN B
RBIT 1	G1 RESET (CS GOES LOW)	SBIT 1	G1 SET (CS GOES HIGH)
X (A)←→(E9)	LOAD DIN INTO SHIFT REG.	X (A)←→(E9)	LOAD D _{OUT} INTO ACC
LD (B)←EF	LOAD PSW REG. ADDR IN B	RC	CLEAR CARRY
SBIT 2	TRANSFER BEGINS	RRCA	SHIFT RIGHT THRU CARRY
\uparrow		RRCA	SHIFT RIGHT THRU CARRY
NOP	15 NOPs FOR TIMING	RRCA	SHIFT RIGHT THRU CARRY
\downarrow		$X (A) \leftarrow \rightarrow (F4)$	LOAD D _{OUT} IN ADDR F4

Motorola SPI (MC68HC05C4, MC68HC11)

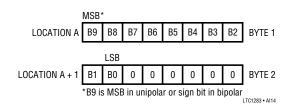
The MC68HC05C4 and MC68HC11 transfer data MSBfirst and in 8-bit increments. Programming the LTC1283 for MSB-first format and 16-bit word length allows the 10-

Hardware and Software Interface to Motorola MC68HC05C4 and MC68HC11 Processors



bit data output to be received by the MPU as two 8-bit bytes with the final 6 unused bits filled with zeroes by the LTC1283.

D_{OUT} from LTC1283 stored in MC68HC05C4 or MC68HC11 RAM



MNEMONIC	COMMENTS	MNEMONIC	COMMENTS
BCLR n	CO IS CLEARED (CS GOES LOW)	STA	START NEXT SPI CYCLE
LDA	LOAD DIN FOR LTC1283 INTO ACC	↑	
STA ↑	LOAD $D_{IN}^{}$ FROM ACC TO SPI DATA REG. START SCK	NOP ↓	6 NOPs FOR TIMING
NOP ↓	8 NOPS FOR TIMING	BSET n LDA	CO IS SET (CS GOES HIGH) LOAD CONTENTS OF SPI STATUS REG. INTO ACC
LDA	LOAD CONTENTS OF SPI STATUS REG. INTO ACC	LDA	LOAD LTC1283 DOUT FROM SPI DATA REG.
LDA	LOAD LTC1283 D _{OUT} FROM SPI DATA REG.		INT ACC (BYTE 2)
	INTO ACC (BYTE 1)	STA	LOAD LTC1283 INTO RAM (LOCATION A +1)
STA	LOAD LTC1283 DOUT INTO RAM (LOCATION A)		

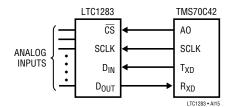




Texas Instruments TMS70C42

The TMS70C42 transfers serial data in 8-bit increments, LSB-first. To accommodate this, the LTC1283 is programmed for 16-bit word length and LSB-first format. The

Hardware and Software Interface to TI TMS70C42 Processor



10-bit output data is received by the processor as two 8-bit bytes, LSB-first. The LTC1283 fills the final 6 unused bits (after the MSB) with zeroes.

D_{OUT} from LTC1283 stored in TMS70C42 RAM

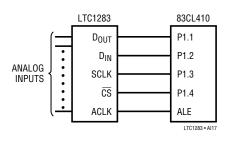


LABEL	MNEMONIC	DESCRIPTION	LABEL	MNEMONIC	DESCRIPTION
START	DINT MOVP % > 2A, P0 MOVP % > 02, P16 MOV % > 60, B LDSP MOVP % > DF, P5 MOVP % > 08, P6	DISABLES ALL INTERRUPTS DISABLE INTERRUPT FLAGS DISABLE INTERRUPT FLAGS ADDRESS OF STACK PUT ADDRESS INTO POINTER CONFIGURE PORT A ENABLE TX BY SETTING B3 = 1	WAIT1	MOVP % > 40, P24 MOVP % > 17, P21 MOVP % > 00, P24 MOVP % > 16, P21 MOV % > 02, A DJNZ A, WAIT1	SCLK OFF (TIMER 3 DISABLED) ENABLE SERIAL PORT SCLK ON (TRANSFER BEGINS) TXEN GOES LOW LOAD COUNTER LOOP WHILE SHIFT OCCURS
	MOVP % > 40, P21 MOVP % > 0C, P20 MOVP % > 00, P24 MOVP % > 00, P21 MOVP % > 00, P23	RESET THE SERIAL PORT CONFIGURE THE SERIAL PORT TURN START BIT OFF ENABLE THE SERIAL PORT SET SCLK RATE (TIMER 3)		NOP MOVP P25, B MOVP A, P26 MOVP % > 40, P24 MOVP % > 17, P21 MOVP % > 00, P24	DELAY PUT D _{OUT} IN B LOAD TXBUF SCLK OFF (TIMER 3 DISABLE) ENABLE SERIAL PORT SCLK ON (TRANSFER BEGINS)
LOOP	MOVP % > C0, P24 MOV % > DF, A CALL SXTNBIT MOV B, R5	START TIMER LOAD D _{IN} WORD IN A ROUTINE THAT SHIFTS DATA PUT FIRST 8 LSBs IN R5	WAIT2	MOVP % > 16, P21 MOV % > 02, A DJNZ A, WAIT2 NOP	TXEN GOES LOW LOAD COUNTER LOOP WHILE SHIFT OCCURS DELAY
SXTNBIT	MOV A, R6 ANDP % > FE, P4 MOVP A, P26	PUT MSBs IN <u>R6</u> A0 CLEARED (CS GOES LOW) PUT D _{IN} INTO TXBUF		MOVP P25, A ORP % > 01, P4 RETS	PUT D _{OUT} IN A AO SET (CS GOES HIGH) RETURN TO MAIN PROGRAM

Parallel Port Microprocessors

When interfacing the LTC1283 to an MPU which has a parallel port, the serial signals are created on the port with software. Three MPU port lines are programmed to create the \overline{CS} , SCLK and D_{IN} signals for the LTC1283. A fourth port line reads the D_{OUT} line. An example is made of the Signetics 83CL410.

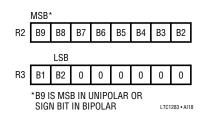
Hardware and Software Interface to Signetics 83CL410 Processor



Signetics 83CL410

To interface to the 83CL410, (a 3V version of the 80C51) the LTC1283 is programmed for MSB-first format and 10bit word length. The 83CL410 generates \overline{CS} , SCLK and D_{IN} on three port lines and reads D_{OUT} on the fourth.

D_{OUT} from LTC1283 stored in 83CL410 RAM



83CL410 Code

MNEMONIC		DESCRIPTION	MNEMONIC	;	DESCRIPTION
	MOV P1, #02H	INITIALIZE PORT 1 (BIT 1 IS MADE AN		MOV C, P1.1	READ DATA BIT INTO CARRY
		INPUT)		CLR A	CLEAR ACC
	CLR P1.3	SCLK GOES LOW		RLC A	ROTATE DATA BIT INTO ACC
	SETB P1.4	CS GOES LOW		SETB P1.3	SCLK GOES HIGH
CONTINUE:	MOV A, #0DH	DIN WORD FOR THE LTC1283 IS PLACED		CLR P1.3	SCLK GOES LOW
	,	INACC		MOV C, P1.1	READ DATA BIT IN CARRY
	CLR P1.4	CS GOES LOW		RRC A	ROTATE RIGHT INTO ACC
	MOV R4, #08	LOAD COUNTER		RRC A	ROTATE RIGHT INTO ACC
	NOP	DELAY FOR DEGLITCHER		MOV R3, A	STORE LSBs IN R3
LOOP:	MOV C, P1.1	READ DATA BIT INTO CARRY		SETB P1.3	SCLK GOES HIGH
	RLC A	ROTATE DATA BIT INTO ACC		CLR P1.3	SCLK GOES LOW
	MOV P1.2, C	OUTPUT DIN BIT TO LTC1283		SETB P1.4	CS GOES HIGH
	SETB P1.3	SCLK GOES HIGH		MOV R5, #07H	LOAD COUNTER
	CLR P1.3	SCLK GOES LOW	DELAY:	DJNZ R5, DELAY	DELAY FOR LTC1283 TO PERFORM
	DJNZ R4, LOOP	NEXT BIT		,	CONVERSION
	MOV R2, A	STORE MSBs IN R2		AJMP CONTINUE	REPEAT PROGRAM

6. Sharing the Serial Interface

The LTC1283 can share the same 3-wire serial interface with other peripheral components or other LTC1283s (see Figure 5). In this case, the \overline{CS} signals decide which LTC1283 is being addressed by the MPU.

ANALOG CONSIDERATIONS

1. Grounding

The LTC1283 should be used with an analog ground plane and single point grounding techniques.

Pin 11 (AGND) should be tied directly to this ground plane.

Pin 10 (DGND) can also be tied directly to this ground plane because minimal digital noise is generated within the chip itself.

Pin 20 (V_{CC}) should be bypassed to the ground plane with a 4.7 μF tantalum with leads as short as possible. Pin 12

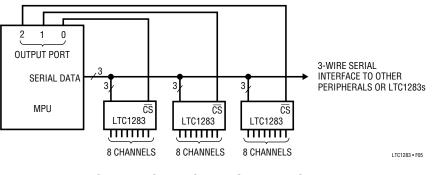
 (V^-) should be bypassed with a $0.1\mu F$ ceramic disk. For single supply applications, V^- can be tied to the ground plane.

It is also recommended that pin 13 (REF⁻) and pin 9 (COM) be tied directly to the ground plane. All analog inputs should be referenced directly to the single point ground. Digital inputs and outputs should be shielded from and/or routed away from the reference and analog circuitry.

Figure 6 shows an example of an ideal ground plane design for a two-sided board. Of course this much ground plane will not always be possible, but users should strive to get as close to this ideal as possible.

2. Bypassing

For good performance, V_{CC} must be free of noise and ripple. Any changes in the V_{CC} voltage with respect to analog ground during a conversion cycle can induce errors







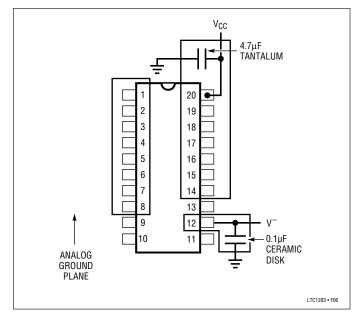


Figure 6. Example Ground Plane for the LTC1283

or noise in the output code. V_{CC} noise and ripple can be kept below 1mV by bypassing the V_{CC} pin directly to the analog ground plane with a $4.7\mu F$ tantalum with leads as short as possible. Figures 7 and 8 show the effects of good and poor V_{CC} bypassing.

3. Analog Inputs

Because of the capacitive redistribution A/D conversion techniques used, the analog inputs of the LTC1283 have capacitive switching input current spikes. These current spikes settle quickly and do not cause a problem.

However, if large source resistances are used or if slow settling op amps drive the inputs, care must be taken to insure that the transients caused by the current spikes settle completely before the conversion begins.

Source Resistance

The analog inputs of the LTC1283 look like 65pF capacitor (C_{IN}) in series with a 500 Ω resistor (R_{ON}) as shown in Figure 9. C_{IN} gets switched between the selected "+" and "-" inputs once during each conversion cycle. Large external source resistors and capacitances will slow the settling of the inputs. It is important that the overall RC time constants be short enough to allow the analog inputs to completely settle within the allowed time.

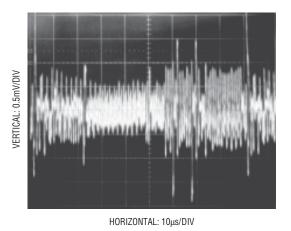
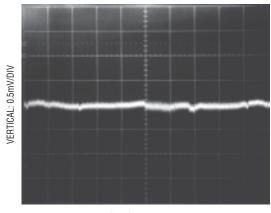


Figure 7. Poor V_{CC} Bypassing. Noise and Ripple can Cause A/D Errors



HORIZONTAL: 10µs/DIV



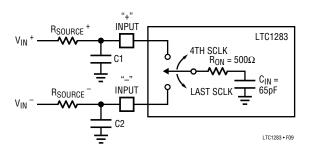


Figure 9. Analog Input Equivalent Circuit



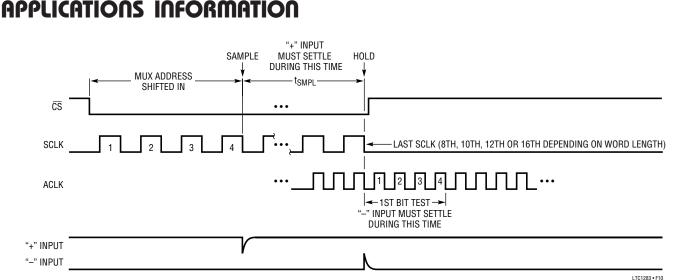


Figure 10. "+" and "-" Input Settling Windows

"+" Input Settling

This input capacitor is switched onto the "+" input during the sample phase (t_{SMPL} , see Figure 10). The sample phase starts at the 4th SCLK cycle and lasts until the falling edge of the last SCLK (the 8th, 10th, 12th or 16th SCLK cycle depending on the selected word length). The voltage on the "+" input must settle completely within this sample time. Minimizing R_{SOURCE}^+ and C1 will improve the input settling time. If large "+" input source resistance must be used, the sample time can be increased by using a slower SCLK frequency or selecting a longer word length. With the minimum possible sample time of 8µs, $R_{SOURCE}^+ < 2k$ and C1 < 20pF will provide adequate settling.

"-" Input Settling

At the end of the sample phase the input capacitor switches to the "-" input and the conversion starts (see Figure 10). During the conversion, the "+" input voltage is effectively "held" by the sample-and-hold and will not affect the conversion result. However, it is critical that the "-" input voltage be free of noise and settle completely during the first four ACLK cycles of the conversion time. Minimizing R_{SOURCE}^{-} and C2 will improve settling time. If large "-" input source resistance must be used, the time allowed for settling can be extended by using a slower ACLK frequency. At the maximum ACLK rate of 1MHz, R_{SOURCE}^{-}
 1k and C2 < 20pF will provide adequate settling.

Input Op Amps

When driving the analog inputs with an op amp it is important that the op amp settle within the allowed time (see Figure 10). Again, the "+" and "-" input sampling times can be extended as described above to accommodate slower op amps. Most op amps including the LT1006 and LT1013 single supply op amps can be made to settle well even with the minimum settling windows of 8µs ("+" input) and 4µs ("-" input) which occur at the maximum clock rates (ACLK = 1MHz and SCLK = 0.5MHz). Figures 11 and 12 show examples of adequate and poor op amp settling.

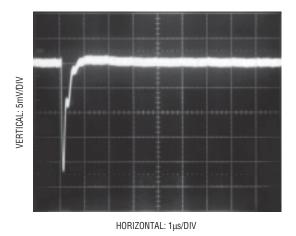


Figure 11. Adequate Settling of Op Amp Driving Analog Input



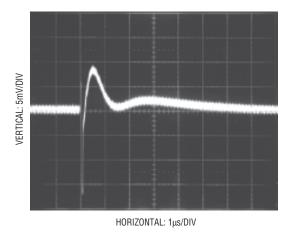


Figure 12. Poor Op Amp Settling Can Cause A/D Errors

RC Input Filtering

It is possible to filter the inputs with an RC network as shown in Figure 13. For large values of C_F (e.g., 1µF), the capacitive input switching currents are averaged into a net DC current. Therefore, a filter should be chosen with small resistor and large capacitor to prevent DC drops across the resistor. The magnitude of the DC current is approximately $I_{DC} = 65 pF \times V_{IN}/t_{CYC}$ and is roughly proportional to V_{IN} . When running at the minimum cycle time of 68µs, the input current equals 2.5µA at $V_{IN} = 2.5V$. In this case, a filter resistor of 100 Ω will cause 0.1LSB of full-scale error. If a larger filter resistor must be used, errors can be eliminated by increasing the cycle time as shown in the typical curve Maximum Filter Resistor vs Cycle Time.

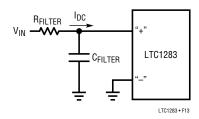


Figure 13. RC Input Filtering

Input Leakage Current

Input leakage currents can also create errors if the source resistance gets too large. For instance, the maximum input

leakage specification of 1μ A (at 125° C) flowing through a source resistance of 1k will cause a voltage drop of 1mV or 0.4LSB. This error will be much reduced at lower temperatures because leakage drops rapidly (see typical curve of Input Channel Leakage Current vs Temperature).

Noise Coupling into Inputs

High source resistance input signals (>500 Ω) are more sensitive to coupling from external sources. It is preferable to use channels near the center of the package (i.e., CH2-CH7) for signals which have the highest output resistance because they are essentially shielded by the pins of the package ends (DGND and CH0). Grounding any unused inputs (especially the end pin, CH0) will also reduce outside coupling into high source resistances.

4. Sample-and-Hold

Single-Ended Inputs

The LTC1283 provides a built-in sample-and-hold (S&H) function for all signals acquired in the single-ended mode (COM pin grounded). This sample-and-hold allows the LTC1283 to convert rapidly varying signals (see typical curve of S&H Acquisition Time vs Source Resistance). The input voltage is sampled during the t_{SMPL} time as shown in Figure 10. The sampling interval begins after the fourth MUX address bit is shifted in and continues during the remainder of the data transfer. On the falling edge of the final SCLK, the S&H goes into hold mode and the conversion begins. The voltage will be held on either the 8th, 10th, 12th or 16th falling edge of the SCLK depending on the word length selected.

Differential Inputs

With differential inputs, or when the COM pin is not tied to ground, the A/D no longer converts just a single voltage but rather the difference between two voltages. In these cases, the voltage on the selected "+" input is still sampled and held and therefore may be rapidly time varying just as in single-ended mode. However, the voltage on the selected "-" input must remain constant and be free of noise and ripple throughout the conversion time. Otherwise, the

differencing operation may not be performed accurately. The conversion time is 44 ACLK cycles. Therefore, a change in the "–" input voltage during this interval can cause conversion errors. For a sinusoidal voltage on the "–" input this error would be:

 $V_{\text{ERROR (MAX)}} = V_{\text{PEAK}} \times 2 \times \pi \times f(\text{``-''}) \times 44/f_{\text{ACLK}}$

Where f("-") is the frequency of the "-" input voltage, V_{PEAK} is its peak amplitude and f_{ACLK} is the frequency of the ACLK. In most cases V_{ERROR} will not be significant. For a 60Hz signal on the "-" input to generate a 1/4LSB error (0.61mV) with the converter running at ACLK = 1MHz, its peak value would have to be 38mV.

5. Reference Inputs

The voltage between the reference inputs of the LTC1283 defines the voltage span of the A/D converter. The reference inputs look primarily like a 10k resistor but will have transient capacitive switching currents due to the switched-capacitor conversion technique (see Figure 14). During each bit test of the conversion (every 4 ACLK cycles), a capacitive current spike will be generated on the reference pins by the A/D. These current spikes settle quickly and do not cause a problem. However, if slow settling circuitry is used to drive the reference inputs, care must be taken to insure that transients caused by these current spikes settle completely during each bit test of the conversion.

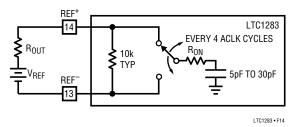


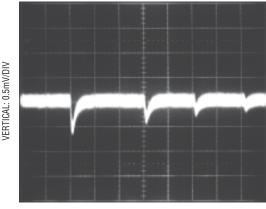
Figure 14. Reference Input Equivalent Circuit

When driving the reference inputs, three things should be kept in mind:

- 1. The source resistance (R_{OUT}) driving the reference inputs should be low (less than 1Ω) to prevent DC drops caused by the 300μ A maximum reference current (I_{REF}).
- 2. Transients on the reference inputs caused by the capacitive switching currents must settle completely during each bit test (each 4 ACLK cycles). Figures 15

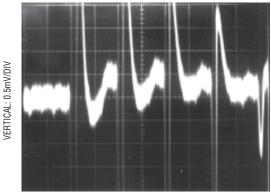
and 16 show examples of both adequate and poor settling. Using a slower ACLK will allow more time for the reference to settle. However, even at the maximum ACLK rate of 1MHz most references and op amps can be made to settle within the 4μ s bit time.

3. It is recommended that the REF⁻ input be tied directly to the analog ground plane. If REF⁻ is biased at a voltage other than ground, the voltage must not change during a conversion cycle. This voltage must also be free of noise and ripple with respect to analog ground.



HORIZONTAL: 1µs/DIV





HORIZONTAL: 1µs/DIV



6. Reduced Reference Operation

The effective resolution to the LTC1283 can be increased by reducing the input span of the converter. The LTC1283 exhibits good linearity and gain over a wide range of reference voltages (see typical curves of Linearity and Gain Error vs Reference Voltage). However, care must be taken 1283fb



when operating at low values of V_{REF} because of the reduced LSB step size and the resulting higher accuracy requirement placed on the converter. The following factors must be considered when operating at low V_{REF} values.

- 1. Conversion speed (ACLK frequency)
- 2. Offset
- 3. Noise

Conversion Speed with Reduced $\ensuremath{\mathsf{V_{REF}}}$

With reduced reference voltages, the LSB step size is reduced and the LTC1283 internal comparator overdrive is reduced. With less overdrive, more time is required to perform a conversion. Therefore, the maximum ACLK frequency should be reduced when low values of V_{REF} are used. This is shown in the typical curve of Maximum Conversion Clock Rate vs Reference Voltage.

Offset with Reduced V_{REF}

The offset of the LTC1283 has a larger effect on the output code when the A/D is operated with reduced reference voltage. The offset (which is typically a fixed voltage) becomes a larger fraction of an LSB as the size of the LSB is reduced. The typical curve of Unadjusted Offset Error vs Reference Voltage shows how offset in LSBs is related to reference voltage for a typical value of V_{OS}. For example, a V_{OS} of 0.5mV which is 0.2LSB with a 2.5V reference becomes 0.5LSB with a 1V reference and 2.5LSBs with a 0.2V reference. If this offset is unacceptable, it can be corrected digitally by the receiving system or by offsetting the "–" input to the LTC1283.

Noise with Reduced V_{REF}

The total input referred noise of the LTC1283 can be reduced to approximately 200μ V peak-to-peak using a ground plane, good bypassing, good layout techniques and minimizing noise on the reference inputs. This noise is insignificant with a 2.5V reference but will become a larger fraction of an LSB as the size of the LSB is reduced. The typical curve of Noise Error vs Reference Voltage shows the LSB contribution of this 200μ V of noise.

For operation with a 2.5V reference, the $200\mu V$ noise is only 0.08LSB peak-to-peak. In this case, the LTC1283

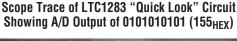


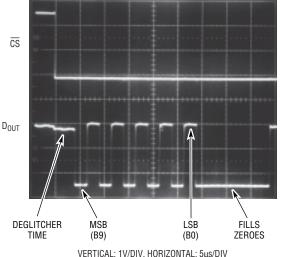
noise will contribute virtually no uncertainty to the output code. However, for reduced references, the noise may become a significant fraction of an LSB and cause undesirable jitter in the output code. For example, with a 1V reference, this same 200μ V noise is 0.2LSB peak-topeak. This will reduce the range of input voltages over which a stable output code can be achieved by 0.2LSB. If the reference is further reduced to 200mV, the 200μ V noise becomes equal to one LSB and a stable code may be difficult to achieve. In this case averaging readings may be necessary.

This noise data was taken in a very clean setup. Any setup induced noise (noise or ripple on V_{CC} , V_{REF} , V_{IN} or V^-) will add to the internal noise. The lower the reference voltage to be used, the more critical it becomes to have a clean, noise-free setup.

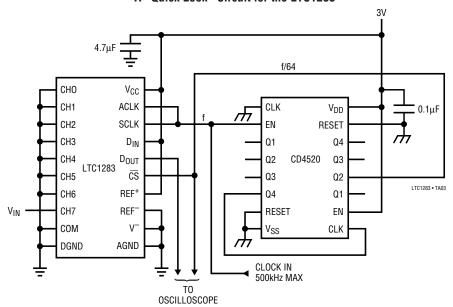
A "Quick Look" Circuit for the LTC1283

Users can get a quick look at the function and timing of the LTC1283 by using the following simple circuit. REF⁺ and D_{IN} are tied to V_{CC} selecting a 3V input span, CH7 as a single-ended input, unipolar mode, MSB-first format and 16-bit word length. ACLK and SCLK are tied together and driven by an external clock. CS is driven at 1/64 the clock rate by the CD4520 and D_{OUT} outputs the data. All other pins are tied to a ground plane. The output data from the D_{OUT} pin can be viewed on an oscilloscope which is set up to trigger on the falling edge of CS.





TYPICAL APPLICATIONS

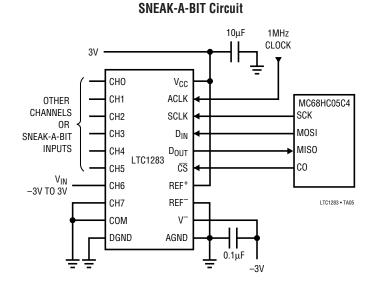


A "Quick Look" Circuit for the LTC1283

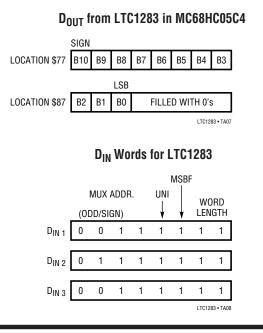
SNEAK-A-BIT[™]

The LTC1283's unique ability to software select the polarity of the differential inputs and the output word length is used to achieve one more bit of resolution. Using the circuit below with two conversions and some software, a 2's complement 10-bit + sign word is returned to memory inside the MPU. The MC68HC05C4 was chosen as an example; however, any processor could be used. Two 10-bit unipolar conversions are performed: the first over a OV to 3V span and the second over a OV to -3V span (by reversing the polarity of the inputs). The sign of the input is determined by which of the two spans contain it. Then the resulting number (ranging from -1023 to 1023 decimal) is converted to 2's complement notation and stored in RAM.

SNEAK-A-BIT Code



SNEAK-A-BIT is a trademark of Linear Technology Corp.





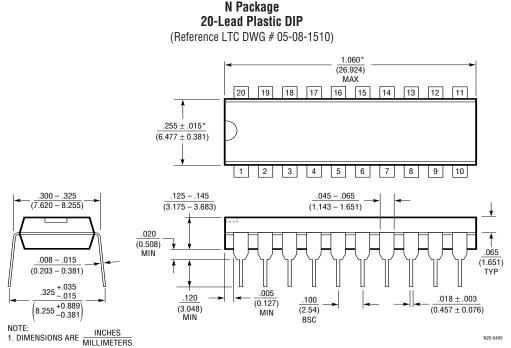
TYPICAL APPLICATIONS

Sneak-A-Bit Code fo	or the LTC1283	Using the MC68HC05C4
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MNEMONIC		;	DESCRIPTION	MI	MNEMONIC		DESCRIPTION
	LDA	#\$50	CONFIGURATION DATA FOR SPCR	L00P 2:	TST	\$0B	TEST STATUS OF SPIF
	STA	\$0A	LOAD CONFIGURATION DATA INTO \$0A		BPL	L00P 2	LOOP TO PREVIOUS INSTRUCTION IF NO
	LDA	#\$FF	CONFIGURATION DATA FOR PORT C DDR				DONE
	STA	\$06	LOAD CONFIGURATION DATA INTO PORT			0, \$02	CS GOES HIGH
	DOFT	0 000			LDA	\$0C	LOAD CONTENTS OF SPI DATA REG. INTO
		0, \$02	MAKE SURE CS IS HIGH		0.7.4	<u>ቀ</u> ር ተ	
	JSR	READ -/+	DUMMY READ CONFIGURES LTC1283 FOR NEXT READ		STA RTS	\$61	STORE LSBs IN \$61 RETURN
	JSR	READ +/-	READ CH6 WITH RESPECT TO CH7	CHK SIGN:		\$73	LOAD MSBs OF +/- READ INTO ACC
	JSR	READ $+/-$	READ CH7 WITH RESPECT TO CH6		ORA	\$73 \$74	OR ACC (MSBs) WITH LSBs OF +/- read
	JSR	CHK SIGN			BEQ	MINUS	IF RESULT IS 0 GOTO MINUS
	0011	onicoran	DATA, CONVERTS TO 2'S COMPLEMENT		CLC	WIINOO	CLEAR CARRY
			AND STORES IN RAM		ROR	\$73	ROTATE RIGHT \$73 THROUGH CARRY
READ -/+:	LDA	#\$3F	LOAD DIN WORD FOR LTC1283 INTO ACC		ROR	\$74	ROTATE RIGHT \$74 THROUGH CARRY
	JSR	TRANSFER	READ LTC1283 ROUTINE		LDA	\$73	LOAD MSBs OF +/- READ INTO ACC
	LDA	\$60	LOAD MSBs FROM LTC1283 INTO ACC		STA	\$77	STORE MSBs IN RAM LOCATION \$77
	STA	\$71	STORE MSBs IN \$71		LDA	\$74	LOAD LSBs OF +/- READ INTO ACC
	LDA	\$61	LOAD LSBs FROM LTC1283 INTO ACC		STA	\$87	STORE LSBs IN RAM LOCATION \$87
	STA	\$72	STORE LSBs IN \$72		BRA	END	GOTO END OF ROUTINE
. .,	RTS	"A	RETURN	MINUS:	CLC	A-1	CLEAR CARRY
Read $+/-$:	LDA	#\$7F	LOAD D _{IN} WORD FOR LTC1283 INTO ACC		ROR	\$71	SHIFT MSBs OF -/+ READ RIGHT
	JSR		READ LTC1283 ROUTINE		ROR	\$72	SHIFT LSBs -/+ READ RIGHT
	LDA STA	\$60 \$73	LOAD MSBs FROM LTC1283 INTO ACC STORE MSBs IN \$73		COM COM	\$71 \$72	1's COMPLEMENT OF MSBs 1's COMPLEMENT OF LSBs
	LDA	\$73 \$61	LOAD LSBs FROM LTC1283 INTO ACC		LDA	\$72 \$72	LOAD LSBs INTO ACC
	STA	\$74	STORE LSBs IN \$74		ADD	#\$01	ADD 1 TO LSBs
	RTS	Ψ	RETURN		STA	\$72	STORE ACC IN \$72
TRANSFER		0. \$02	CS GOES LOW		CLRA		CLEAR ACC
	STA	\$0C	LOAD D _{IN} INTO SPI. START TRANSFER		ADC	\$71	ADD WITH CARRY TO MSBs. RESULT IN
L00P 1:	TST	\$0B	TEST STATUS OF SPIF			+ ···	ACC
	BPL	LOOP 1	LOOP TO PREVIOUS INSTRUCTION IF NOT		STA	\$71	STORE ACC IN \$71
			DONE		STA	\$77	STORE MSBs IN RAM LOCATION \$77
	LDA	\$0C	LOAD CONTENTS OF SPI DATA REG. INTO		LDA	\$72	LOAD LSBs IN ACC
			ACC		STA	\$87	STORE LSBs IN RAM LOCATION \$87
	STA	\$0C	START NEXT CYCLE	END:	RTS		RETURN
	STA	\$60	STORE MSBs IN \$60				



PACKAGE DESCRIPTION



^{*}THESE DIMENSIONS DO NOT INCLUDE MOLD FLASH OR PROTRUSIONS. MOLD FLASH OR PROTRUSIONS SHALL NOT EXCEED .010 INCH (0.254mm)