The trend to miniaturization in electronics continues. Integrated circuit board solutions are becoming more and more popular as a means of efficiently utilizing the even smaller casing volume in all three dimensions.

Flexible foils of polyimide and LCP (Liquid Cristal Polymer) with a typical thickness of 50 µm are materials that withstand high temperatures and can be used with copper-cladding as base material for pure flex circuit boards or in combination with rigid base materials for flex-rigid circuit boards with all the prevalent soldering methods. Thin FR4 layers in FR4 Semiflex circuit boards are also bendable.

In recent years, Würth Elektronik has accumulated extensive expertise in already completed projects and commissions of the widest variety of designs and applications, from Aerospace to Medical devices and currently it supplies more than 500 customers. With the broad range of technology we offer, you can make the best possible selection for any requirements in terms of performance and costs.

In the following, you will find information about systems that explain the different variants of flex-rigid circuit boards as well as practical tips on design:

1. Systematic view of flex-rigid circuit boards
2. Project checklist for system requirements
3. Selection of the right technology
4. Materials and design parameters
5. Mechanical design
6. Layout and routing
7. Documents for manufacturing circuit boards

Basically, standards must be regarded such as IPC-2223, IPC-6013, the Basic Design Guide from Würth Elektronik, as well as variant-specific design rules and drying recommendations.

1. Systematic view of flex-rigid circuit boards

There are basically different ways to create a system:

**Heterogeneous system**
- Rigid circuit board + wiring harness/ flex soldered in or plugged (detachable)
  - Few connections
  - Non-critical applications
  - Wiring errors possible

**Homogeneous system**
- Circuit boards with identical stack-up in all rigid areas
  - Integrated flex layer(s) throughout
  - Considerably greater wiring density
  - Saves valuable space by eliminating connecting points (solder pads or footprint of connectors)

**Partially homogeneous system**
- Sub-systems vary considerably in terms of technology and size: e.g. flex-rigid/ connector combination
  - Separable

**TIP:** Integrated wiring should be provided for the smaller and simpler PCB1.
Flex-rigid circuit boards are mechatronic components. In addition to their electronic function, very careful consideration must also be given to mechanical factors:

- Component assembly, soldering and testing in flat condition in the multiple delivery panel
- Separating, configuring and installing

**Advantages:**
- Significantly less space required due to three-dimensional wiring
- Elimination of additional components such as connectors and connecting cables
- Improved signal transmission through elimination of cross-sectional changes to conductors (connectors, cable, solder connections)
- Weight reduction
- More valuable component assembly and wiring space
- Reduced logistical complexity
- Solution of difficult contacts is possible, simplification of assembly
- Considerably improved reliability of the entire system (a homogeneous unit is considerably more reliable than one with connectors and cable)
- Combination with HDI Microvia technologies (microvia, buried via, finest conductor width) is possible in many cases
- Combination with heatsink technology is possible

An exact selection of the best components and substrate technology is also necessary in order to be able to fulfill reliably the required operating conditions. Product development also includes getting a precise picture of component assembly, the soldering process, the test and the device assembly.

**Cooperation of all participants of the value-added chain**

Flex/flex-rigid projects: Interdisciplinary cooperation in development is indispensable!
2. Project checklist for system requirements:

a) Technical requirements for the final product: target market, key functions, any unique features, service life, size, appearance

b) Commercial requirements: quantities, cost goals, prototype schedule, pre-series, series release, ramp-up, second source, possible audit planning

c) Legal requirements: listings and permits, regulated medical technology market, relevance for German Federal Office of Economics and Export (BAFA)

d) Reliability requirements: IPC class 1/2/3, failure risk analysis, product liability, quality management agreement, APQP, PPAP, traceability

e) Product operating conditions: ambient conditions such as temperature, temperature change, cooling, humidity, shock and vibration, non-flammability, component assembly/soldering/repairs, test procedures for environmental and reliability tests

f) Casing size, material and shape: analysis of all mechanical and electrical interfaces, displays, switches, connectors, interfaces with other devices or modules. Design of a three-dimensional model (paper + scissors / mCAD+eCAD) in order to find minimum area for flat projection of the circuitry

g) Mechanical requirements of circuit board: static or dynamic application, circuit board thickness, stability, aspect ratio of drill hole diameter/board thickness, bending radii, bending radius/flex thickness ratio, bending form, number of bending cycles, bending frequency

h) Electrical requirements of circuit board: power, dielectric strength, amperage, insulation and shielding, EMC, number of signals across the flexible area, number of flex layers, signal integrity, impedance requirements, surface resistance

<table>
<thead>
<tr>
<th>Number of flex layers</th>
<th>1</th>
<th>2</th>
<th>4</th>
<th>6</th>
<th>8</th>
<th>10</th>
<th>12</th>
</tr>
</thead>
<tbody>
<tr>
<td>Flex/TWINflex</td>
<td></td>
<td></td>
<td></td>
<td></td>
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<td></td>
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<tr>
<td>Flex-rigid flex outside</td>
<td></td>
<td></td>
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<td></td>
<td></td>
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<tr>
<td>Flex-rigid flex inside</td>
<td></td>
<td></td>
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<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>FR4 Semiflex</td>
<td></td>
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</tr>
</tbody>
</table>

i) Type and positioning of components, design and connection technology: components such as BGA requiring advanced via technology, stackup, naked chip technology, soldering surface, delivery panel, legend print, press-fit technology, embedded components

j) Testing and Packaging: electrical and mechanical test of the circuit board, product testing documentation (detailed initial sample test report is recommended for complex stack-up, specify test criteria), packaging

k) Further processing of flex and flex-rigid PCBs: possibilities of drying prior to soldering, logistics, dry storage, panel separation, casing assembly, installation tolerances and fastening possibilities

Circuit board form „L“ is better than „T“ Würth Elektronik will offer you the best delivery panel (best price!)
3. Selection of the right technology

Possible variants:

**Flex / TWINflex®**
- 2F (Flex)
- 2F-Ri (TWINflex)
- 4F with microvias 1-2/2-3/3-4

**In comparison:**
- 1F-Ri (TWINflex)
- 1F-0Ri (flex-rigid)

- Very thin flexible foil PI/LCP
- 1 to 6 copper layers
- Partially reinforced with stiffener
- Photosensitive solder mask foil or Polyimide coverlay
- Delivered individually or as panel

**NOTE:**
Flex-rigid 1F-0Ri design can be more affordable than a TWINflex 1F-Ri

**Flex-rigid**
- 1F-5Ri
- 2F-2Ri
- 3Ri-2F-3Ri
- 3Ri-8F-3Ri

- Components on stable rigid section
- Flexible area 1 to 12 layers bonded/unbonded (airgap)
- Flexible Polyimide layers out-side or symmetrically inside
- Rigid areas: standard soldermask
- Flexible area: highly flexible soldermask or Polyimide coverlay

**FR4 Semiflex**
- ML4 Semiflex 1-layer
- ML6 Semiflex 2-layers

- Rigid FR4 circuit boards with deep milling process
- Affordable
- Clearly defined installation situation and large bending radius
- Bending area: 1 or 2 copper layers, flex soldermask or Polyimide coverlay

**NOTE:**
Often more affordable than a connector-cable-connector solution
Indicators for preferential use of individual variants:

<table>
<thead>
<tr>
<th>Variant</th>
<th>Indicators for</th>
<th>Comments</th>
</tr>
</thead>
<tbody>
<tr>
<td>Flex xF</td>
<td>Very small, dense circuits</td>
<td>Microvias and contour possible with laser</td>
</tr>
<tr>
<td></td>
<td>Very limited installation space</td>
<td>Flexible foil 50 µm thick</td>
</tr>
<tr>
<td></td>
<td>Use in vacuum</td>
<td>Practically no gas emission</td>
</tr>
<tr>
<td></td>
<td>Use at high temperatures</td>
<td>PI and LCP can be used up to more than 200°C</td>
</tr>
<tr>
<td></td>
<td>High frequency applications</td>
<td>Good thickness tolerance, copper treatment flat</td>
</tr>
<tr>
<td></td>
<td>Vias in flexible area</td>
<td>But NOT permitted in bending area!</td>
</tr>
<tr>
<td>TWINflex xF-Ri</td>
<td>Cooling problem</td>
<td>Metal reinforcement (heatsink)</td>
</tr>
<tr>
<td>FR4 Semiflex</td>
<td>Flex-to-install with large bending radii</td>
<td>Affordable solution</td>
</tr>
<tr>
<td></td>
<td>Large board with angled connector</td>
<td>Only bendability is necessary</td>
</tr>
<tr>
<td></td>
<td>Flex material not permitted</td>
<td>Only rigid base materials</td>
</tr>
<tr>
<td>Flex-rigid 1F-xRi</td>
<td>Large portion of flex surface</td>
<td>Laser-cut panel very stable</td>
</tr>
<tr>
<td></td>
<td>1:1 wiring across flexible area</td>
<td>More affordable than xRi-2F-xRi</td>
</tr>
<tr>
<td></td>
<td>Small bending radii</td>
<td>Thin flexible area, highly flexible soldermask</td>
</tr>
<tr>
<td></td>
<td>Short drying times</td>
<td>Flex layer on outside</td>
</tr>
<tr>
<td>Flex-rigid 2F-xRi</td>
<td>High-frequency component-to-connector connection across flexible area with reference layer</td>
<td>No vias necessary for transfers WARNING: complex (see table below)</td>
</tr>
<tr>
<td>Flex-rigid xRi-1F-xRi</td>
<td>Highly-dynamic prolonged bending</td>
<td>Copper in neutral phase ideal</td>
</tr>
<tr>
<td>Flex-rigid xRi-2F-xRi</td>
<td>Reference layer due to signal integrity</td>
<td>Polyimide with 50/75/100 µm possible</td>
</tr>
</tbody>
</table>

Indicators against the use of individual variants:

<table>
<thead>
<tr>
<th>Variant</th>
<th>Indicators against</th>
<th>Comments</th>
</tr>
</thead>
<tbody>
<tr>
<td>Flex xF</td>
<td>Wired components or connectors</td>
<td>No via barrel, low mechanical stability</td>
</tr>
<tr>
<td>TWINflex xF-Ri</td>
<td>Many individual reinforcements</td>
<td>Better to use flex-rigid 1F-xRi</td>
</tr>
<tr>
<td>FR4 Semiflex</td>
<td>S-shaped bending in one surface</td>
<td>Do not subject glass mat to tension</td>
</tr>
<tr>
<td></td>
<td>Multi-section casing</td>
<td>Assembly tolerances have effect on Semiflex area</td>
</tr>
<tr>
<td>Flex-rigid 1F-xRi</td>
<td>-</td>
<td>-</td>
</tr>
<tr>
<td>Flex-rigid 2F-xRi</td>
<td>Large circuit boards</td>
<td>Design tends to bend and twist</td>
</tr>
<tr>
<td>Flex-rigid xRi-2F-xRi</td>
<td>Large quantities</td>
<td>limited area, tends to be expensive</td>
</tr>
</tbody>
</table>

Please look at the Basic Design Guide of Würth Elektronik for design rules regarding structures, via sizes and soldermask.

The requirements in the checklist should be analyzed in detail in a discussion of the project with our specialists.

4. Materials and design parameters
IPC class 2, use A (flex-to-install)

<table>
<thead>
<tr>
<th>Flexible material</th>
<th>Polyimide core 50 µm, coverlay 25 µm</th>
</tr>
</thead>
<tbody>
<tr>
<td>Rigid material</td>
<td>FR4 IPC-4101/21 or high-Tg FR4 filled, halogen-free: IPC-4101C/128 (92,94,127)</td>
</tr>
<tr>
<td>Copper thicknesses</td>
<td>Inner layers 18/35/70 µm base copper, outer layers 18/35µm + plating (with 1F-xRi flex layer is outside)</td>
</tr>
<tr>
<td>Circuit board thickness</td>
<td>Depends on number of layers: flex &gt; 100 µm, flex-rigid/FR4 Semiflex ≥ 0.8 mm</td>
</tr>
<tr>
<td>Solder surface</td>
<td>ENIG</td>
</tr>
</tbody>
</table>
5. The mechanical design

- Always provide large contour radii (inner and outer radii) in the flexible areas (design suitable for plastic)
- Provide registration drill holes for bonding reinforcements or heatsinks, if necessary
- Arrange flex extensions to save space, if necessary combine multiple extensions, use fold technology
- Flex-rigid: Use “nut and feather designs” or plastic retaining frame
- Flex lift-off technique
- Calculation of flex length
- With short flexible areas, four bonded flex layers are easier to bend than 2+2 flex layers with airgap

<table>
<thead>
<tr>
<th>Bending radius [mm]</th>
<th>1</th>
<th>2</th>
<th>3</th>
<th>4</th>
<th>5</th>
<th>6</th>
</tr>
</thead>
<tbody>
<tr>
<td>Flex area 1-layer</td>
<td></td>
<td></td>
<td></td>
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<tr>
<td>Flex area 2-layers</td>
<td></td>
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<tr>
<td>Flex area 4-layers</td>
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</tbody>
</table>

IPC-2223: Use A Flex-to-install

tight radius causing compression of inner flex layers
6. Layout & Routing
Features and recommendations for flex-rigid circuit boards

- Extra layer is necessary for defining flexible and rigid areas
- No vias in flexible area with flex-rigid
- Use teardrops
- Round routing

Regard distances of drill holes and SMD pads to flex-rigid transition, see Würth Elektronik design rules

For IPC-2223 „Use B“ applications, be sure to consult with our specialists!

- Introduce fiducials for laser-cut contours

7. Documents for the circuit board

- Include all applicable points from the checklist.
- Define what is more important: drawing or data. Electrical data (Gerber/ODB++, CAD data) already contain all geometric dimensions.
- No overspecification: a good drawing shows flat handling of the circuit (2D), a 3D view of the installation situation and critical dimensions only. Any extraneous measurement on the drawing must be compared with electronic data, and any discrepancies will inevitably result in delays and additional costs.
- Specify materials in terms that are as general as possible, e.g. according to IPC specification sheets. Do not stipulate any material descriptions of supplier X with material Y.
- Adhesive layers basically should not be dimensioned, only the total thickness, copper thicknesses and necessary dielectric thicknesses (e.g. due to impedance or insulation requirements).
- General specifications for creating an optimal delivery panel and possible positions for posts (especially in the flexible area / alternative to laser cut). A delivery panel specified in the request for quotation can be replaced by a more affordable one, and due to better capacity utilization it has a more affordable price.

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