



Behzad Razavi

# The Design of a Millimeter-Wave VCO

Millimeter-wave transceivers have found their place in 5G radios operating around 30 GHz. In this article, we design a voltage-controlled oscillator (VCO) in 28-nm CMOS technology for such an environment. We target the following performance

- tuning range: 28–32 GHz
- phase noise (PN): –100 dBc/Hz at 1-MHz offset
- power consumption: less than 2 mW.

The circuit is simulated in the slow–slow corner of the process with  $V_{DD} = 0.95$  V and at  $T = 75^\circ\text{C}$ . Given the high oscillation frequency and the low PN, we opt for an inductance–capacitance (LC) topology. The reader is referred to numerous articles on LC oscillator design for background information, e.g., [1]–[5].

The design of the VCO depends to some extent on the phase-locked loop (PLL) in which it is embedded. We assume that the PLL receives a reference frequency of 200 MHz with a PN of –170 dBc/Hz. The PLL therefore employs a feedback divide ratio equal to 300.

## General Considerations

We begin with the simple LC oscillator shown in Figure 1, where  $R_p$  models the loss of each tank. It can be shown that the peak-to-peak voltage swing at X (or Y) is given by  $(4/\pi)R_p I_{SS}$  [5]. The outputs bear a common-mode (CM) level close to  $V_{DD}$ , possibly requiring capacitive coupling for driving stages

such as mixers and frequency dividers. The tail current source is necessary to maintain the proper bias conditions and voltage swings in the presence of process, supply voltage, and temperature (PVT) variations.

The output PN of this structure due to the thermal noise of  $M_1$ ,  $M_2$ , and the tanks is expressed as

$$S_{\phi n}(\Delta f) = \frac{\pi^2 kT(\gamma + 1)}{2R_p I_{SS}^2} \left( \frac{f_0}{2Q\Delta f} \right)^2, \quad (1)$$

where  $k = 1.38 \times 10^{-23}$  J·K,  $\gamma$  is the MOS excess noise coefficient (and approximately equal to one),  $f_0$  is the oscillation frequency,  $Q$  is the tank quality factor, and  $\Delta f$  is the offset frequency [5]. Since  $V_0 = (4/\pi) I_{SS} R_p$ , we rewrite (1) as

$$S_{\phi n}(\Delta f) = \frac{2\pi kT(\gamma + 1)}{I_{SS} V_0} \left( \frac{f_0}{2Q\Delta f} \right)^2. \quad (2)$$

If we select  $V_0 \approx 0.8V_{pp}$ , we have only  $I_{SS}$  and  $Q$  under our control. What combination of these two parameters yields  $S_{\phi n}(\Delta f = 1\text{ MHz}) = -100$  dBc/Hz at  $T = 350$  K? For example, a power budget of 2 mW and  $I_{SS} \approx 2$  mA requires  $Q \approx 9$ , a reasonable value. We bear in mind these theoretical predictions and proceed.

## Inductor Design

The tank quality factor, the output swing, and the PN of the foregoing oscillator strongly depend on the inductor's design. We then ponder how this device must be realized. Numerous geometries can be envi-

sioned, but we focus on a single-turn octagonal structure. Shown in Figure 2(a), this shape provides two degrees of freedom, namely, the diameter,  $d$ , and the linewidth,  $W$ . The former defines the inductance, and the latter affects the loss. At millimeter-wave frequencies, the current tends to flow near the edges of the octagon, but  $W$  still plays some role in the  $Q$ . In this spirit, we also consider a parallel stack of metal-9 (M9) and metal-8 (M8) lines [Figure 2(b)] and ask whether it can offer a greater  $Q$ .

The two geometries in Figure 2 have been simulated in Cadence's EMX tool for various inductance values and with different dimensions. Table 1 summarizes the results, suggesting that the  $Q$  reaches a maximum of 32 for a 106-pH M9/M8 stack having a diameter of 110  $\mu\text{m}$  and a linewidth of 20  $\mu\text{m}$ . The  $Q$  does rise by 10% as a result of stacking. We should remark that these values correspond to the differential excitation of the inductors.

Whether or not the 106-pH device satisfies our needs is also determined

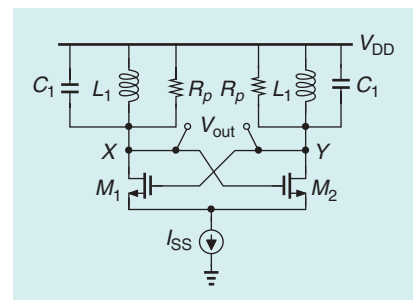


FIGURE 1: A basic LC oscillator.

by the equivalent parallel resistance,  $R_p$ , that it provides. Specifically, with an  $I_{SS}$  bound of about 2 mA in Figure 1, the output swing,  $(4/\pi)R_p I_{SS}$ , must be reasonable. Fortunately, a differential inductance of  $L = 106$  pH yields  $R_p = (L/2)\omega Q = 320 \Omega$  at 30 GHz, and hence, a single-ended swing of about 815 mV<sub>pp</sub>. We then proceed with this geometry.

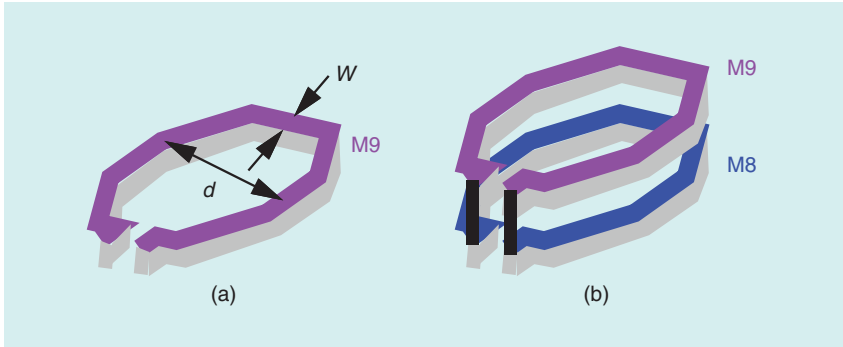
Using (1) and this inductor design, we can predict the PN. If  $I_{SS} = 2$  mA and  $R_p = 320 \Omega$ , we have  $S_{\phi_n}(\Delta f) = -112$  dBc/Hz at 1-MHz offset. We are eager to see whether simulations agree with this result.

### Basic Oscillator Design

With the optimal inductor found, we construct the basic oscillator

shown in Figure 3(a). Here, we select  $(W/L)_{1,2}$  such that  $M_1$  and  $M_2$  steer their tail current completely and rapidly while sensing sinusoids at X and Y having a peak-to-peak swing of about 800 mV. For now, each tank includes a constant capacitance of 500 fF so as to provide  $f_0 \approx 30$  GHz.

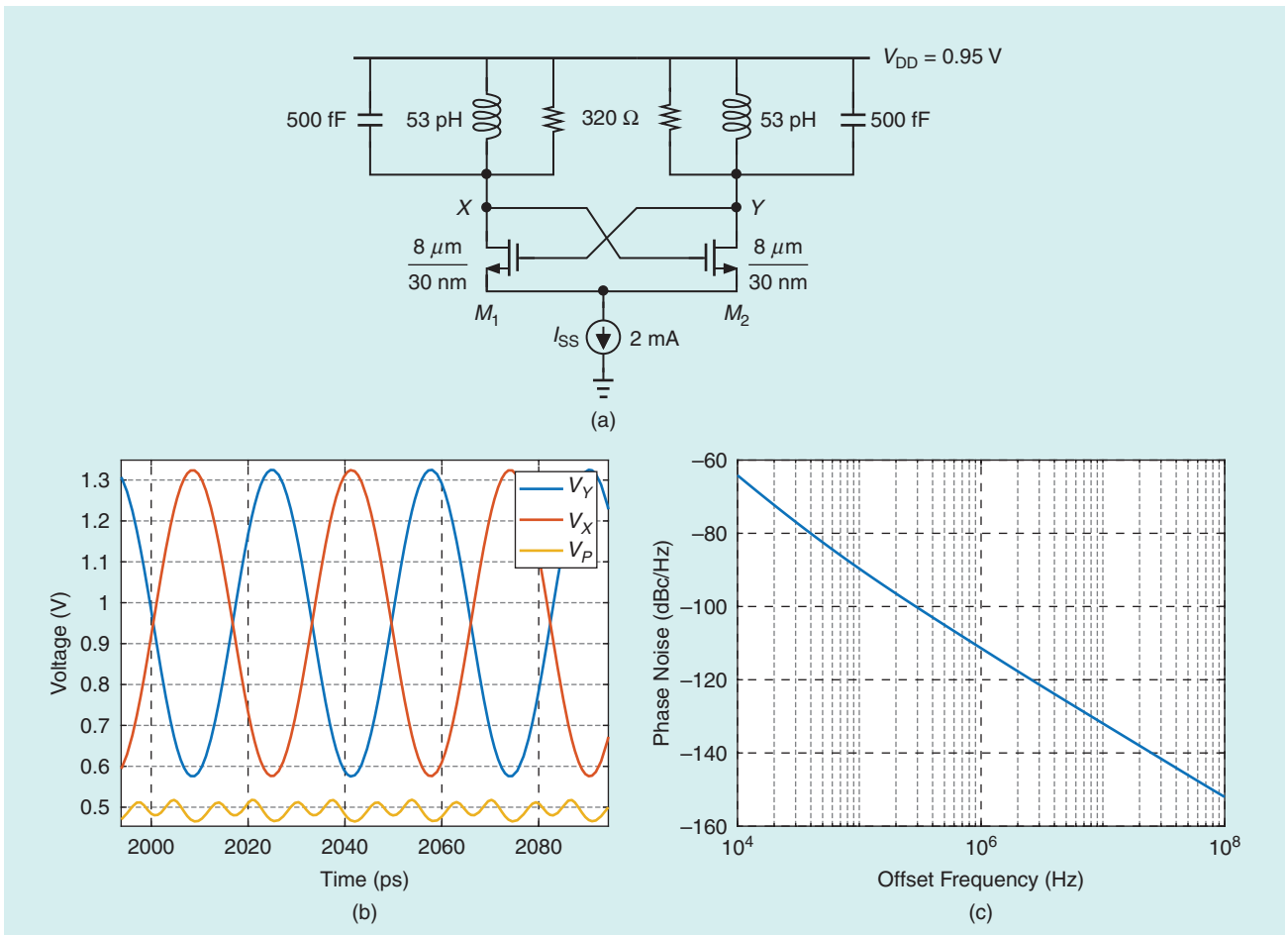
Plotted in Figure 3(b) are the output waveforms. The swing is about 10% less than the target because



**FIGURE 2:** Octagonal inductors realized as (a) a single metal-9 layer and (b) parallel stack of metal-9 and metal-8 (M8) layers.

**TABLE 1. A COMPARISON OF DIFFERENT INDUCTOR DESIGNS.**

$d$ ( $\mu\text{m}$ )	82	110	118	136
$W$ ( $\mu\text{m}$ )	20	20	15	13
$L$ (pH)	57	106	158	203
$Q$ at 30 GHz				
M9 Only	22	29	28	28
M9/M8	25	32	30	30



**FIGURE 3:** (a) The preliminary oscillator design, (b) its waveforms, and (c) its PN profile.

the expression  $(4/\pi)R_p I_{SS}$  assumes that the drain currents are perfect square waves, but in reality, they suffer from gradual transitions.

The oscillator's PN is shown in Figure 3(c), offering two interesting insights. First, the profile displays a slope of about  $-30$  dBc/decade from  $\Delta f = 10$  kHz to  $\Delta f = 100$  kHz, suggesting flicker noise upconversion. Second, the PN at  $\Delta f = 1$  MHz is about  $-111$  dBc/Hz, while (1) implies a value of  $-114$  dBc/Hz at  $T = 350$  K and with  $Q = 32$ . This discrepancy arises primarily because  $M_1$  and  $M_2$  enter the triode region in this design—as evidenced by a maximum  $V_X - V_Y$  of  $750$  mV—whereas (1) assumes they do not.

The basic oscillator must now be modified for continuous and discrete tuning. The former is created by varactors, and the latter is realized by switched capacitors.

### Continuous Tuning

We wish to add MOS varactors to the output nodes so as to provide continuous tuning (Figure 4). We must select the dimensions of  $M_{v1}$  and  $M_{v2}$ . The minimum length is typically dictated by the design kit's rules at a value much greater than the process node's minimum channel length. This is possibly because the foundry has not measured and characterized short-channel varactors. Here, we choose the minimum allowable length of  $200$  nm, expecting that the long channel introduces a high equivalent series resistance, degrading the varactor  $Q$ . Indeed, the  $Q$  is around  $20$  at  $30$  GHz.

This limitation may suggest that the tank  $Q$  drops considerably when the varactors are attached. Fortunately,  $M_{v1}$  and  $M_{v2}$  need pro-

vide but a narrow tuning range and can therefore be small. It is shown [6] that the overall tank  $Q$  is obtained from

$$\frac{1}{Q_{\text{tot}}} = \frac{1}{Q_L} + \frac{1}{\left(1 + \frac{C_1}{C_{\text{var}}}\right)Q_{\text{var}}}, \quad (3)$$

where  $Q_L$  and  $Q_{\text{var}}$  denote the inductor and varactor quality factors, respectively;  $C_1$  is the constant tank capacitance; and  $C_{\text{var}}$  is the varactor capacitance. For example, if  $Q_L = 32$ ,  $Q_{\text{var}} = 20$ , and  $C_1/C_{\text{var}} = 20$ , then the varactor lowers the tank  $Q$  by about  $9\%$ . This point calls for a small  $C_{\text{var}}$  and, thus, a low VCO gain,  $K_{\text{VCO}}$ . Nonetheless, an excessively narrow continuous tuning range means that the circuit cannot accommodate large temperature drifts unless the discrete-tuning network switches capacitors into or out of the tanks. Such an action disrupts the operation of the phase-locked loop and should be preferably avoided.

As a compromise, we choose a width of  $16 \mu\text{m}$  for  $M_{v1}$  and  $M_{v2}$  in Figure 4, obtaining  $f_0 = 28.8$  GHz for  $V_{\text{cont}} = 100$  mV and  $f_0 = 29.7$  GHz for  $V_{\text{cont}} = 850$  mV. (The control voltage is allowed to reach within  $100$  mV of the supply rails in view of the preceding circuit's output voltage compliance.) The  $900$ -MHz range accrues at the cost of a high  $K_{\text{VCO}}$ , nearly  $1.9$  GHz/V in the vicinity of  $V_{\text{cont}} = 850$  mV. This effect makes the circuit sensitive to noise on  $V_{\text{cont}}$  and on  $V_{\text{DD}}$ . For example, suppose a sinusoidal ripple appears on  $V_{\text{cont}}$  at the PLL reference frequency of  $200$  MHz. For such a ripple to yield an output spur at  $-60$  dBc, we have  $K_{\text{VCO}} V_m / (2\omega_m) = 10^{-3}$ , where  $V_m$  and  $\omega_m$  denote the ripple amplitude and frequency, respectively. It follows that  $V_m < 0.21$  mV, a difficult condition to guarantee.

We can also estimate the maximum tolerable supply noise for  $K_{\text{VCO}} = 1.9$  GHz/V. As explained in [7], a noise spectral density of  $\overline{V_n^2}$  at a frequency  $f_1$  yields  $S_\phi(f_1) = K_{\text{VCO}}^2 \overline{V_n^2} / (4\pi^2 f_1^2)$ . For this value to remain negligible with respect to our target of  $-100$  dBc/Hz at  $1$ -MHz offset,

we select  $S_\phi(f_1) = -110$  dBc/Hz, obtaining  $\sqrt{\overline{V_n^2}} = 4.4$  nV/ $\sqrt{\text{Hz}}$ , also a daunting challenge in supply voltage regulator design.

Another issue arising from a high  $K_{\text{VCO}}$  relates to the conversion of amplitude modulation (AM) to phase modulation (PM). As explained later, this occurs when the tail current source's noise modulates the output amplitude, and the varactor nonlinearity converts this AM to PM.

For these reasons, we halve the varactor width and observe a tuning range of  $500$  MHz and a maximum  $K_{\text{VCO}}$  of  $980$  MHz/V. In practice, these choices are refined in conjunction with the PLL design.

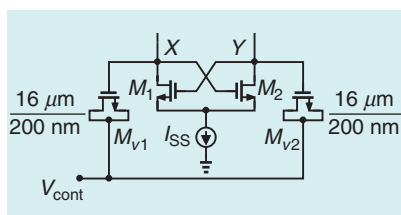
According to simulations, the  $8\text{-}\mu\text{m}$ -wide varactors negligibly affect the PN. Unfortunately, this will not be true when the ideal tail current source is replaced with an actual implementation, as seen later.

### Discrete Tuning

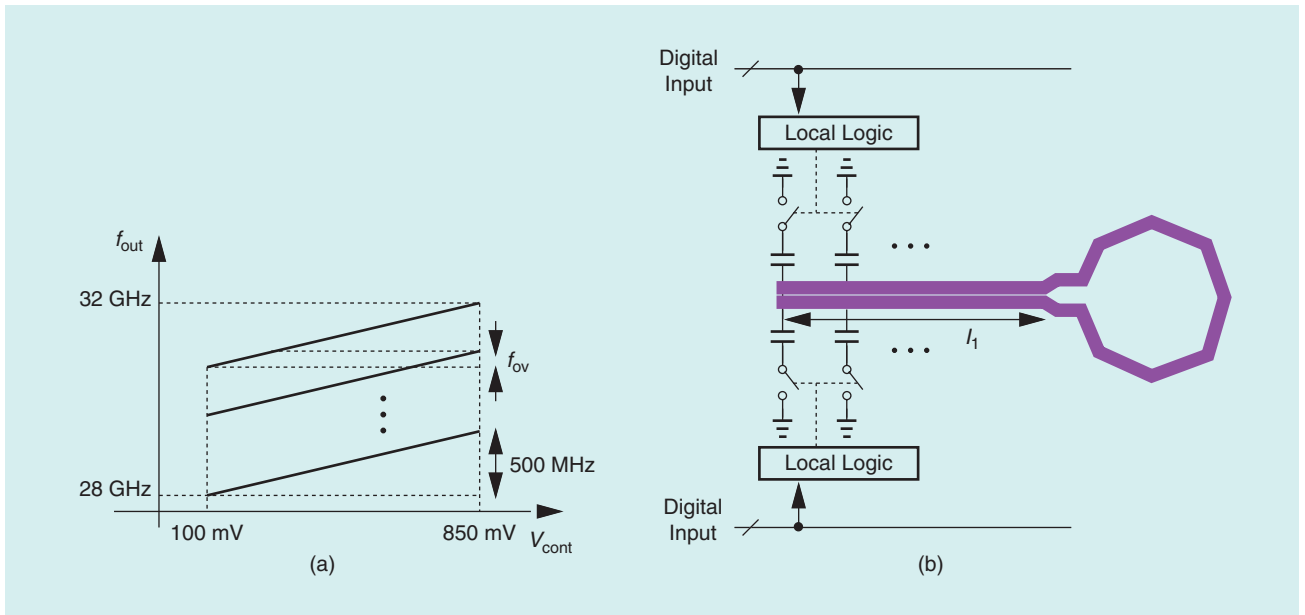
In addition to the  $500$ -MHz continuous tuning range produced previously, we wish to cover a total of about  $4$  GHz by means of switched capacitors. We envision the characteristics shown in Figure 5(a), where adjacent curves must have some overlap,  $f_{\text{ov}}$ , so as to avoid "dead zones." This family of curves presents its own challenges.

Suppose we allow  $f_{\text{ov}} = 100$  MHz. Then, the VCO demands about  $10$  tuning curves, i.e.,  $20$  switched capacitors must be tied to nodes  $X$  and  $Y$  in Figures 4(a) and Figure 5(b). The inductor's legs are extended to accommodate the switching units, thereby introducing additional resistance, while their inductances approximately cancel. The  $Q$  thus drops. Given that the total length of the original  $106$ -pH inductor is about  $350 \mu\text{m}$ , we must maintain  $l_1$  below about  $10 \mu\text{m}$ . The  $10$  units on each side must therefore be designed with a pitch of no more than  $1 \mu\text{m}$ , an impossible task in  $28$ -nm technology.

The next challenge stems from the finite  $Q$  of the switched capacitors. Consider the simple branch shown in Figure 6(a), where the digital input,  $D_j$ , switches the unit



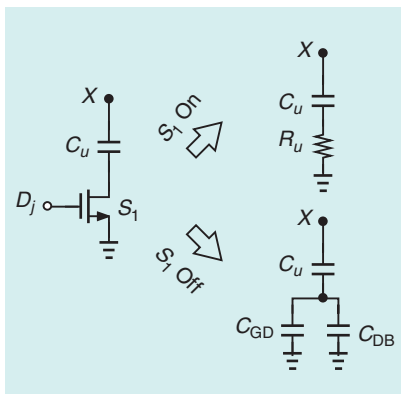
**FIGURE 4:** The addition of varactors to oscillator core.



**FIGURE 5:** (a) The desired continuous and discrete tuning characteristics and (b) the resulting layout complexity.

capacitor,  $C_u$ , into or out of the tank at node  $X$ . If conducting,  $S_1$  displays an on-resistance,  $R_u$ , limiting the  $Q$  of this branch to  $1/(R_u C_u \omega_0)$ . If off,  $S_1$  still presents  $C_p = C_{GD} + C_{DB}$  in series with  $C_u$ . That is, the “on/off capacitance ratio” is given by  $1 + C_u/(C_{GD} + C_{DB})$ . As the width of  $S_1$  increases, so does the  $Q$ , but this ratio drops. The reader can see that this less-than-infinity ratio reduces the vertical spacing between the successive curves in Figure 5(a) or, equivalently, raises the overlap,  $f_{ov}$ . In other words, 10 curves may not suffice to cover a range of 4 GHz.

With the foregoing thoughts, we ask whether it is possible for the switched-capacitor branches to



**FIGURE 6:** A switched-capacitor branch in on and off conditions.

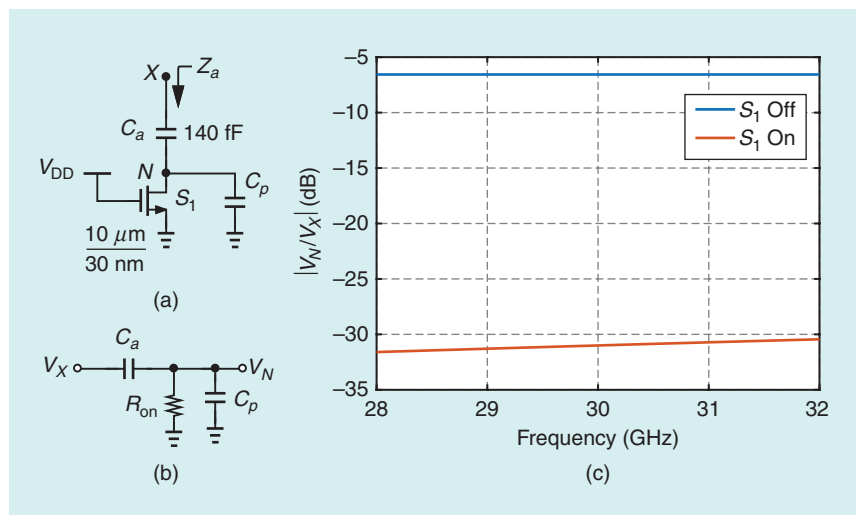
achieve a  $Q$  comparable to that of the inductor. This is an important issue because, unlike the varactors, these capacitors must constitute about 25% of the tank capacitance, potentially degrading the overall  $Q$  considerably.

With  $L = 53$  pH, the tank capacitance should vary from 610 fF to 470 fF to yield the desired frequency range. The total switched capacitance then amounts to 140 fF. We begin with the arrangement shown in Figure 7(a), where all of the switched branches are lumped into one. We select, as an example, a  $W/L$  ratio of  $10 \mu\text{m}/30 \mu\text{m}$

for  $S_1$  and use ac simulations to find the  $Q$  of the structure. Defining  $Q$  as  $1/(R_{on} C_a \omega) = \text{Im}\{Z_a\}/\text{Re}\{Z_a\}$ , we obtain  $Q \approx 1$  at 30 GHz! This means that  $R_{on} \approx 1/(C\omega) \approx 44 \Omega$ . Thus, to approach the inductor  $Q$  of 32, the width of the switch must increase to  $10 \mu\text{m} \times 32 = 320 \mu\text{m}$ . Note that with such a high  $Q$ , we have from Figure 7(b)

$$\left| \frac{V_N}{V_X} \right| = \left| \frac{R_{on} C_a s}{R_{on} (C_a + C_p) s + 1} \right| \quad (4)$$

$$\approx \frac{1}{Q}. \quad (5)$$



**FIGURE 7:** (a) A lumped representation of the entire discrete tuning network, (b) the simplified model, and (c) the magnitude response for the on and off states.

We can then simply measure the  $Q$  from the plot of  $|V_N/V_X|$  [Figure 7(c)]. When the switch is off,

$$\left| \frac{V_N}{V_X} \right| = \frac{C_a}{C_a + C_p}, \quad (6)$$

which is also plotted in Figure 7(c). The 6-dB attenuation reveals that  $C_p \approx C_a$ , and hence, the on/off ratio is  $C_a/(0.5C_a) = 2$ .

In summary, it is possible to raise the  $Q$  of the tank's switched

capacitance to that of the inductor. Applying (3) to this case, we write the second denominator on the right as  $(1 + 610 \text{ fF}/140 \text{ fF}) \times 32 \approx 170$ , obtaining  $Q_{\text{tot}} = 27$ . The PN then degrades by  $20 \log 32/27 = 1.5 \text{ dB}$ . More importantly, the low on/off ratio limits the tuning range; with the 140-fF capacitor switched out, the tank still contains  $470 \text{ fF} + 140 \text{ fF}/2 = 540 \text{ fF}$ . That is, the frequency rises by only  $\sqrt{610 \text{ fF}/540 \text{ fF}} = 6.3\% \approx 1.89 \text{ GHz}$  rather than by 4 GHz. It is important to note that these issues are far less severe in designs operating at, e.g., 5 GHz, because the width of the bottom-plate switches can be proportionally smaller at these frequencies for the same  $Q$ .

It is possible to improve the situation through the use of a "differential" switch. Illustrated in Figure 8, the idea is to recognize that the differential swings at  $X$  and  $Y$  also cause  $V_N$  and  $V_M$  to vary in opposite directions. Consequently, the "midpoint" of the channel of  $S_0$  is at ac ground, introducing only half of the device's on-resistance in series with  $C_a$  and  $C_b$ .

We conclude that  $S_0$  can be only  $160 \mu\text{m}$  wide and yet afford a  $Q$  of 32 for these capacitors. The parasitic capacitance is then halved. When  $C_a$  and  $C_b$  are switched out, they appear in series with  $140 \text{ fF}/2$ , yielding a net value of  $140 \text{ fF}/3 \approx 47 \text{ fF}$ . Repeating the foregoing calculations, we learn that the frequency rises by  $\sqrt{610 \text{ fF}/517 \text{ fF}} = 8.6\% \approx 2.6 \text{ GHz}$ . Switches  $S_1$  and  $S_2$  can have minimum dimensions as they simply define a zero dc level for  $V_N$  and  $V_M$ .

Since we still do not meet our 4-GHz tuning target, we select  $C_a = C_b = 175 \text{ fF}$  in Figure 8, at the cost of reducing the  $Q$ . Figure 9(a) shows our present design, and Figure 9(b) plots the PN at  $f_0 = 28 \text{ GHz}$  and  $f_0 = 32 \text{ GHz}$  (with the 175-fF capacitors switched in and out and with  $V_{\text{cont}}$  set to 100 and 850 mV, respectively.) The latter PN is higher than expected by a large amount, an effect studied in the next section.

We now decompose the 175-fF capacitors and the  $160\text{-}\mu\text{m}$  switch into 10 units. The units need not be

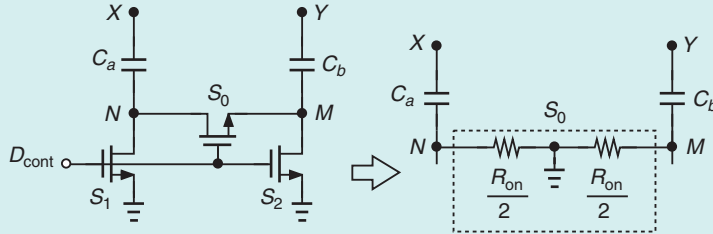


FIGURE 8: The use of a differential switch to alleviate the  $Q$ -capacitance tradeoff.

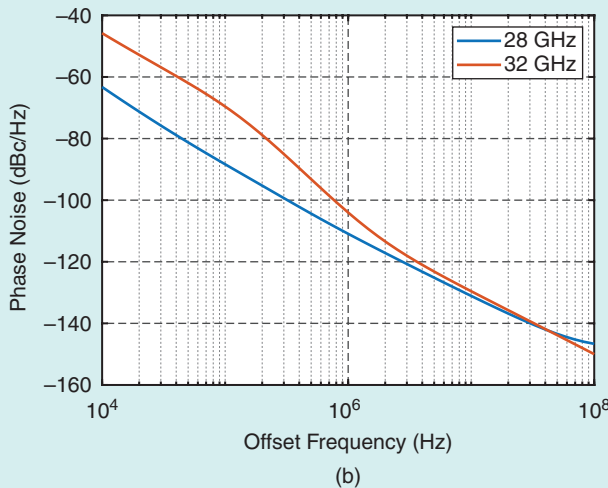
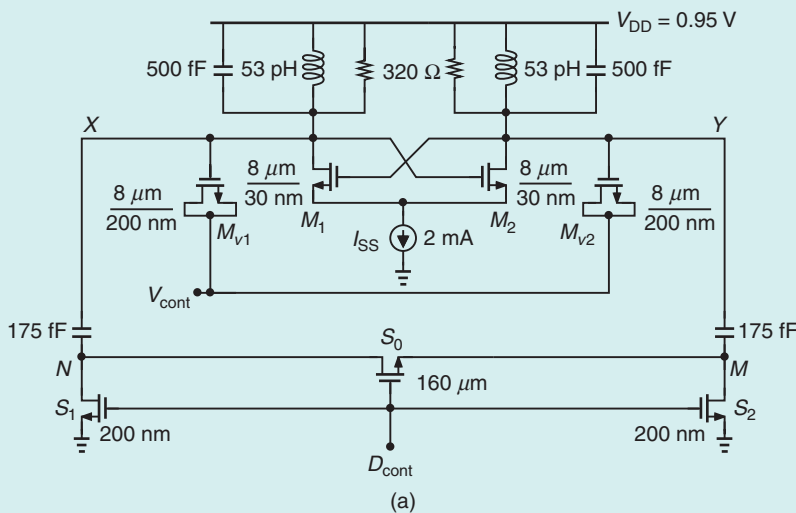


FIGURE 9: (a) The preliminary VCO design and (a) its PN profile at 28-GHz and 32-GHz oscillation frequencies.



identical. In fact, those that switch out at higher frequencies should be smaller so as to yield relatively uniform steps in the tuning range.

### The Problem of Switch Flicker Noise

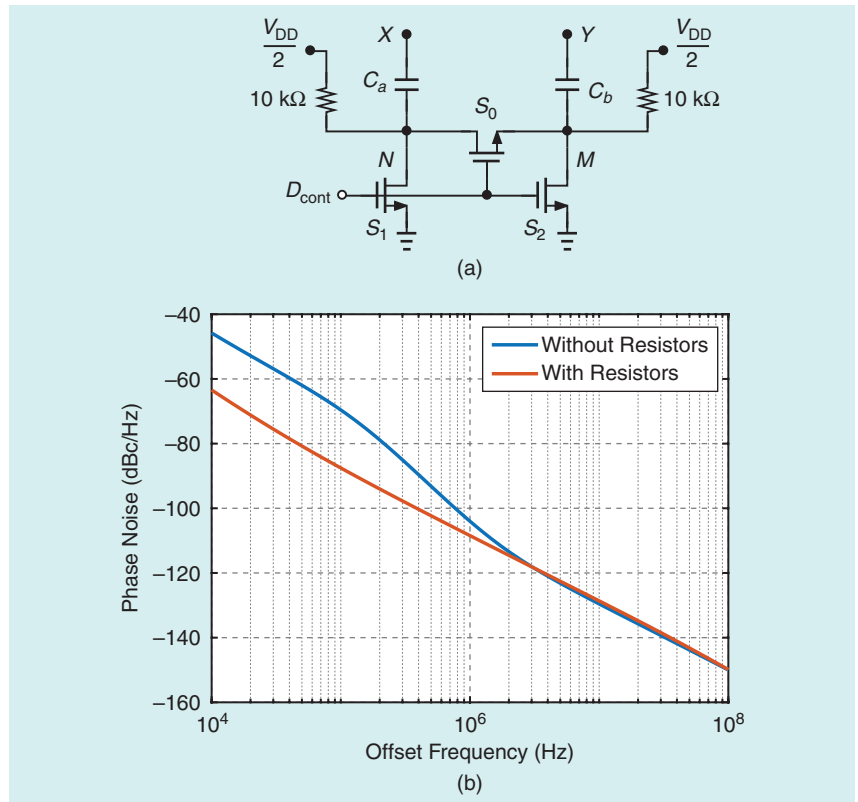
The discrete tuning circuit of Figure 8 presents an interesting issue when the switches are nominally off. Since  $V_N$  and  $V_M$  swing by several hundred millivolts, the switches turn on partially and inject flicker noise. Fortunately, the situation can be remedied by raising the CM level of  $N$  and  $M$  in the off mode. Illustrated in Figure 10(a), this is accomplished by tying these nodes to a dc level of about  $V_{DD}/2$  through two large resistors. Figure 10(b) plots the PN before and after the resistors are added, suggesting that the degradation is almost completely avoided.

The method shown in Figure 10(a) does pose another difficulty; upon decomposing the network into, for example, 10 cells, we must scale the resistors up by the same factor. The large footprint of such devices makes the layout depicted in Figure 5(b) even more complex.

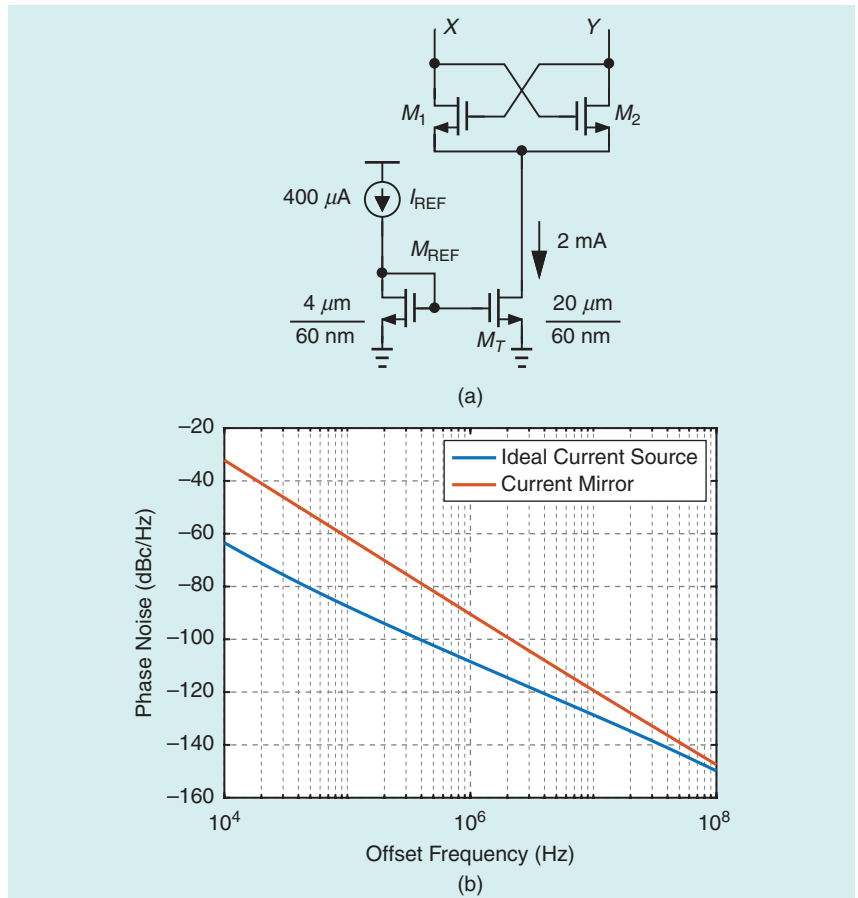
### The Problem of the Tail Current Source

The ideal tail current source in the VCO of Figure 9(a) must now be realized by a current mirror arrangement [Figure 11(a)]. To conserve power, we are tempted to select a value of 5–10 for the mirror current multiplication factor, e.g., we have  $I_{REF} = 400 \mu A$ . But the flicker and thermal noise of  $M_{REF}$  are amplified proportionally. The tail flicker noise current,  $I_n$ , simply adds to  $I_{SS}$  and introduces AM according to  $(4/\pi)R_p(I_{SS} + I_n)$ , evidently a benign effect as far as the output *phase* is concerned. However, the nonlinear capacitance at  $X$  and  $Y$  converts AM to PM [8]. The tail thermal noise at twice the oscillation frequency also manifests itself as PN around the carrier.

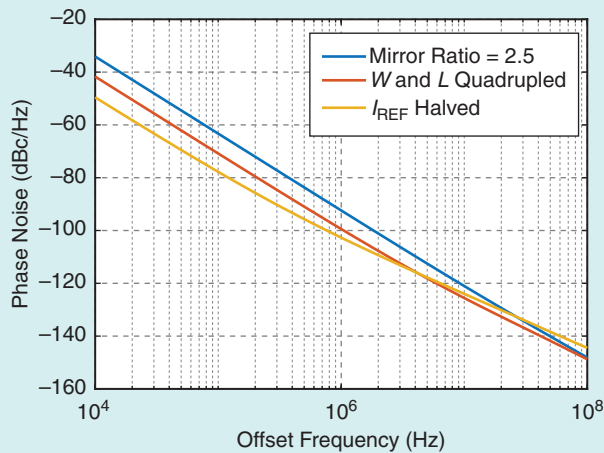
We should note that the worst case for AM/PM conversion in this design occurs when  $K_{VCO}$  is maximum. This is because the varactors



**FIGURE 10:** The use of pull-up resistors to avoid turning on the bottom-plate switches and (b) the effect of pull-up on the PN.



**FIGURE 11:** (a) Tail current source realization by a mirror arrangement and (b) its effect on PN.



**FIGURE 12:** The VCO PN with a reduced mirror ratio, larger mirror transistors, and a lower tail current.

exhibit the greatest voltage dependence at this extreme. We then turn off the switched capacitors and set  $V_{\text{cont}}$  to 850 mV.

If we choose  $(W/L)_{\text{REF}} = 4 \mu\text{m}/60 \text{ nm}$  and  $(W/L)_{\text{T}} = 20 \mu\text{m}/60 \text{ nm}$ , we obtain the PN plotted in Figure 11(b), which also includes the profile corresponding to an ideal tail current source. The degradation is more than 20 dB at low offset frequencies.

To alleviate this issue, we decrease the mirror ratio to 2.5, allowing  $I_{\text{REF}} = 0.8 \text{ mA}$  and  $(W/L)_{\text{REF}} = 8 \mu\text{m}/60 \text{ nm}$ , at the cost of not meeting our power

budget. The new VCO PN is plotted in Figure 12, still higher than our specification of  $-100 \text{ dBc/Hz}$  at 1-MHz offset. In the next step, we reduce the flicker noise of the two transistors by quadrupling their (drawn) widths and lengths. As shown in Figure 12, the PN at 1-MHz offset falls to  $-100 \text{ dBc/Hz}$ .

Recognizing that flicker noise modulates the varactor capacitances (if they exhibit odd-order symmetry), we surmise that the effect can be alleviated if the voltage swings at X and Y are reduced. We therefore

halve  $I_{\text{REF}}$  and observe a 3-dB drop in PN (Figure 12). This leads to a single-ended output swing of about  $400 \text{ mV}_{\text{pp}}$ , requiring that the VCO be followed by self-biased inverters if rail-to-rail swings are required.

## References

- [1] J.-C. Chen and L.-H. Lu, "Design of wide-tuning-range millimeter-wave CMOS VCO with a standing-wave architecture," *IEEE J. Solid-State Circuits*, vol. 42, no. 9, pp. 1942–1952, Sep. 2007, doi: 10.1109/JSSC.2007.903050.
- [2] X. Liu, Z. Huang, J. Yin, and H. C. Luong, "Magnetic-tuning millimeter-wave CMOS oscillators," in *Proc. IEEE Custom Integr. Circuits Conf.*, May 2019, pp. 1–8, doi: 10.1109/CICC.2019.8780120.
- [3] P. Andreani and H. Sjolund, "Tail current noise suppression in RF CMOS VCOs," *IEEE J. Solid-State Circuits*, vol. 37, no. 3, pp. 342–348, Mar. 2002, doi: 10.1109/4.987086.
- [4] A. Mazzanti and P. Andreani, "Class-C harmonic CMOS VCOs, with a general result on phase noise," *IEEE J. Solid-State Circuits*, vol. 43, no. 12, pp. 2716–2729, Dec. 2008, doi: 10.1109/JSSC.2008.2004867.
- [5] P. Andreani, X. Wang, L. Vandl, and A. Fard, "A study of phase noise in Colpitts and LC-tank CMOS oscillators," *IEEE J. Solid-State Circuits*, vol. 40, no. 5, pp. 1107–1118, May 2005, doi: 10.1109/JSSC.2005.845991.
- [6] B. Razavi, *RF Microelectronics*, 2nd ed. Englewood Cliffs, NJ, USA: Prentice-Hall, 2012.
- [7] B. Razavi, "The design of an LDO regulator," *IEEE Solid-State Circuits Mag.*, vol. 14, no. 2, pp. 7–17, Spring 2002, doi: 10.1109/MSSC.2002.3167308.
- [8] S. Levantino, C. Samori, A. Zanchi, and A. Lacaita, "AM-to-PM conversion in varactor-tuned oscillators," *IEEE Trans. Circuits Syst. II. Analog Digit. Signal Process.* (1993–2003), vol. 49, no. 7, pp. 509–513, Jul. 2002, doi: 10.1109/TCSII.2002.804051.

SSC

# Are You Moving?

Update your contact information  
so you don't miss an issue of this magazine!

Change your address

**E-MAIL:** [address-change@ieee.org](mailto:address-change@ieee.org)

**PHONE:** +1 800 678 4333 in the United States

or +1 732 981 0060 outside the United States

If you require additional assistance regarding your IEEE mailings,  
visit the IEEE Support Center at [supportcenter.ieee.org](http://supportcenter.ieee.org).



IMAGE LICENSED BY INGRAM PUBLISHING

